

**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-001556**Date Inspected:** 26-Oct-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**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	
<b>Bridge No:</b>	34-0006	<b>Component:</b>	Shapes/Plate	

**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Timothy 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.

QA Inspector Timothy McClendon went to the ZPMC blast/paint shop to observe shapes (W21 x 57) being blasted and/or painted however no work was being performed on W21 x 57 shapes.

QA Inspector Timothy McClendon accompanied by ZPMC QA Mr. Shen Xue Jun and ZPMC QC Miss Cary Wu Ming went to the ZPMC Numerical Cutting (NC) Shop to observe plate NG070508G221 being cut on CNC machine. QA Inspector Timothy McClendon observed testing of CNC machine on scrap plate before proceeding with actual cutting of plate NG070508G221. It was determined by ZPMC QA Shen Xue Jun and ZPMC QC Miss Cary Wu Ming and shop personal, the CNC cutting machine would produce 8mm kerf. Drawing number MUB-MA21 F/J used to cut plate into shapes indicates kerf would need to be 4mm. At this point cutting operation was stopped until CNC machine could be adjusted in order to meet the requirements of the drawing.

QA Inspector Timothy McClendon accompanied by ZPMC QA Mr. Shen Xue Jun went to observe previously blasted and primed shapes (W21 x 57) being marked to be split by fuel gas cutting process. QA Inspector Timothy McClendon and ZPMC QA Mr. Shen Xue Jun witnessed ZPMC QC Mr. Guo Xang Wei measuring the inside W21 x 57 and it was found to be 430mm. ZPMC QC Mr. Guo Xang Wei proceeded to mark the entire length of W21 x 57, 215mm, with a painted line. This measurement will split W21 x 57 shapes into two equal halves. QA Inspector Timothy McClendon also witnessed ZPMC QC Mr. Guo Xang Wei recording all material information

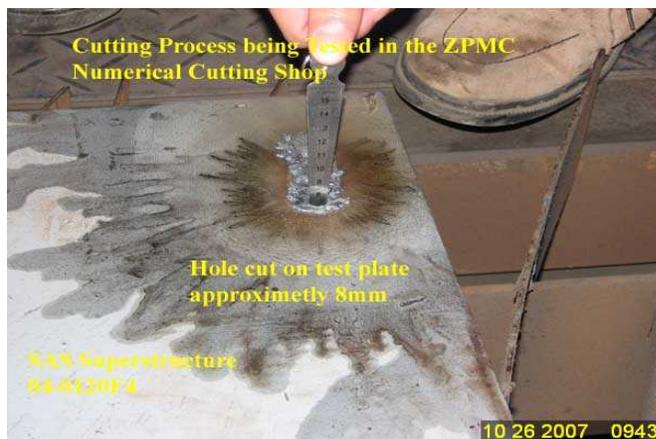
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on both halves of W21 x 57 in order to maintain traceability after the cutting operation is complete. Cutting operation may begin once approval has been given by ZPMC QA department. See attached pictures for additional information.



## Summary of Conversations:

No relevant conversations spoken on this day.

## 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:** McClendon, Timothy

Quality Assurance Inspector

**Reviewed By:** Cuellar, Robert

QA Reviewer