

**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-000652**Date Inspected:** 22-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

<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>	Shapes	

**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Timothy McClendon 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 Shape Material Blast/Paint shop:

QA Inspector Timothy McClendon went to the ZPMC blast/paint yard accompanied by ZPMC QC Miss Cary Wu Min. QA Inspector Timothy McClendon observed shapes (W21\*57) being unloaded in blast/paint shop and loaded on rollers in order to be blasted. QA Inspector Timothy McClendon observed heat numbers stamped on top and bottom web for identification purposes. Shapes proceeded through two shot blasting stations in a slow and steady pace, after which dust was removed with air and loaded onto racks in order to paint. Shapes were thoroughly inspected by QA Inspector Timothy McClendon, ZPMC QC Miss Cary Wu, and ZPMC blast/paint personal. It appeared to QA Inspector Timothy McClendon all loose scale and other foreign material was removed; however shapes were not taken to white blast. After blasting process shapes received a light coat of ZPMC shop primer. No blast profile or mil thickness readings were taken. It is understood by QA Inspector Timothy McClendon, shapes are receiving a preliminary zinc coating, only designed to protect shapes during the manufacturing process. Shapes will receive additional blasting and painting at a later date.

# WELDING INSPECTION REPORT

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## Summary of Conversations:

As stated in body of 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:** McClendon, Timothy

Quality Assurance Inspector

**Reviewed By:** Cuellar, Robert

QA Reviewer