

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-004761**Date Inspected:** 14-Nov-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: Zhu Zhon Hai
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: Yes No N/A
Verified Joint Fit-up: 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:**

Tower Shop Bay 3 Deck Panel repairs

This Caltrans QA Inspector arrived at ZPMC at Changxing Island for the continued observation of the SAS structure fabrication. During this QA inspectors observations in tower shop bay 3 it was noted that ZPMC was performing deck panel repairs on 3 panels by grinding and welding. There are 20 deck panels currently inside this location with 10 ZPMC personnel and 4 QC personnel. This Caltrans QA Inspector performed final VT along with ZPMC and ABF on 2 deck panels listed as DP252-001 and DP225-001, these panels appeared to be within compliance of the repair procedure by ZPMC. All 3 parties signed the ABF yellow tracking tag affixed to each deck panel as completed per each inspection process. This QA Inspector noted that ZPMC had CWI Li Yan Hua within the shop at periodic intervals to monitor and perform VT inspection as required. ABF personnel observed with bay 3 for repairs and inspection were Kevin Chen and Wong Wei.

** Conversation with ABF personnel Kevin Chen had stated that ZPMC has moved to a new outside location for deck panel repairs which is west of the old repair area outside. It was stated at approximately 1930hrs that ZPMC was ready for Visual Inspection outside. Caltrans QA Inspector under the direction of the Task Leader informed ABF that CT would perform the inspection tomorrow morning in daylight hours. The inspection for tonight due to limited lighting in the area would create a safety factor for the inspectors, and that natural lighting during daylight hours would be the best avenue for the inspections due to the panels being outside. ABF personnel agreed to the time of inspection set forth as tomorrow 11-15-08.

89M mock up

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This QA inspector noted that at the 89M mock up ZPMC had performed the 72hr magnetic particle inspections for the MUB-MA21-G/J welds that included the diaphragm to fit-lug and stiffeners to fit-lug welds. It was noted that ZPMC had hand written on the diaphragm that "72hr MT of cover welds accepted 11-14-08" This QA Inspector spoke with ABF personnel about the weld continuing weld trials and it was relayed that ABF has submitted request for approval to use the 150mm fit-lug with 7018 electrode either ZPMC's E7018 H4R or ABF's E7018 C3L H4R (high nickel). They are waiting for approval to proceed with the remaining weld trials. All MT has been completed and accepted.

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 Josh Ishibashi, 1-376-471-0411, who represents the Office of Structural Materials for your project.

Inspected By:	Riley, Ken	Quality Assurance Inspector
Reviewed By:	Carreon, Albert	QA Reviewer
