

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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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-001165**Date Inspected:** 07-Jan-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 230**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: Wu Ming Kai
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: Yes No N/A
Verified Joint Fit-up: 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 work in progress on the 77 meter, 89 meter, upper and lower 114 meter mock up assemblies. The QA inspector noted that 2 ZPMC workers are grinding a back gouged joint and preparing it for submerged arc welding (SAW) on the outside corner joint between skin plates D and E on the 77 meter assembly. The QA inspector noted that ZPMC workers are grinding welds smooth on the upper and lower 114 meter assemblies. The QA inspector observed Liu Xie using shielded metal arc welding (SMAW) on MUSB-MA38 G/J-59. The QA inspector noted that there is very limited access for this weld and no direct observations of the welding could be conducted. The QA inspector was informed that welding procedure specification (WPS)-B-T-4112-3 is being used at this location. The QA inspector noted that approved CWI Sha Zhi is monitoring the welding at this location.

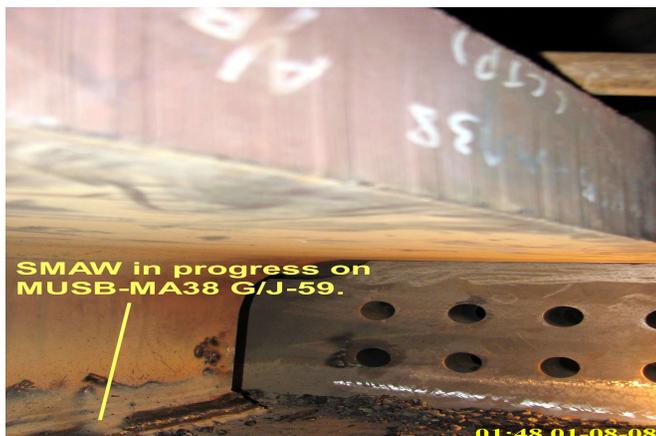
Bay 3: The QA inspector observed ZPMC personnel preparing to operate the gantry mounted flux cored arc welding (FCAW) to make fillet welds on SP011-01. The QA inspector noted that 4 welders will each be operating 2 machines. The QA inspector was informed that the welders will be Guo Yang Wei, Li Zhou Qian, Xin Meng and Li Shu Liang. The QA inspector observed that joints to be welded are 030, 031, 034, 035, 038, 039, 042 and 043.

The QA inspector made random observations of other work in progress in Bay 3. As reported on the TL-6031

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from 1-6-2008, the QA inspector noted that the "temporary CWI" is present in Bay 3. The QA inspector attempted to verify if there were any approved CWI/CAWI Quality Control (QC) persons in Bay 3. The QA inspector noted that approved CAWI Tao Lun Gang and approved CWI Wu Ming Kai are also in Bay 3. The QA inspector asked the approved CWI what work areas he was monitoring. The QA inspector was informed that the approved CWI was monitoring all of the work in Bay 3. The QA inspector noted that ZPMC crews appear to be fitting and tack welding stiffener plates onto various side and bottom plate assemblies. The QA inspector could only identify SP011-01, 2 other assemblies do not appear to have identifiable part numbers written on them.



Summary of Conversations:

The QA inspector Scott Croff showed the CWI / Quality Control Liaison (QCL) Fu Yu Hong the base metal gouges that were observed and reported on the TL-6031 from 1-6-2008. The QCL was asked if ZPMC had been informed of this observed item, as there was apparently a "temporary CWI" who was informed on 1-6-2008. The QCL replied that he would make sure that proper ZPMC personnel were aware of the situation.

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
