

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-004003**Date Inspected:** 19-Aug-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:****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:**

On this date, Caltrans Office of Structure Materials (OSM) Quality Assurance Inspector (QA) Raymond Lara was present at jobsite in Zhenhua Port Machinery Company facility on Changxing Island, China for the purpose of observing and monitoring the fabrication of the OBG.

Bay Sub-Assembly

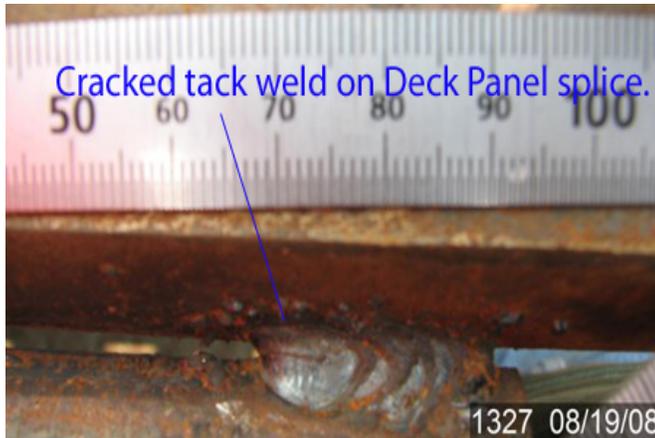
The Quality Assurance Inspector performed a walk thru of the Bay Sub-Assembly in an effort to location and track deck panels. The Quality Assurance Inspector observed various deck panels turned over and will be unable to be receive ultrasonically prescreened for cracked tack welds by the Quality Assurance. The Quality Assurance Inspector observed deck panels which were not on the list as priority are being welding to deck panels that are on the priority. See the Tack Weld Assessment dated August 19, 2008.

The Quality Assurance Inspector observed ZPMC deck panel staging area behind the Bay Sub-Assembly building.

The Quality Assurance Inspector verified complete joint penetration weld joint joining deck panel 603-001 to deck panel 602-001. The Quality Assurance Inspector observed several cracked tack welds and weld splatter in the bevel joint. The Quality Assurance Inspector informed the on site ZPMC Quality Control Inspector about the cracked tacks in the bevel joint. The ZPMC Quality Control Inspector informed the Quality Assurance Inspector the tack welds will be repaired prior to welding. The Quality Assurance Inspector observed several tack welds were repaired by grinding.

WELDING INSPECTION REPORT

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Summary of Conversations:

No relevant conversations 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 138-1694-2685, who represents the Office of Structural Materials for your project.

Inspected By: Lara, Raymond

Quality Assurance Inspector

Reviewed By: Lanz, Joe

QA Reviewer