

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-001813**Date Inspected:** 17-Mar-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 430**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhang Zhong**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:** OBG side panels**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Steve Hall was present During the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

New OBG Assembly area

QA observed Zhenhua Port Machinery Company (ZPMC) welding personnel Submerged Arc Welding (SAW) side panels SP62A to SP74A. QA observed ZPMC Quality Control (QC) inspectors randomly monitor the welding parameters. The parameters appeared to be in conformance with the posted WPS. ZPMC's QC inspectors were observed Visually Inspecting (VT) the above mentioned weld for compliance to the contract documents immediately after the completion of the weld. Visual inspection appeared to be in conformance with AWS D1.5 2002 and the contract documents.

After completion of the above mentioned weld, ZPMC welding personnel began moving the welding equipment to the next panel. QA departed the area before ZPMC welding personnel commenced welding on the next joint.

QA observed four ZPMC QC inspectors in the vicinity of the above mentioned welding operation at all times.

WELDING INSPECTION REPORT

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Summary of Conversations:

There were no significant conversations relative to this project today.

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:	Hall,Steven	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer
