

**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-001353**Date Inspected:** 11-Jan-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2100**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	Hue Wei Qing & Wu Meng Kai	<b>CWI Present:</b>	<b>Yes</b>	<b>No</b>
<b>Inspected CWI report:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Approved WPS:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
		<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<b>Bridge No:</b>	34-0006	<b>Component:</b>	OBG & 114 Meter Mock-Up	

**Summary of Items Observed:**

This Quality Assurance Inspector was requested by Zhenhua Port Machinery Company Translator (Eric) Xu Jun to perform 10% ultrasonic verification testing on MUC-MA106 B/C 114 Meter Upper Shaft Assembly complete joint penetration corner joints. The two joints requested for testing were 90 millimeter thick number 2 and 3 between skin plates B & C and C & D however it was discovered that Zhenhua Port Machinery Company Quality Control department had only carried out testing from faces 'A' and 'B' and had skipped testing from face 'C' as required by item 12 on page 333 of the Special Provisions. A meeting was held back in the Quality Assurance Office where phone calls were made to both Quality Assurance Lead Inspector, Alfredo Acunia and Senior Level III David Mc Clary. It was decided that the Quality Control Department needed to contact American Bridge/Flour to work out the ultrasonic technique needed to full fill the requirements of the special provisions.

This Quality Assurance Inspector witnessed the selection of the retest CVN site for the sixth batch plate WY070226Q072, heat number 07100566N. This site selected was the opposite corner of plate where the previous piece had been cut. This required the plate information be re-applied to the plate as the corner selected contained all the plate information. Lot number B72-001-80

This Quality Assurance Inspector was informed by Mr. Lai Tao, one of the Zhenhua Port Machinery Company Translators, who came to the quality assurance offices and stated that quality control had just completed ultrasonic testing of 8 beam flanges out of 24 side plates. Quality Assurance received no notice that the ultrasonic testing was going to be carried out today and was not given an opportunity to witness the testing. Mr. Lai Tao stated that he came to inform Quality Assurance but we were not in the office. When Mr. Lai Tao was asked why he did not phone quality assurance as he has our cellular phone numbers he shrugged and laughed and said he did not know

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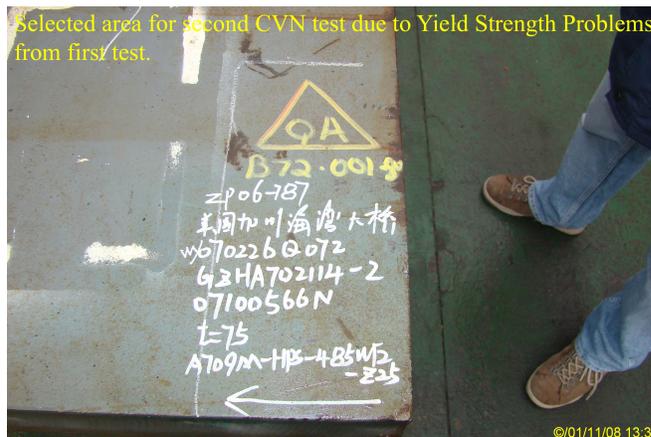
# WELDING INSPECTION REPORT

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why.



## Summary of Conversations:

As noted above.

## 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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**Inspected By:** Berger, Bruce

Quality Assurance Inspector

**Reviewed By:** Cochran, Jim

QA Reviewer