

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-000737**Date Inspected:** 01-Nov-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**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:	Xu Xian Ping	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:	Caltrans Mock-Up	

Summary of Items Observed:

Caltrans Quality Assurance (QA) Inspector, Ken Jobes was present along with Caltrans QA Inspector, Mike Hasler to randomly verify dimensional accuracy on Bottom Plate Mark PL38A (Drawing Sheet No. PL38), Sub-Assembly Mark BP7A, Piece Mark RS9C (2 pieces) and RS9D (4 pieces), at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island. The QA Inspector observed that the overall length of each piece is within 2 mm of the drawing dimension. ZPMC personnel were grinding, cleaning and inspecting these parts. The holes have not yet been drilled. American Welding Society Certified Welding Inspector, Xu Xian Ping, representing ZPMC, was present during these observations.

Caltrans QA Inspector Ken Jobes along with Caltrans Inspector Tim McClendon verified the receiving of two plates –Batch No. 24, No. 1948 (I. D. #070516Q096, ASTM A709M Grade 345-T2-X-S, Heat No. 7301181N); and Batch No. 29, No. 2208 (I. D. #WY070816Q166, ASTM A709M Grade 345-F2-X, Heat No. 7302677N0). The QA Inspectors observed that the original manufacturer's identification markings had been transferred to the plate material. Lot No. B93-009-07 was assigned to the Batch 24 plate and Lot No. B93-010-07 was assigned to the Batch 29 plate. ZPMC QC representative, Sun Bo, was present during these verifications.

Summary of Conversations:

As identified within the contents of this 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.

WELDING INSPECTION REPORT

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Inspected By: Jobses, Kenneth

Quality Assurance Inspector

Reviewed By: Cochran, Jim

QA Reviewer