

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-002232**Date Inspected:** 10-May-2008**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:** Chen Xi**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:** OBG deck, side and bottom panels**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Steve Hall was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

OBG new assembly bay

QA observed ZPMC perform Magnetic particle Testing (MT) on side panel SP56A-SP68A joint# SEG-020A-021. MT appeared to be in conformance with the contract documents.

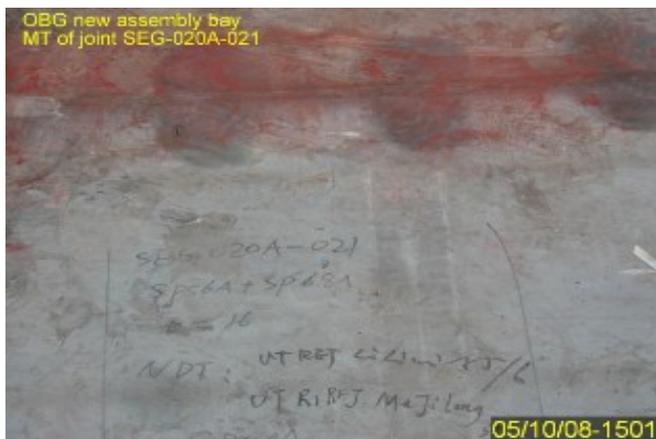
QA also observed ZPMC flame straighten bottom panel BP23A-BP24A near joint# SEG-020A-003 without QC being present to monitor the process. QA observed the process from 1500 hrs to 1525 hrs at which time it appeared that the personnel performing the process was finished. According to ZPMC's WQCP section 11 paragraph 11.1.4 "QC inspectors shall monitor the heat straightening process using the heat straightening report to document the results". QA informed ABF representative identified as Mr. Steve Lawton and ZPMC QC identified as Mr. Shen Xuejun that an incident report would be forthcoming concerning this discrepancy. Later in the evening, ZPMC QC identified as Mr. Shen Xuejun informed QA that ZPMC QC inspector had filled out a heat straightening report which indicated that QC did monitor the process at a later time (1520 hrs to 1550 hrs). QA reiterated that an incident report would be written concerning the fact that from 1500 hrs to 1525 hrs no QC was present to monitor the process.

Production Monitoring Tests Macroetches

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QA Inspector performed a visual inspection of one set of production monitoring tests (PMT) macro etch samples, identified as DP-410-001/DP-248-001. This PMT was welded this morning. All samples appeared to contain penetration greater than 80 percent. All the data from the review was recorded in a tracking log and QA labeled the samples in preparation for photographing.



Summary of Conversations:

as noted above.

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 Patrick Lowry (858)-344-2712, who represents the Office of Structural Materials for your project.

Inspected By: Hall, Steven

Quality Assurance Inspector

Reviewed By: Cuellar, Robert

QA Reviewer