

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-004060**Date Inspected:** 05-Sep-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: ZPMC Zhang Bao Li
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: Yes No N/A
Verified Joint Fit-up: Yes No N/A
Approved WPS: Yes No N/A
Delayed / Cancelled: Yes No N/A

Bridge No: 34-0006**Component:** OBG Assembly**Summary of Items Observed:**

This report serves to document the events occurring on this date at the following location. Caltrans Quality Assurance (QA) Inspector Robert Vatcher arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. The QA Inspector observed the following:

ZPMC welding personnel Zhang Yan Bo ID number 045196 was observed performing welding operations in the 4G position at location 3AW for side plate to floor beam joining. The welder was observed continuously welding without utilizing a slag hammer or wire brush before subsequential weld passes were deposited. ZPMC QC personnel Shen Fu you was observed arriving to measure welding procedure specification parameters and did not direct the welder to utilize the above mentioned tools for interpass cleaning. QA brought this issue to the attention of AB/F QC Li Hanjie for resolution. Mr. Hanjie corrected the issue by directing the welder to de-slag and wire brush his welds.

Mid Bay- QA observed and performed a cursory visual examination where tack welds were being applied between diaphragm plates and deck panel U-rib and deck plates for deck panel DP080-001.

The above mentioned items as observed by QA and field resolved by AB/F QC & ZPMC QC appear to be in conformance with the contract documents.

Summary of Conversations:

See above for situational specific conversation summaries.

WELDING INSPECTION 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 Ady Velasco 138-1694-2685, who represents the Office of Structural Materials for your project.

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