

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-004964**Date Inspected:** 09-Dec-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:** Chen Chin 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**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 SAS Superstructure.

East OBG Assembly

OBG Assembly Building

East OBG Assembly

DP380-001 to DP353-001 Segment 026-018

The Quality Assurance Inspector observed ZPMC welder 048038, utilizing the flux cored arc welding process on a complete joint penetration in the flat position joining DP380-001 to DP353-001. The Quality Assurance Inspector observed ZPMC Quality Control Personnel record parameters and verify preheat temperatures. The welding parameters observed by the Quality Assurance Inspector appeared to be within welding procedure specification WPS-B-T-223(2) IT.

Segment 018B-010

The Quality Assurance Inspector observed ZPMC in process of installing fit up aids on grinding on various deck panels to diaphragm plates assemblies.

Segment 009A-004

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The Quality Assurance Inspector observed ZPMC personnel in process of performing heat straightening operations on the following bottom plate assemblies BP191A to BP185A.

Segment 009A-006

The Quality Assurance Inspector observed ZPMC personnel in process of performing heat straightening operations on the following side plate assemblies SP179 to SP178.

Outside Area West of the OBG Assembly Building

The Quality Assurance Inspector observed areas where the caulking was removed from the u-rib diaphragm plate to the deck panel on DP588-002 and DP583-001. The Quality Assurance Inspector observed water leaking from the areas where the caulking was removed from the u rib diaphragm plate. The deck panels are in non conformance with the State of California Department of Transportation Standard Specifications 1999 section 55 paragraph 55-1.04 Shipping, Handling and Storing of Materials. See Caltrans Incident Report dated December 9, 2008 for additional information.

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 Peter Dautermann 150 0219 9593, who represents the Office of Structural Materials for your project.

Inspected By:	Lara, Raymond	Quality Assurance Inspector
Reviewed By:	Wright, Mark	QA Reviewer
