

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-000223**Date Inspected:** 07-Jun-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**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:	Radiographic Review	

Summary of Items Observed:

Caltrans Quality Assurance (QA) Inspector Robert Cuellar is present at the fabrication facility of Zhenhua Port Machinery Company (ZPMC), LTD for the purpose of monitoring activities relative to the subsequent fabrication of the SFOBB Self Anchored Suspension Bridge. The following items have been observed,

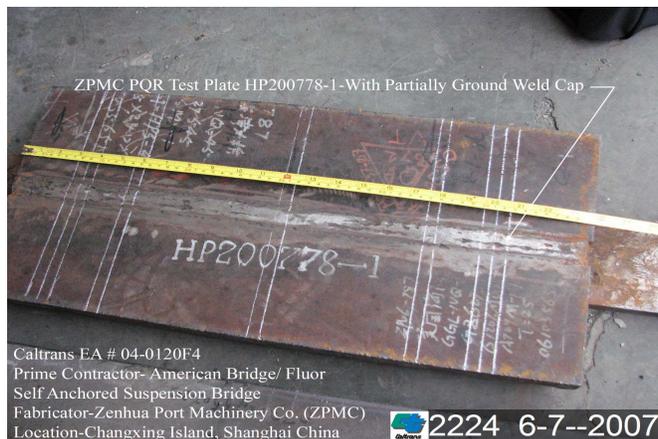
Item	Description	WBS	Dwg No.	Status
1	PQR Radiograph Review Radiograph Review	N/A	N/A	PQR RT Retest Required

1) PQR Test Plate HP200778-1- The Caltrans QA Inspector observed that the presented radiographs for this PQR test plate contain linear indications that are not in compliance with the requirements of AWS D1.5 (2002). It is inconclusive as to whether or not the PQR test plate weld cap with multiple weld passes represents the linear indications within the radiographs. The Caltrans QA Inspector and ZPMC representative Mr. Lu Jian Hua visually observed that the PQR test plate weld cap has been partially ground flush prior to radiographic testing. Mr. Lu Jian Hua stated that the weld cap needed to be completely ground and subsequently radiographically tested again. Radiographic film reviewers for ZPMC and ABF representative Mr. Nate Lindell did not address this issue prior to this review by the Caltrans QA Inspector. Included below is a digital picture of the PQR test plate which contains the partially ground weld cap and also a digital picture of a ZPMC welder grinding the weld cap of the PQR test plate.

Specific information relative to the radiographs for this PQR test have been recorded within a Caltrans TL-6032 for this date.

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2 Radiographs For Welder Qualification Tests N/A N/A N/A

2) Radiographs for Welder Qualification Tests-

Welder Identification 070409052- Radiograph complies with AWS D1.5 (2002).

Welder Identification 070409054- Radiograph complies with AWS D1.5 (2002).

Welder Identification 070409056- Radiograph complies with AWS D1.5 (2002).

Welder Identification 070409060- Radiograph complies with AWS D1.5 (2002).

Welder Identification 070409062- Radiograph complies with AWS D1.5 (2002).

Welder Identification 070409063- Radiograph complies with AWS D1.5 (2002).

Welder Identification 070409101- Radiograph complies with AWS D1.5 (2002).

Welder Identification 070409102- Radiograph complies with AWS D1.5 (2002).

Welder Identification 070409104- Radiograph non-compliant with AWS D1.5 (2002) due to a 25 mm long linear indication. Review by ZPMC, Moody and ABF representative Nate Lindell initially accepted this radiograph. ZPMC Representative Mr. Lu Jian Hua agreed that the radiograph for this welder is non-compliant.

Welder Identification 0704090103- Radiograph complies with AWS D1.5 (2002).

Welder Identification 070409110- Radiograph complies with AWS D1.5 (2002).

Welder Identification 070409113- Radiograph non-compliant with AWS D1.5 (2002) due to an 8 mm long linear indication. Review by ZPMC, Moody and ABF representative Nate Lindell initially accepted this radiograph. ZPMC Representative Mr. Lu Jian Hua agreed that the radiograph for this welder is non-compliant.

Welder Identification 070409119- Radiograph complies with AWS D1.5 (2002).

Welder Identification 070409121- Radiograph complies with AWS D1.5 (2002).

Welder Identification 070409122- Radiograph complies with AWS D1.5 (2002).

Welder Identification 070409125- Radiograph complies with AWS D1.5 (2002).

Welder Identification 070409126- Radiograph complies with AWS D1.5 (2002).

Welder Identification 070409128- Radiograph complies with AWS D1.5 (2002).

Welder Identification 070409129- Radiograph non-compliant with AWS D1.5 (2002) due to a 25 mm long linear indication. Review by ZPMC, Moody and ABF representative Nate Lindell initially accepted this radiograph. ZPMC Representative Mr. Lu Jian Hua agreed that the radiograph for this welder is non-compliant.

Welder Identification 070409001- Radiograph complies with AWS D1.5 (2002).

Welder Identification 070409002- Radiograph complies with AWS D1.5 (2002).

Welder Identification 070409005- Radiograph complies with AWS D1.5 (2002).

Welder Identification 070409007- Radiograph complies with AWS D1.5 (2002).

The radiographs for the welder qualification identifications listed have been previously reviewed by ZPMC, Moody

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and ABF representative Mr. Nate Lindell.

Summary of Conversations:

As identified within item 1 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.

Inspected By:	Cuellar,Robert	Quality Assurance Inspector
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Reviewed By:	McClary,David	QA Reviewer
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