

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-003216**Date Inspected:** 16-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 this segment is idle on this date. There are no activities to report.

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

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

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North Fabrication Bay OBG Assemblies

OBG Assembly Segment 5AW- Caltrans QA observed ZPMC Fitting Floor Beam sections FL2-1, FL2-2 and FL1-1 at the Panel Point (PP) 31 location.

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 ZPMC Grinding weld profile on "A" side of weld connecting the Side panel on the C5 side of the assembly to the Bottom Panel E6 in order to fit up Longitudinal Diaphragm.

OBG Assembly Segment 4AW- Caltrans QA observed ZPMC in the process of fitting all Floor Beam segments at the Panel Point (PP)24 location.

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

OBG Assembly Segment 3AW- Caltrans QA observed ZPMC personnel depositing FCAW filler metal on CJP weld connecting Floor Beam FL3 to the Side Panel E7 (Weld number 15) located at Seg. 13A PP21. Caltrans QA also observed ZPMC personnel depositing SMAW filler metal to the "B" side, on CJP weld connecting Seg. 13A Side Panel E7 to Bottom Panel D6, Weld Number 11.



Summary of Conversations:

Conversations are within the body of the report.

Comments

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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 Ady, Velasco 13816942685, who represents the Office of Structural Materials for your project.

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