

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-011978**Date Inspected:** 20-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	NA.	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 day CALTRANS OSM Quality Assurance Inspector (QA) Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

Trial Assembly – 5AW.

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector has generated MT report for this date. The member(s) are identified as OBG components. The weld designations reviewed are as follows:

PP31-DP81-001- 062, 063, 065, 067, 068, 070, 072, 073, 075, 076, 078, 080, 081, 083, 084, 086.

PP31-DP108-001- 082, 084, 081, 086, 087, 089, 091, 092, 094, 095, 099, 100, 103, 105, 107, 108, 110, 111 & 113.

PP31-DP135-001- 100, 101, 103, 106, 108, 110, 113, 114, 116, 118, 119, 121, 122, 124, 126, 127, 129, 130, 132, 134, 135, 137, 138 & 140.

PP31-DP162-001- 100, 101, 103, 105, 106, 108, 110, 111, 113, 114, 116, 118, 119, 121, 122, 124, 126, 127, 129, 130, 132, 134, 135, 137, 138 & 140.

For Cross Beams:

WELDING INSPECTION REPORT

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Outside Yard:

- CB16.

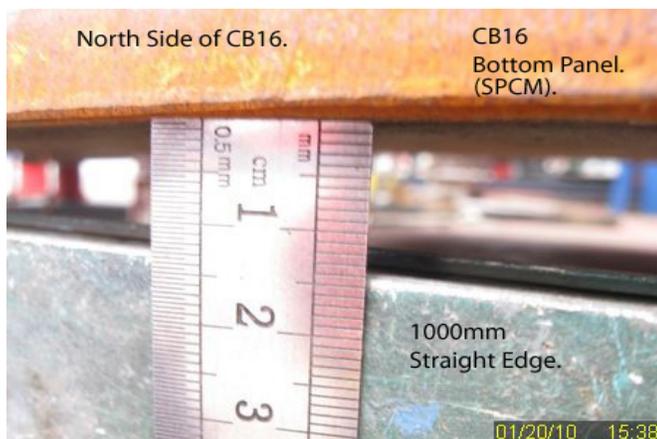
During visual inspection; the below mentioned activity was noted, which did not appear to comply with the applicable contract document.

ZPMC heat straightening the Bottom Panel distorted by welding without the Engineers approval. (As per Special Provisions, for material less than or equal to 16 mm thick, the Contractor shall not heat straighten members more than 6 in 1000 without prior approval of the Engineer). The deviation from flat as measured by this QA was 15mm per 1000mm. Material thickness is 12mm. This material is designated as Seismic Performance Critical Member (SPCM). Heat straightening was in process at North side of Bottom Panel.

This QA informed ZPMC Quality Control (QC) identified as Mr. Zhong Wei and American Bridge Fluor (ABF) QA identified as Mr. Cao Hai Zhau, of this issue and that an incident report would be generated.

Refer attached photograph for additional details.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

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; phone: 15000422372., who represents the Office of Structural Materials for your project.

Inspected By: Wadkar,Sailesh

Quality Assurance Inspector

Reviewed By: Hall,Steven

QA Reviewer