

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-000317**Date Inspected:** 23-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**CWI Name:** Huong Wei**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:** WQT & MTR's**Summary of Items Observed:**

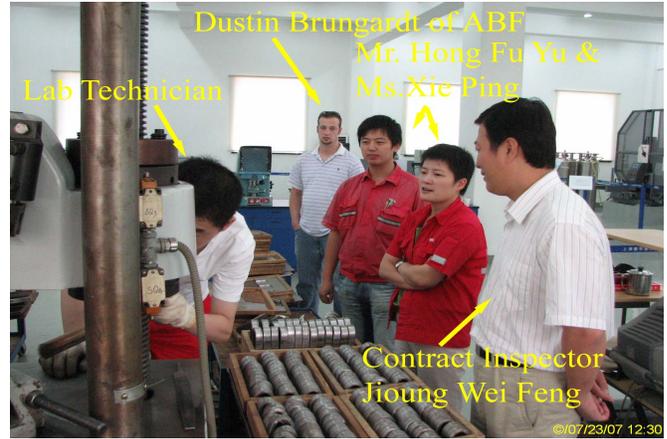
Caltrans Quality Assurance (QA) Inspector, Bruce Berger was present to observe quality control functions related to welding, testing and fabrication procedures at the Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

Caltrans Quality Assurance (QA) Inspector Bruce J. Berger witnessed the side bend testing of 96 various welder qualification tests in lieu of radiography. The test included two bend test specimen for each welder qualification test of which there were 16 submerged arc welding tests (SAW); 51 flux cored arc welding tests (FCAW) and 29 shield metal arc welding tests (SMAW). One SAW welder qualification test failed and was marked so by the ZPMC Mechanical Testing Lab. Those witnessing the testing today included American Bridge/Fluor Inspectors Mr. Dustin Brungardt and Jioung Wie Feng. Also witnessing the test were ZPMC personnel Fu Yu Hong and Xie Ping.

Caltrans Quality Assurance (QA) Inspector Bruce J. Berger started a review of 55 material test reports for material scheduled to be received tomorrow. 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 approximately 10 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. Review of material test reports will continue tomorrow.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)



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.

Inspected By: Berger, Bruce

Quality Assurance Inspector

Reviewed By: McClary, David

QA Reviewer