

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001154**Date Inspected:** 30-Dec-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2330**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wang Saifa**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Mock Ups, OBG components**Summary of Items Observed:**

The Caltrans Quality Assurance (QA) inspector, Scott Croff, was present at Zhenhua Port Machinery Company, Ltd (ZPMC) to observe the scheduled mock up construction and production construction of the SAS Superstructure.

Bay 2: The QA inspector observed ultrasonic testing (UT) being conducted by ZPMC technician Li Li Ming on the lower 114 meter mock up assembly. The QA inspector noted that the weld was being tested with at 45° angle beam (shear wave). The UT was being conducted prior to the QA inspector's arrival. The QA inspector observed that repairs in the weld appear to be the only areas being tested at this time. The QA inspector noted that testing was being conducted from face "A" and face "B" only. The QA inspector observed that no testing (straight beam or shear wave) has been conducted from face "C." The QA inspector noted the ZPMC technician marked the weld as acceptable.

The Quality Control Liaison (QCL) Shen Xiu Jun informed the QA inspector that magnetic particle testing (MT) was going to be conducted on root welds of the 89 meter mock up assembly. Upon the arrival to the work location, the QA inspector noted that ZPMC workers were still grinding the welds and preparing for the inspection. The QA inspector asked the QCL when the MT would be conducted. The QCL made several phone calls and then informed the QA inspector that he could not determine when the MT would be done.

Bay 3: The QA inspector observed ZPMC personnel operating the gantry mounted flux cored arc welding (FCAW) to make fillet welds on BP005-01. The QA inspector observed 3 welders, each operating 2 machines. The QA inspector was informed that the welders were Li Zhou Qian, Xin Meng and Li Shu Liang. The QA inspector observed that joints being welded were 028, 029, 032, 033, 036 and 037. During the welding, the QA

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inspector made random observations of the tack welds that were going to be welded. The QA inspector noted that the tack welds appeared to be conforming to the contract requirements. The QA inspector noted that the approved CWI Wang Saifa is near by the work but was not observed directly monitoring any of the welding at this location.



Summary of Conversations:

As noted above, the QA inspector Scott Croff had a conversation with the QCL Shen Xiu Jun regarding the root MT on the 89 meter mock up assembly. The QA inspector was first informed that ZPMC's MT was completed and ready for QA verification. Upon the arrival of the QA inspector and the QCL to the work area, it was very apparent that no MT has been conducted yet. The QA inspector asked the QCL to find out when the parts would be ready for testing. The QA inspector was informed that the MT would be done and the approximate time couldn't be determined.

The QA inspector Scott Croff informed the QA inspector Bruce Berger of the above mentioned observations and conversations. The QA inspector also generated a summary report of these observations to be included in the daily shift notes. There were no other notable conversations during this shift.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Croff, Scott	Quality Assurance Inspector
Reviewed By:	Cuellar, Robert	QA Reviewer
