

**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-001576**Date Inspected:** 08-Mar-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** Huang Wen bang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Floor beams**Summary of Items Observed:**

This Quality Assurance (QA) inspector upon arrival at ZPMC for observation of the 89m mock up observed and witnessed ZPMC personnel performing Ultrasonic Testing (UT) on floor beams number FB025-02-146 which was relayed to this QA inspector had a rejectable indication found by ZPMC UT technicians Li Li Ming and Eshui Qin.

Three other locations were tested By ZPMC and found to not have any rejectable indications they are as follows; FB022-02-148, FB022-03-148 and FB021-02-146. This QA inspector performed QA verification on 10% of the above noted accepted weldments and found no rejectable indication in the length tested. As this QA inspector continued his observation in bay 7 it was observed that ZPMC welding personnel was performing a Complete Joint Penetration (CJP) weld on floor beam FB006-04-103 flange splice as this QA inspector inquired about welding parameters from ZPMC Quality Control personnel Shi Lei it was observed from ZPMC's tracking log for welding progress and parameters that this information had not been documented during the course of the CJP welding. The QC inspector then proceeded to write on the log with no reference material information pertaining to the weldment. At this point QC Shen Xue Jun was called to this location for translation and investigation into the issue. It was relayed to this QA inspector that ZPMC QC Shen Xue Jun would generate a incident report for this issue. This QA inspector also informed QC Shen Xue Jun that there will be an incident report generated by Caltrans METS for direct violation of section 8-3-01 of the special provisions which addresses tracking and daily reports for QC personnel. This information was also relayed to ZPMC QC/CWI Huang Wen bang who was overseeing the QC inspector noted above in bay 7. Digital photos below shows the QC log with no documentation and the weldment at the point where this QA inspector discovered the issue.

