

**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-002314**Date Inspected:** 12-May-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	NA	<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>	Caltrans Tower	

**Summary of Items Observed:**

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

**Production Monitoring Tests – Macro-Etches**

The QA Inspector was assigned, along with Caltrans QA Inspector, Paul Dawson, to examine macro-etch test specimens, prepared and evaluated by ZPMC Quality control (QC) personnel and reviewed by ABF.

One set (15) of Production Monitoring Tests (PMT's) was examined. The Macro-Etch samples for U ribs to deck panels were identified as DP-554-001 and DP-549-002. The PMT's were welded on 05-12-08. Both ZPMC QC and ABF QA had accepted the samples prior to Caltrans Inspectors' visual examination. All samples except 554-5-4 appeared to contain penetration greater than 80 percent. Sample 554-5-4 appeared to have less than 80 percent penetration, but more than 70 percent. According to the criteria, this is acceptable but recordable and was logged as such. The QA Inspector observed that sample 554-3-4 appeared to have an acceptable inclusion. All the data from the review was recorded in a tracking log and forwarded to Quality Assurance Task leaders and Structural Materials representatives. The samples were digitally photographed and placed on the internal server for future reference. Below is a photograph of sample 554-3-4.

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# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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## Summary of Conversations:

As identified within the contents of this report.

## 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>	Jobs, Kenneth	Quality Assurance Inspector
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<b>Reviewed By:</b>	Cochran, Jim	QA Reviewer
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