

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-003484**Date Inspected:** 14-Jul-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2200**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** Li Yun Hua**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:**

Deck Panel Repair Area 2 (yard)

This Quality Assurance (QA) inspector arrived at ZPMC in Shanghai China for observation of Orthotropic Bridge Girders (OBG) and Self Anchored Suspension (SAS) Bridge. ZPMC has started OBG Deck Panel repairs located at the North West corner of ZPMC facility, passed the OBG assembly shop. At approximately 1630hrs ZPMC QC informed Caltrans that no repairs were being performed and only jig tables were being fit-up at this time. This QA inspector observed ZPMC workers grinding at weld terminations on several deck panels listed as follows; DP163-001, DP459-001 and DP244-001. At 1930hrs ZPMC informed this QA inspector that three (3) initial visual inspections (VT) of Deck Panels were ready and necessary to begin repairs. ZPMC, ABF and Caltrans representatives were outside after dusk performing VT inspection before repairs with flashlights. Caltrans and ABF representative made ZPMC aware that there was possible not sufficient lighting to perform VT inspection prior to repairs. The inspection continued with flashlights and one of three Deck Panels number DP163-001 was completed by 2100hrs. ZPMC informed Caltrans that there would not be any work performed at this new repair location after 2100hrs.

Tower Shop Bay 3 Deck Panel repairs

The QA Inspector randomly observed ZPMC personnel performing grinding of repairs for the Orthotropic Box Girder (OBG) deck panel Partial Joint Penetration (PJP) welds. During initial observations it was noted that twenty-two (22 ea) deck panels are inside the shop. This QA inspector observed the repair grinding on the following deck panels; DP245-001, DP272-001, DP191-001 and DP488-001 these were in process for the remainder of this shift. This QA inspector requested from ZPMC that deck panel Dp083-001 be un-stacked and available for Caltrans to perform an initial visual inspection. ZPMC informed Caltrans that they would have the

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panel available by the day shift which was agreeable. Certified Welding Inspector for ZPMC Li Yun Hua was present at this location for the monitoring of the deck repairs and inspection. Also noted in bay 3 to monitor deck panel repairs were ABF personnel Kevin Chen, Wang Zhong Yuan and Ding Bao Hua.



Summary of Conversations:

As noted above.

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 Ady Velasco , 1-381-694-2685, who represents the Office of Structural Materials for your project.

Inspected By:	Riley, Ken	Quality Assurance Inspector
Reviewed By:	Carreon, Albert	QA Reviewer
