

**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-001318**Date Inspected:** 29-Jan-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	N/A	<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes No N/A	<b>Rod Oven in Use:</b>	Yes No N/A	
<b>Electrode to specification:</b>	Yes No N/A	<b>Weld Procedures Followed:</b>	Yes No N/A	
<b>Qualified Welders:</b>	Yes No N/A	<b>Verified Joint Fit-up:</b>	Yes No N/A	
<b>Approved Drawings:</b>	Yes No N/A	<b>Approved WPS:</b>	Yes No N/A	
		<b>Delayed / Cancelled:</b>	Yes No N/A	

**Bridge No:** 34-0006**Component:** Floor Beam**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Tim McClendon arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China to periodically monitor welding and Quality Control (QC) functions. While on site the QA Inspector observed and/or discovered the following.

While on site the QA Inspector verified snipe and hold back measurements on Floor Beam FB015-04. The findings are as follows:

Snipe measurements for stiffener plates X2 was 25mm x 25mm, X2F was 26mm x 26mm, and X2H was 26mm x 26mm. Drawings indicate snipe measurements should be 25mm x 25mm. It should be understood that an attempt is being made to measure snipe after welding has been completed 100% accuracy is difficult.

Hold back measurements for weld number 012 - 12mm, 011 - 15mm, 015 - 20mm, 016 - 10mm, 018 - 10mm, and 017 - 7mm. These dimensions correspond to the Y value on drawing on GN3 Detail WT1 which require a dimensions of 13mm ±6mm.

Hold back measurements for weld number 004 - 16mm and 16mm, 003 - 16mm and 12mm, 005 - 9mm and 10mm, 006 - 10mm and 13mm, 007 - 12mm and 20mm, 008 - 12mm and 13mm. These dimensions correspond to the X value on drawing GN3 detail WT1 which require a dimension of 6mm ±3mm. The first dimension recorded is located next to snipe and the second dimension recorded is located on the opposite end of snipe.

**Summary of Conversations:**

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# WELDING INSPECTION REPORT

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No conversations spoken.

## **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.

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<b>Inspected By:</b>	McClendon, Timothy	Quality Assurance Inspector
<b>Reviewed By:</b>	Cuellar, Robert	QA Reviewer

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