

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-004471**Date Inspected:** 21-Oct-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2200**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Wu Ming Kai		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No	
Rod Oven in Use:	Yes	No	N/A
Weld Procedures Followed:	Yes	No	N/A
Verified Joint Fit-up:	Yes	No	N/A
Approved WPS:	Yes	No	N/A
Delayed / Cancelled:	Yes	No	N/A

Bridge No: 34-0006**Component:** bottom panel, side panel, shear link**Summary of Items Observed:**

Sub-assembly – Bay 4

Caltrans Quality Assurance Inspector George Goulet (QA Inspector) randomly performed VT and final MT verification, 10% of the total linear distance of the 10% final MT performed by ZPMC on BP066-001-007 through 018 and SP441-001-001 through 010.

No apparent indications were observed.

QA Inspector randomly observed a ZPMC welder perform vertical SMAW on stiffener to web tacks and horizontal SMAW on bottom flange to web fill passes on a shear link. QA Inspector was assured by ZPMC CWI Wu Ming Kai (CWI) that the preheat temperature of 180 C. was being monitored by CWI. QA Inspector passed this information on to QA Lead Inspector Ken Riley and Structural material Representative Josh Ishibashi.

Approximately 45 ZPMC workers were present in this bay appearing to work on this contract as well as many ABF representatives including ABF QC's Li Shi You and Peng Wen Jun.

Summary of Conversations:

As noted in Summary.

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 Joshua Ishibashi, 136-6471-0411, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

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Inspected By:	Goulet, George	Quality Assurance Inspector
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Reviewed By:	Carreon, Albert	QA Reviewer
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