

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-000072**Date Inspected:** 09-Feb-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1330**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	NA	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:	NA	

Summary of Items Observed:

Caltrans Quality Assurance (QA) Inspector observed ZPMCs internal tower mock-up. ZPMC Quality Control (QC) Inspector, Mr. Zhu Qiu Dong accompanied the QA inspector during observation of the Mock-up. The QA Inspector observed that the fit-up and welding appeared to be complete on the tower mock-up. The QA Inspector observed that weld profiles on many of the welds were not in conformance with the project specifications requirements. The digital picture below illustrates tower mock-up.

Caltrans QA Inspector observed the ZPMC fabrication building where the rib panels are to be fabricated. Mr. Zhu Qiu Dong stated that the panels and rib plates would be cut at another shop and transferred to the building for further processing. This material at the fabrication building would then be milled to have smooth square edge at perimeter cuts, beveled as required and then form the ribs at the brake press workstation. The ribs would then be fit-up and tack welded to the floor plate and then moved to a fixture for cambering and welding as shown below. However, QA was informed later that day. That ZPMC decided to perform some of the fabrication, bending, at another site in Nantong City. The following pictures illustrate equipment that may be used in the fabrication of the rib panels.

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Summary of Conversations:

See the area Task Leaders daily journal for conversations.

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: Hasler, Mike

Quality Assurance Inspector

Reviewed By: Wright, Mark

QA Reviewer
