

**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-003862**Date Inspected:** 10-Sep-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 Chih-Ming**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 side, edge and deck 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 2

QA was notified by ZPMC QC representative Mr. Testino Wang of 6 cracked tacks on 5 OBG deck panels (DP-049-001-184, DP-051-001-191, DP-050-001-021, DP-050-001-067, DP-074-001-099 and DP-075-001-141). These tacks join the outer diaphragms to the deck plate and u-ribs. ZPMC QC has allowed ZPMC personnel to commence repairing these cracked tacks without an approved repair procedure in the vicinity of the repairs. QC inspector identified as Mr. Geng Wei was unable to produce a procedure upon QA request. As of the end of this shift ZPMC has only removed the cracked tacks by grinding. No further activities concerning repairs of these tacks were observed on this shift. Note: these deck panels are currently in non compliance because ZPMC has commenced fitting and welding the diaphragms after the state issued a letter suspending further fabrication of these deck panels until issues with cracked tacks in the PJP welds joining u-ribs to deck plates have been resolved. ZPMC and ABF have been notified by QA of an impending incident report concerning these issues.

QA observed that ZPMC has cut into the end of 3 stiffeners during the beveling operation on side panel SP-040-01 at the ends of welds 011, 012, 017, 018, 019 and 020. ZPMC CWI identified as Mr. Chen Chih-Ming informed this QA inspector that ZPMC would determine if this was a CWR or not and would submit the proper paper work in order to commence repairing these areas as early as tomorrow (09/11/08).

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# WELDING INSPECTION REPORT

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OBG assy. bay 2

QA performed 10% MT for ABF/ZPMC/Caltrans green tagging on the following OBG panels: SP-040B, SP-55A, SP-043A, EP-18B and EP-19B.

No other observations were made in this bay tonight.



## Summary of Conversations:

As mentioned 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 Ryan Smith, (858) 232-6799, who represents the Office of Structural Materials for your project.

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

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