

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-003092**Date Inspected:** 25-Jun-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Chih-Ming / 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 side, bottom and deck panels**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 new assembly bay 2

QA attempted to perform 10% R1 repair verification Ultrasonic Testing (UT) on the following weld joints: SEG-020A-031 (QC rej), SEG-014A-031 (QC rej), SEG-018-007 (QC rej) and SEG-018A-008 (QC rej). ZPMC QC did not indicate whether or not the following R1 repairs were accepted or rejected: SEG-016B-012, 002, 028, 038, 039 and 001. QA attempted to communicate this discrepancy to ZPMC QC in the shop however; they were unable to answer QA's questions concerning the acceptance or rejection of the repaired areas due to the fact that the responsible ZPMC UT technicians shift had ended.

QA noted that there was no welding being performed in this bay at the time QA was present.

Other general observations include ZPMC personnel fitting and welding OBG temporary support columns, grinding and weld bevel prep on various OBG components.

OBG bay 1

QA attempted to perform 10% verification UT on U-rib diaphragms for DP-617-001 however, ZPMC had

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started fitting these U-ribs to the deck plate before QA had the opportunity to UT these welds. It was brought to this QA's attention that ZPMC had notified QA that they would be unable to wait for QA to perform verification UT prior to fitting the U-ribs to the deck plate.

Other general observations by QA were as follows:

QA observed ZPMC has approximately 30-40 workers performing various functions relative to the fabrication of the OBG Deck Panels. These functions include; closed rib press forming, hole drilling at ends of U-Ribs using a drill template, PJP bevel preparation, closed rib splice FCAW welding, closed rib diaphragm fit-up and FCAW welding, closed rib to deck plate fit-up and tack welding.

Summary of Conversations:

Only general conversations were 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 Patrick Lowry (858)-344-2712, who represents the Office of Structural Materials for your project.

Inspected By:	Hall,Steven	Quality Assurance Inspector
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Reviewed By:	Cuellar,Robert	QA Reviewer
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