

**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-003299**Date Inspected:** 24-Jul-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**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:** 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:** OBG**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Tim McClendon arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China to periodically monitor welding and Quality Control (QC) functions. While on site the QA Inspector observed and/or discovered the following.

This Caltrans QA Inspector has been assigned to the ZPMC, ABF, Caltrans group tagging team performing the review of numerous QC and QA documents for the purpose of continuing with the on-going group tagging of the segments identified below.

**South Fabrication Bay OBG Assemblies**

OBG Assembly Segment 3AE- Caltrans QA observed ZPMC depositing SMAW filler metal on CJP welds, attaching T-Stiffeners near PP21 on Segment 14.

Fit up of Corner Assembly - for Segment 3AE is in progress in the center of Fabrication Bay 2.

OBG Assembly Segment 3BE- Caltrans QA observed this segment is idle on this date. There are no activities to report.

OBG Assembly Segment 4AE- Caltrans QA observed this segment is idle on this date. There are no activities to report.

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# WELDING INSPECTION REPORT

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OBG Assembly Segment 4BE- Caltrans QA observed ZPMC Fitting SSD16 Floor Beam located at PP26.

OBG Assembly Segment 5CE – Caltrans QA observed ZPMC Fitting Side Panel E7 to Bottom Panel D6.

North Fabrication Bay OBG Assemblies

OBG Assembly Segment 5AW- Caltrans QA observed this segment is idle on this date. There are no activities to report.

OBG Assembly Segment 5BW- Caltrans QA observed this segment is idle on this date. There are no activities to report.

OBG Assembly Segment 5CW- Caltrans QA observed ZPMC depositing filler metal utilizing SMAW process on Segment number 25 Weld number 007 joining D6 to E7 on the “B” side.

OBG Assembly Segment 4BW- Caltrans QA observed ZPMC Fitting Longitudinal Diaphragm located at PP26/27

OBG Assembly Segment 4AW- Caltrans QA observed ZPMC Depositing FCAW filler metal on various welds attaching Longitudinal Diaphragms to Floor Beam at Seg. 17B

OBG Assembly Segment 3BW- Caltrans QA observed this segment is idle on this date. There are no activities to report.

OBG Assembly Segment 3AW- Caltrans QA observed ZPMC depositing filler metal utilizing SMAW process in the 4G position, on CJP welds attaching D6 Floor Beam FL2-2 to E7 FL 3 Side Panel at PP 21 location “B” side of plate.

### Summary of Conversations:

No relevant conversations spoken on this date.

### 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 Ady, Velasco 13816942685, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	McClendon, Timothy	Quality Assurance Inspector
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<b>Reviewed By:</b>	Cuellar, Robert	QA Reviewer
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