

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-006832**Date Inspected:** 21-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Xi**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 crossbeams**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 cross beam CB7

This Quality Assurance Inspector (QA) observed that the contractor has performed flame straightening on side panel identified as CB201D without an approved procedure. The procedure presented to this QA indicated that the distortion was 5mm on 18mm plate. This is non compliant to the Contract Special Provisions 8-3.01 which specifies "for material more than 16mm, the contractor shall not heat straighten members more than 3 in 1000 without prior approval of the Engineer. Furthermore, the contractors personnel did not follow the available procedure on the shop floor identified as Heat Straightening Report number HSR1(B)-6427. The procedure did not indicate the use of blocks under each edge of the panel as shown in the photos below.

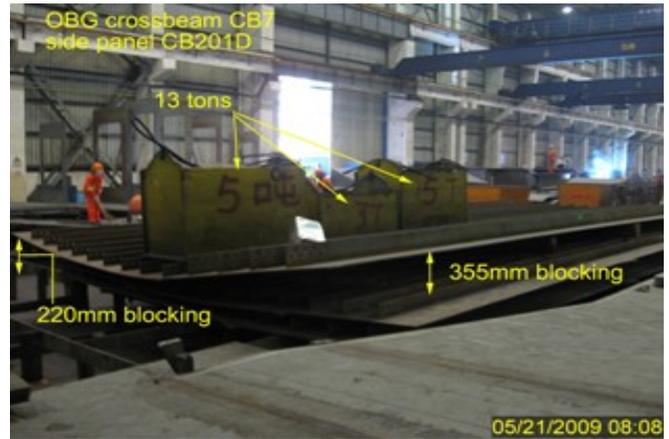
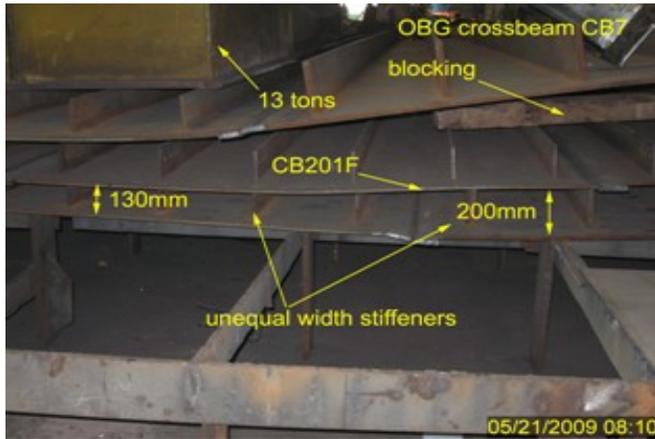
This Quality Assurance (QA) inspector observed that the contractor has bent one of the side panels for crossbeam CB7. This panel is identified as CB201F. The panel in question was underneath side panel identified as CB201D that was being straightened by the use of heat and counter weights. The total weight of the counterweights was 13 tons. This force bent this side panel over top of unequal width stiffeners on another side panel below it. See attached photos. This is non compliant to Caltrans 1999 standard specifications section 6-1.3 which specifies "Articles or materials to be incorporated in the work shall be stored in such a manner as to ensure the preservation of their quality and fitness for the work, and to facilitate inspection".

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This QA informed ZPMC QC identified as Mr. Shen Xuejun, ABF QA inspector identified as Mr. Shen Ru Shan and ABF representative identified as Mr. Mike Williams of the above mentioned non conformances and that separate incident reports would be submitted for each issue.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



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 Eric Tsang (15000422372), who represents the Office of Structural Materials for your project.

Inspected By:	Hall,Steven	Quality Assurance Inspector
Reviewed By:	Prue,Erik	QA Reviewer
