

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-002850**Date Inspected:** 06-Jun-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** C. M. Shen**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:**

Caltrans Quality Assurance (QA) Inspector Tim McClendon arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China to periodically monitor welding and Quality Control (QC) functions. While on site the QA Inspector observed and/or discovered the following.

General On-Going Fabrication- The Caltrans QA Inspector's have observed that there are six (6) OBG assembly segments that are at various stages of fabrication. Four (4) segments are being assembled at the south end of the bay and are identified as segments 3AE, 3BE, 4AE, and 4BE. At the far north end of the bay are segments 3BW and 4AW are being assembled. The following specifics apply to each segment observed.

OBG Assembly Segment 3AE- The Caltrans QA Inspector observed that ZPMC is continuing with the fit-up and tack welding of the FL1 floor beam on the south side and also the FL2 to the bottom plate.

OBG Assembly Segment 3BE- The Caltrans QA Inspector observed that work on this assembly is idle.

OBG Assembly Segment 4AE- The Caltrans QA Inspector observed that work on this assembly is idle.

OBG Assembly Segment 4BE- The Caltrans QA Inspector observed that work on this assembly is idle.

OBG Assembly Segment 4AW- The Caltrans QA Inspector observed that ZPMC is in process of applying the FCAW root pass to the E7 side plate to bottom plate D6 CJP splice weld.

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OBG Assembly Segment 3BW- The Caltrans QA Inspector observed that ZPMC has completed the welding of the FL2 and FL1 Floor beam segments.



Summary of Conversations:

No relevant conversations spoken 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 Pat Lowry, (858) 344-2712, who represents the Office of Structural Materials for your project.

Inspected By:	McClendon, Timothy	Quality Assurance Inspector
Reviewed By:	Cuellar, Robert	QA Reviewer
