

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-004063**Date Inspected:** 01-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:** AB/F Wang Heng**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 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 personnel indicated multiple locations requiring weld reinforcement blending by manual grinding for the below mentioned deck panels. Several ZPMC QC personnel and AB/F QC were involved performing said visual examinations. As well QA performed a cursory visual examination following behind both contractor QC. QA inquired about the weld cap blending and if QC personnel would be following up with another final visual examination. ZPMC QC responded with "yes."

DP557-001

DP563-001

DP572-001

DP596-001

DP571-001

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QA has observed that ZPMC has performed fit-up and tack welding of diaphragm plates to deck panels in the OBG Assembly Building after receiving direction to suspend the work involving diaphragm to deck plate fit-up and welding by the Resident Engineer. Please see the Incident Report generated for this day concerning this issue.

North Fabrication Yard

QA was tasked with performing a selection of random locations for radiographic testing (RT) to be performed by ZPMC NDT personnel on transverse complete joint penetration joints for the following Deck panels;

DP119-1-153

DP119-2-153

DP281-1-117

DP092-1-117

DP254-1-189

DP362-1-189

DP470-1-189

The above mentioned items as observed by QA appear to be in conformance with the contract documents.

Summary of Conversations:

See above for situational specific conversation summaries.

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
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Reviewed By:	Cuellar,Robert	QA Reviewer
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