

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-000701**Date Inspected:** 19-Oct-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**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:	Closed Rib Trial Assembly	

Summary of Items Observed:

OBG-CLOSED RIB TRIALS

The Caltrans Quality Assurance (QA) Inspector Roscoe Dixon was present at the time requested by ZPMC QA Representative Eric Hu, to randomly verify transverse and longitudinal flatness of the Closed Rib Trial Assembly after the welding of the closed ribs onto the bottom plate of the Closed Rib Trial Assembly. The QA Inspector assisted QA Inspector Charlie Franco to record flatness measurements observed during the inspection. ZPMC QA Representative Fu Yuhong informed the QA Inspector, that ZPMC had previously performed their verification of the transverse and longitudinal measurements. The QA Inspector utilized a 1-meter and a 2-meter straight edge to perform the flatness verification. The QA Inspector randomly observed that the underside of the bottom plate of the Closed Rib Trial Assembly had been divided into sections A through J longitudinally and sections 1, 2 and 3 transversely. The QA Inspector randomly verified 30 readings in the transverse direction and 30 readings in the longitudinal direction. The readings were recorded and forwarded to the Lead QA Inspector. The QA Inspector randomly observed that there were 2 transverse readings and 2 longitudinal readings that were in excess of the maximum allowed per the contract requirements. These readings were highlighted on the verification sheet that was forwarded to the Lead QA Inspector. See QA Inspector Charlie Franco's report for this date for photographs to provide additional detail.

Summary of Conversations:

As noted above and basic communication between QC Inspector and QA inspector when and where welding inspections are to be performed.

Comments

WELDING INSPECTION REPORT

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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:	Dixon,Roscoe	Quality Assurance Inspector
Reviewed By:	Cochran,Jim	QA Reviewer
