

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-000615**Date Inspected:** 10-Oct-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**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:	Plate Material	

Summary of Items Observed:

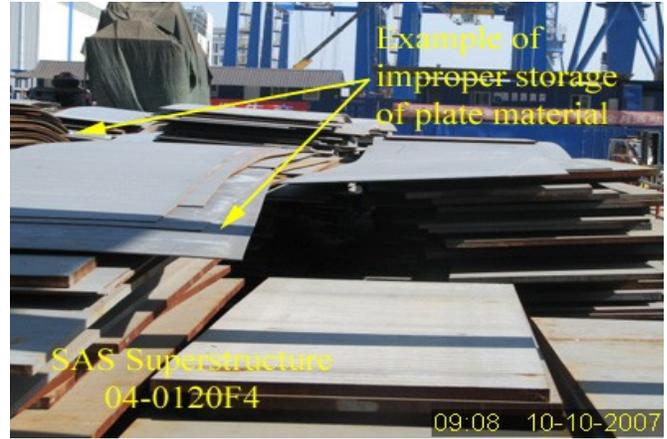
Caltrans Quality Assurance (QA) Inspector Sherri Brannon arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China to periodically monitor welding and Quality Control (QC) functions. While on site the QA Inspector observed and/or discovered the following.

Plate Material Storage Yard:

Quality Assurance (QA) Inspector Brannon received plate material list for batch #21, production plate list No. 1672, 1694~1811 received from American Bridge/Fluor (ABF). QA Inspector Brannon went to the ZPMC material storage yard accompanied by ZPMC Quality Assurance Mr. Shen Xue Jun. QA Inspector Brannon observed a total of 50 out of 119 plates for batch #21. The plates were observed for their general condition and markings. Plate material thicknesses range from 12mm to 20mm. The plates were designated as A709M-345T2, A709M-345T2-X, A709M-345F2-X and A709M-345T2-X-S. Plate material list for batch #21 was accompanied with material test reports (MTR's). The MTR's could not be reviewed on this date and will be reviewed at the earliest opportunity. QA Inspector Brannon assigned lot number B22-045-07 to the 50 plates observed on this date.

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Summary of Conversations:

QA Inspector Brannon questioned ZPMC Quality Assurance Mr. Shen Xue Jun with concerns on how ZPMC is storing plate material in the plate material storage yard. QA Inspector observed long plate's hanging over the shorter plates. Mr. Shen Xue Jun stated that ZPMC receives a number of plates in a batch and in that batch of plates there are various sizes and lengths, when ZPMC receives a batch of plate material we store that batch in one stack. QA Inspector Brannon suggests that dunnage should be placed under the longer plates for better support, Mr. Shen Xue Jun agreed and spoke to the ZPMC personnel stacking and moving plates.

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:	Brannon, Sherri	Quality Assurance Inspector
Reviewed By:	Cuellar, Robert	QA Reviewer
