

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-000668**Date Inspected:** 17-Oct-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1430**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:	N/A	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 - Closed Rib Trials	

Summary of Items Observed:

OBG-CLOSED RIB TRIALS

The Caltrans Quality Assurance (QA) Inspector Charlie Franco was present at the time requested to randomly observe welding and associated operations being performed for the OBG Closed Rib Trials. The QA Inspector observed that the Closed Rib Trial Assembly was in the process of being clamped down onto the jig for the Gas Metal Arc Welding (GMAW) and Submerged Arc Welding (SAW) gantry. The gantry jig allows for the Closed Rib Trial Assembly to be clamped down and placed in a negative deflection for welding. The QA Inspector was informed by Pete Ferguson of ABF, that ZPMC had jumped the gun, removed the Closed Rib Trial Assembly from the welding table and placed it on the gantry jig. Mr. Ferguson also informed the QA Inspector, that the Closed Rib Trial Assembly would be unclamped from the gantry jig and returned to the welding table, where required dimensions could be rechecked by ZPMC and then verified by the QA Inspector. The QA Inspector observed the CRTA being unclamped, removed from the gantry jig and returned to the welding table. Mr. Ferguson informed the QA Inspector that after ZPMC had rechecked the dimensions, that ZPMC would inform the QA Inspector so that the QA Inspector could perform his verification of the tack welds and gap between the ribs and the CRTA bottom plate. ZPMC was not able to verify the original dimensions and the QA Inspector and therefore, the QA Inspector was not able to verify any dimensions. The attached photographs provide additional details.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)



Summary of Conversations:

Arbin of Bureau Veritas and Eric Hu of ZPMC, informed the QA Inspector that several dimensions had changed due to the moving of the Closed Rib Trial Assembly and the clamping down of it onto the gantry jig, and that the Closed Rib Trial Assembly was not fully released to the QA Inspector.

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 Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Franco,Charlie

Quality Assurance Inspector

Reviewed By: Cochran,Jim

QA Reviewer
