

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-001156**Date Inspected:** 26-Dec-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**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:** Xu Xian Ping, Wu Ming Kai**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.

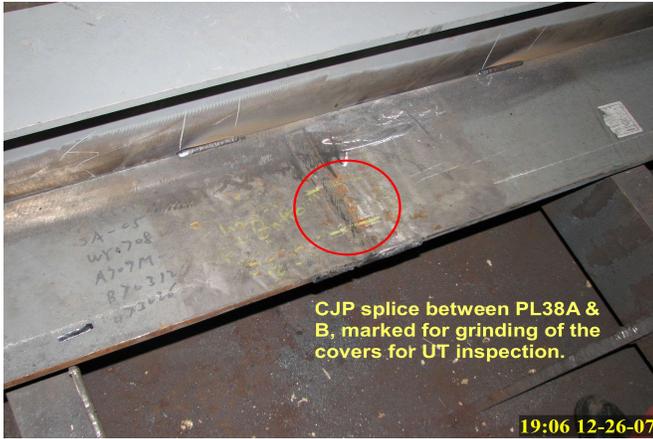
Bay 3: The QA inspector observed ZPMC workers in the process of fitting and tack welding T-stiffeners on side plate assemblies. The QA inspector noted that weld joints 025 and 027 on SP029-01 is being tack welded. The QA inspector observed Li Meng Qian and Wei Da Shui using welding procedure specification (WPS)-B-T-2132-2. The QA inspector noted that the welding parameters and preheat temperatures are being measured and recorded by Guo Yang Wei and Luan Zhao Gang. The QA inspector reviewed the list of approved CWI/CAWI Quality Control (QC) personnel and could not identify these persons. The QA inspector noted that the approved CWI Xu Xian Ping and the approved Lead CWI Wu Ming Kai are present at this work area.

The QA inspector observed a weld previously identified by the QA inspector Joe Lanz. The QA inspector noted that the weld covers were marked to be ground smooth as required by the contract special provisions, where there could be masking of an indication observed by ultrasonic testing. The QA inspector noted that the weld covers do not appear to be ground smooth at this time. See the attached photo.

The QA inspector observed ZPMC workers preparing to straighten a side plate assembly that appears to have warpage/distortion. The QA inspector was unable to accurately measure the dimensional warpage/distortion of SP075-01. The QA inspector was unable to locate any approved documents for the straightening of this part.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)



Summary of Conversations:

The QA inspector Scott Croff informed the QA inspector Joe Lanz that the CJP splice between PL38A & B area marked for grinding smooth does not appear to have been ground smooth yet.

The QA inspector Scott Croff informed the QA inspector Bruce Berger of the above mentioned observations. 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
