

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-003208**Date Inspected:** 14-Jul-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. Chen**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.

This Caltrans QA Inspector has been assigned to the ZPMC, ABF, Caltrans group tagging team performing the review of numerous QC and QA documents for the purpose of continuing with the on-going group tagging of the segments identified below.

South Fabrication Bay OBG Assemblies

OBG Assembly Segment 3AE- Caltrans QA observed this segment is idle on this date. There are no activities to report.

OBG Assembly Segment 3BE- Caltrans QA observed ZPMC is in the process of fitting four (4) Longitudinal Diaphragms at the SSD17 and SSD17A Panel Point (PP) 21 locations.

OBG Assembly Segment 4AE- Caltrans QA observed ZPMC depositing FCAW in the 1G position being deposited on CJP welds on Floor Beam FL 2-1 to FL 1-1 at location SSD 19 PP24 on both C5 and E7 side of Floor Beam. These welds are located on the top flange of the Floor Beams.

OBG Assembly Segment 4BE- Caltrans QA observed ZPMC measuring and marking the location for Panel Point

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(PP) 26.

North Fabrication Bay OBG Assemblies

OBG Assembly Segment 5AW- Caltrans QA observed this segment is idle on this date. There are no activities to report.

OBG Assembly Segment 5BW- Caltrans QA observed this segment is idle on this date. There are no activities to report.

OBG Assembly Segment 5CW- Caltrans QA observed this segment is idle on this date. There are no activities to report.

OBG Assembly Segment 4BW- Caltrans QA observed this segment is idle on this date. There are no activities to report.

OBG Assembly Segment 4AW- Caltrans QA observed ZPMC having completed tack welding complete on all longitudinal diaphragm located on Seg. 17 SSD14/14A, PP 025. This Caltrans QA observed Floor Beam FB015-02 flange plate that attaches to longitudinal diaphragm LD 002 having a root opening of 11mm. The allowable root opening on ZPMC's WPS is 5mm. In a conversation with ZPMC CWI Bao Lei a ZPMC welding repair report will be written in order to resolve this issue. See attached photograph for additional information.

OBG Assembly Segment 3BW- Caltrans QA observed FCAW being deposited on the two welds (Number 008 and 009) attaching the Longitudinal Diaphragm (Number LD11) to Bottom Panel at the SSD13 - PP23 segment 15 location.

OBG Assembly Segment 3AW- Caltrans QA observed this segment is idle on this date. There are no activities to report.



Summary of Conversations:

Conversations are within the body of the report.

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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
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Reviewed By:	Lanz, Joe	QA Reviewer
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