

**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-002505**Date Inspected:** 14-May-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1430**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2200**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wang Lu (Testino)**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 Deck Panels**Summary of Items Observed:**

On this date, Caltrans Office of Structural Materials (OSM) Quality Assurance (QA) Inspector Edward Leach was present to randomly observe and document the welding and Quality Control (QC) functions performed by ZPMC personnel relative to the fabrication of SAS Superstructure project. While on site, the QA Inspector noted the following work.

**OBG-Bay 1**

The QA Inspector began initial visual testing (VT) for deck panel, DP453-001 on weld joint 001. After marking the defective areas of the weld length, the QA Inspector recorded the Y locations, length and defect type onto a Caltrans VT report. At approximately 1830hrs, ZPMC re-located this deck panel from the gantry table to the shop floor towards the front of the bay and stacked two additional panels on top while the visual inspection was still in process. When the QA Inspector returned from lunch break, it was noted that weld joint 002 through 009 were now inaccessible. The QA Inspector informed ZPMC QC personnel Wang Lu (Testino) about the priority of the VT for this deck panel and stated that the two panels stacked on top need to be removed to continue inspection. Mr. Wang Lu informed the QA Inspector that he would ask the ZPMC shop personnel to remove those panels. At approximately 1940hrs, Mr. Wang Lu informed the QA Inspector that the ZPMC shop personnel would relocate those panels between 2020hrs and 2030hrs. As of 2130hrs the QA Inspector noted that ZPMC failed to remove the additional deck panels off the stack. The QA Inspector could not resume VT for the remainder of swing shift. This information was relayed to swing shift QA Task Leader Albert Carreon.

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# WELDING INSPECTION REPORT

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## Summary of Conversations:

As noted above in 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>	Leach,Ed	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer

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