

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-001306**Date Inspected:** 24-Dec-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: Zhu Zhonghai
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:** 89 Meter Mockup**Summary of Items Observed:**

Caltrans Quality Assurance Inspector Gabriel Quintana (QA Inspector) arrived at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China to observe fabrication and Quality Control Inspectors (QC Inspectors) perform their duties and responsibilities as specified in the contract documents, approved plans, fabrications documents and Special Provisions for this project. While on site the QA Inspector observed the following:

Bay 7- Qualified welders Wang Jian #067081 and Dai Lu #048659 performed tack welding of piece mp957 to mp537 and mp538 on the 89 Meter Skin Plate Sub assembly drawing MUSB-MA22B/B. Weld Map identifies the locations as weld joint #13, #14, #15 and #16. QA Inspector observed that preheating and welding current was performed and monitored during tack welding per the Welding Procedure Specification (WPS) WPS-B-T-43(1)14.

QA Inspector observed welding parameters of 170 amps and 22 volts were used by Wang Jian and 183 amps and 23.7 volts were used by Dai Lu. Welding and welding parameters observed by QA Inspector appear to be in general compliance with the approved WPS.

Caltrans Check Samples - QA Inspector verified a list of material for Caltrans Check Test Samples for batch number six (6) and seven (7) were properly identified and prepared for shipping. QA Inspector observed ZPMC QC Inspector Sun Bo witness and perform an inventory check list as each sample was placed in a box in preparation for shipping the samples to the testing facility.

QA Inspector observed that Caltrans Check Sample Batch nine (9), Lot# L17-208-07 was not prepared for shipping. The following information is provided to identify the Check Sample for Batch nine (9):

Lot Number	Heat No	Grade	Thickness	Identification
L17-208-07	07108201	A709M-345F2-X	12mm	NG071129G049

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Items observed by QA Inspector described above appear to comply with project specifications. See the photographs below which show material described above. Date and time that appears in the photographs is Pacific Standard time zone.



Summary of Conversations:

General communications took place between the QA and QC Inspector. QA Inspector informed Quality Assurance Task Leader Jim Cochran that Caltrans Check Sample Batch nine (9), Lot# L17-208-07 is not included in this shipment of test samples.

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: Quintana, Gabriel

Quality Assurance Inspector

Reviewed By: Cochran, Jim

QA Reviewer