

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-000351**Date Inspected:** 11-Aug-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Mr. Xu Le Feng & Mr. Ye Yong			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:** 77 Meter Mock Up**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. Also present are Caltrans representatives Mr. Dave McClary, Mr. Alfredo Acuna, and Mr. Charles Franco. The following was observed,

77 Meter Mock-Up Diaphragm Type 3B

- 1) The Caltrans QA Inspectors, Mr. Dave McClary, Mr. Alfredo and the Caltrans QA Inspector arrived at the tower fabrication area at approximately 0930-1000. The Caltrans QA Inspectors were accompanied by ABF representatives Mr. Craig Knops and Mr. Warren Buehler. Also present are ZPMC representatives Mr. Xu Jun (Eric) and Mr. Shen Xue Jun. There were also numerous ZPMC representatives present.
- 2) The Caltrans QA Inspector observed that ZPMC has a table set up in front of the skin plate welding area. This table contained large sized fabrication drawings. The Caltrans QA Inspector observed that the large sized drawings include either an approved as noted or an approved Caltrans stamp on such drawings. The Caltrans QA Inspector also observed individual piece drawings with a legend similar to a bill of material. The Caltrans QA Inspector also observed two welding procedure specifications (WPSs) that are posted on a large board in front of the skin plate fabrication area. These WPSs include WPS-B-P-2211-B-U3b and WPS-B-T-2221-B-U3c-S.
- 3) The Caltrans QA Inspector observed that ABF representative Mr. Craig Knops and Mr. Warren Buehler have a significant audience and appeared to be providing direction or guidance to such group.
- 4) The Caltrans QA Inspector observed that there is no evidence of preheating thermal devices that would indicate that ZPMC is intending on tack welding any skin plates. It was the understanding of on-site Caltrans

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representatives that the purpose of Caltrans presence was to observe tack welding of the skin plates for the 77 meter mock-up. Based on what was being observed by the Caltrans QA Inspector it was evident that ZPMC was not prepared to start tack welding the skin plates that are positioned on elevated supports.

5) The Caltrans QA Inspector observed that there is a ZPMC shielded metal arc welder starting to weld the hold down devices to the temporary supporting devices for skin plate identified as skin plate E with piece numbers MA1-1 to MP15. These plates are of a 75 mm and 100 mm thickness and are scheduled to be joined with a double vee complete joint penetration groove weld. The Caltrans QA Inspector identified that the shielded metal arc welding of the temporary hold down devices recorded as step five (5) within the fabrication procedure section V-V of sheet FP-MUA-05 is being performed out of sequence since step 4 was not performed.

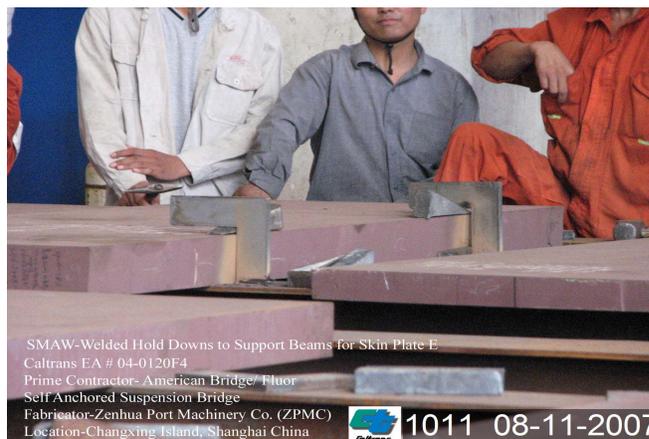
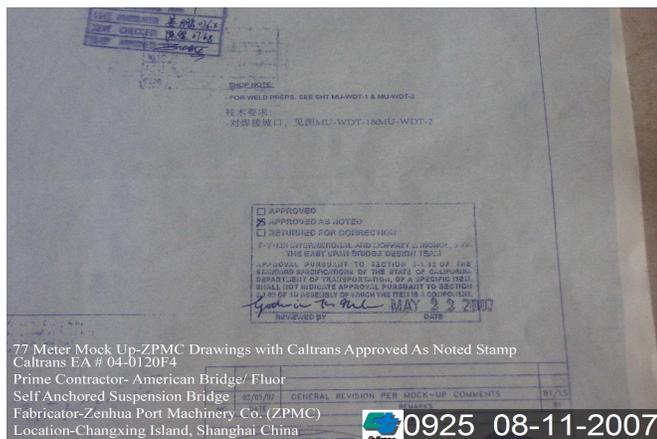
6) The ZPMC representatives informed the Caltrans QA Inspectors that ZPMC would not be tack welding the complete joint penetration splices for skin plates until sometime after lunch. The skin plates scheduled for tack welding included Skin Plate E, piece numbers MA1-1 to MP15 and Skin Plate D, piece numbers MA5 to MP14.

7) The Caltrans QA Inspectors and the ABF representatives departed the skin plate fabrication area at approximately 1045.

Included below are digital pictures that support the observations addressed within this report. Additional digital pictures are being maintained on-site by Caltrans OSM.

Summary of Conversations:

At approximately 1500, ABF representative Mr. Warren Buehler informed the Caltrans QA on-site staff that ZPMC would not be tack welding any of the splice joints for the skin plates on this date. The Caltrans QA Inspector questioned Mr. Warren Buehler as to why ZPMC could not proceed with the tack welding of the skin plates identified above. Mr. Warren Buehler voiced that ZPMC was delayed due to ZPMC not wanting to proceed until they had the correct 77 meter fabrication procedure. Warren Buehler voiced that ZPMC would continue with the 77 meter mock-up on Sunday 08-12-2007 at 0930.



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ABF -Craig Knops & Warren Buehler Discussion With ZPMC QA & QC Representatives
Caltrans EA # 04-0120F4
Prime Contractor- American Bridge/ Fluor
Self Anchored Suspension Bridge
Fabricator-Zenhua Port Machinery Co. (ZPMC)
Location-Changxing Island, Shanghai China
 0939 08-11-2007



77 Meter Mock-Up-Initial Start of Fabrication Due
Caltrans EA # 04-0120F4
Prime Contractor- American Bridge/ Fluor
Self Anchored Suspension Bridge
Fabricator-Zenhua Port Machinery Co. (ZPMC)
Location-Changxing Island, Shanghai China
 0937 08-11-2007

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

Reviewed By: McClary,David

QA Reviewer