

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-000795**Date Inspected:** 08-Nov-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**CWI Name:** n/a**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:** Plate Material MTR's/CVN**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Sherri Brannon 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. While on site the QA Inspector observed and/or discovered the following.

Material Test Reports (MTR's)

Quality Assurance (QA) Inspector Brannon reviewed Material Test Reports (MTR's) for material received in the ZPMC yard for Batch #31. QA Inspector Brannon checked MTR's for material designation, heat numbers, weights, carbon equivalent, sulfur content, fine grain particles, through-thickness, ultrasonic testing and reduction of area. Material test reports appear to comply with contract documents.

Quality Assurance (QA) Inspector, Sherri Brannon also, worked on updating tracking logs for tracking various QA, Office of Structural Materials (OSM) functions.

Charpy Vee Notch Testing (CVN)

QA Inspector Brannon arrived at ZPMC's on-site testing laboratory to randomly observed impact testing of Charpy Vee Notch Test (CVN) specimens for plate material. Also, observing (CVN) ZPMC Quality Control Mr. Tao Lin and American Bridge /Fluor (ABF) representative Mr. Jeff Evans. QA Inspector Brannon performed visual inspection on CVN samples using a optical comparator and found that the depth and angle of test specimens had not been machined properly per the AWS D1.5. 2002, Figure 5.13-CVN Test Specimen. ZPMC laboratory personnel and ABF Mr. Jeff Evans agreed with QA Inspector Brannon findings. ZPMC Quality Control Mr. Tao Lin stated to QA Inspector Brannon and ABF Mr. Jeff Evans that testing is canceled and that ZPMC will machine

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new samples for Charpy Vee Notch testing.

Summary of Conversations:

No relevant conversations on this date.

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:	Brannon, Sherri	Quality Assurance Inspector
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Reviewed By:	Cuellar, Robert	QA Reviewer
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