

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:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025747**Date Inspected:** 29-Jun-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** ShangHai, China**CWI Name:** Shi Yu**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:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance(QA) Inspector, DJ Shin was present during the times noted above for observations relative to the work being performed.

Bay 1

This QA Inspector observed the following work in progress for Bay 1.

ZPMC was performing grinding to smooth the edges of areas that had been cut by Oxygen/Acetylene cutting, weld spatters, smooth to final weld pass and removing the burr's caused by drilling on hand rails.

Bay 9

This QA Inspector observed the following work in progress for Bay 9.

ZPMC was performing grinding to smooth the edges of areas that had been cut by Oxygen/Acetylene cutting, weld spatters, smooth to final weld pass and removing the burr's caused by drilling on hand rails, traveler, and bike path.

Trial Assembly Yard

This QA inspector has issued incidental report for followings:

During Quality Assurance (QA) random in-process observations of the fabrication of OBG CB3002A-018, Weld ID number is CB3002A-018-035,-036, this Caltrans QA Inspector observed the following issues:

-ZPMC has changed a joint design without prior approval from the Engineer.

-According to approved shop drawing, the joint is designed for 6mm fillet.

WELDING INSPECTION REPORT

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- The joint has been changed to a Complete Joint Penetration (CJP).
- ZPMC has completed the repair welding without an approved critical weld repair (CWR) procedure.
- The length of welding was measured to be 350mm for the hold back location.
- The affected members are identified as CB3002A-018-035,036
- Due to ZPMC performing the weld repair the component is approximately 17mm misalignment.

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



Summary of Conversations:

No relevant conversations

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: Shin,DJ

Quality Assurance Inspector

Reviewed By: Riley,Ken

QA Reviewer
