

**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-000315**Date Inspected:** 25-Jul-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

<b>CWI Name:</b>	N/A	<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>	Material Receiving	

**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Bruce Berger was present to observe quality control functions related to welding, testing and fabrication procedures at the Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

This Caltrans Quality Assurance (QA) Inspector, Bruce Berger performed a review of the radiographic film for five welder qualification tests (WQT). The welds and film all appeared to meet the requirements of the code and special provisions.

This Caltrans Quality Assurance (QA) Inspector, Bruce Berger performed a review of the radiographic film for welding procedure qualification test HP2007247-2. The 26 millimeter thick groove weld and film both appeared to meet the requirements of the code and special provisions. For further detail see Welding Witness Report TL-6032 dated July 25, 2007. Caltrans lot number B72-070-07 was assigned to this report.

Caltrans Quality Assurance (QA) Inspector Bruce J. Berger completed the review of 55 material test reports for material received yesterday. The plates covered by the material testing reports were ASTM A709M-345T2, Z, Z25; A709M-HPS-485WT2, z & Z25 and A572M-gr345-Z25 materials and were accompanied with material test reports some of which had the letter Z or a Z25 after the material type on the MTR. The Assigned lot number for these plates is B72-069-07. A review of the material test reports was completed. There was no Fine grain Practice listed on any of the material test reports and the length of test samples for the elongation is not given on the reports.

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# WELDING INSPECTION REPORT

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**Summary of Conversations:**

No relevant conversations took place 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.

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<b>Inspected By:</b>	Berger, Bruce	Quality Assurance Inspector
<b>Reviewed By:</b>	McClary, David	QA Reviewer

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