

**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-003479**Date Inspected:** 24-Jul-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2200**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	Chen Xi, Sun Bo, and Sun Wei Fen			<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>	closed rib to deck plate welds		

**Summary of Items Observed:**

Heavy Duty Machine Shop – Bay 3:

Caltrans Quality Assurance Inspector George Goulet (QA Inspector) performed final VT on DP005-001 (see photo below showing yellow tag containing inspection record attached to deck panel) and DP042-002. QA Inspector performed initial VT on DP135-001 and DP353-001.

QA Inspector observed grinding on the following deck panels: DP-326-002, DP-081-001, DP-042-002 (before final VT), DP-432-001, and DP-405-001.

Ten workers were present in this shop as well as ABF QC Kevin Chen, ZPMC QC Fu Yuhong, and ZPMC CWI's Chen Xi, Sun Bo, and Sun Wei Fen. 27 deck panels were in the bay. No welding was observed being performed.

**Summary of Conversations:**

At approximately 1715 hours ZPMC QC Fu Yuhong informed QA Inspector that a deck panel would be ready for final inspection by ZPMC, ABF, and QA Inspector at 1930 hours. When QA Inspector arrived ABF QC Kevin Chen and ZPMC Shop Foreman Niu were involved in a discussion in Chinese. At 1950 QA Inspector asked ABF QC Kevin Chen why ZPMC and ABF QC were not beginning their final inspection. ABF QC Kevin Chen informed QA Inspector that it would be at least another hour before ZPMC was ready to begin.

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# WELDING INSPECTION REPORT

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**SFOBB STATUS TAG**  
**IN-PROCESS**

SUBASSEMBLY DP005-001 Tag No. 000256

INSPECTIONS				REPAIRS			
	ZPMC	ABF	CT	ZPMC	ABF	CT	
FVT	<i>Sanjo</i>	<i>1/24/13</i>	<i>1/24/13</i>	<i>6-26-7/13/13</i>	CWR		
UT				HSR			
MT	<i>Wol</i>	<i>1/24/13</i>	<i>1/24/13</i>	NCR			
RT							
Dimen							

Notes: *Initial VT OF 3 Purities ART 7/23* *drawn ZPMC 7/23* *INITIAL 3 PARTY VT 13597/13/13*

07.24.08 1716

### 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 Ady Velasco, 138-1694-2685, who represents the Office of Structural Materials for your project.

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**Inspected By:** Goulet, George

Quality Assurance Inspector

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**Reviewed By:** Carreon, Albert

QA Reviewer