

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-002747**Date Inspected:** 20-May-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** C. M. Chen**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:** Floor Beams, Side Plates, Bottom Plates, Deck**Summary of Items Observed:**

The Quality Assurance (QA) Inspector, Mahlon Lindenmuth, arrived on site at the Zhenhua Port Machinery Company facility on Changxing island, China to periodically monitor welding and Quality Control functions. While on site the Quality Assurance Inspector observed and/or discovered the following:

QA Inspector, Lindenmuth, observed the work being performed in Bay 2 of the New OBG. ZPMC personnel were performing various functions related to the fabrication of the OBG Side Plates and Bottom Plates as well as the deck sections in the jig fixture. The fabrication performed includes but is not limited to the preparation of areas where temporary welds for strongbacks are located, bevel preparation and welding of the Complete Joint Penetration welds (CJP) on Side Plates and Bottom Plates, heat straightening of Side Plates and Bottom Plates.

Member identification and the work performed on the members are as follows:

South Jig Fixture

Segment 3BE/Panel Point (PP) 23: Caltrans QA Inspector, Lindenmuth, observed that weld joints numbered 131 and 135 have been tacked welded. The welds are Complete Joint Penetration welds that join the Floor Beam Segments FL2-2 North and South ends to FL1-1 North and FL1-1 South. The joint alignment had been misaligned by approximately 25mm on the South end but has been corrected to acceptable tolerances prior to tack welding. QA Lindenmuth did observe that the Floor Beam Segment FL2-1 upper flange is still laterally misaligned, by approximately 3mm, with Floor Beam segments FL1-1 North and FL1-1 South upper flanges. Plumbing and alignment of the 3BE segment has not been completed yet and the upper flanges have not been tacked.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Segment 4AE: Caltrans QA Inspector, Lindenmuth, observed that ZPMC personnel have positioned the Side Plate segments 4AE-C5 and 4AE-E7 in the jig fixture but have not welded the segments to the fixture. The segments still require alignment with the Bottom Plate segment 4AE-D6.

Shop Welding

Caltrans QA Inspector, Lindenmuth, observed the ongoing fabrication of various Side Plates and Bottom plates. No welding was performed by ZPMC personnel during the AM shift.

Storage of steel members(dunnage)

Caltrans QA Inspector, Lindenmuth, observed that Floor Beam assemblies are being improperly stacked by ZPMC personnel. The floor Beams are set on top of each other in stacks as high as five Floor Beams, with no dunnage between the members. Caltrans QA Inspector, Lindenmuth, informed ZPMC QC Cheh Chi Ming and ABF representative, Art Peterson of the issue and stated that an incident report will be written if the members are not properly stored

Summary of Conversations:

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.

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| Inspected By: | Lindenmuth, Mahlon | Quality Assurance Inspector |
| Reviewed By: | Cuellar, Robert | QA Reviewer |
