

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-004085**Date Inspected:** 06-Oct-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**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:	Sun Bo			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/Tower		

Summary of Items Observed:**OBG Bay 1**

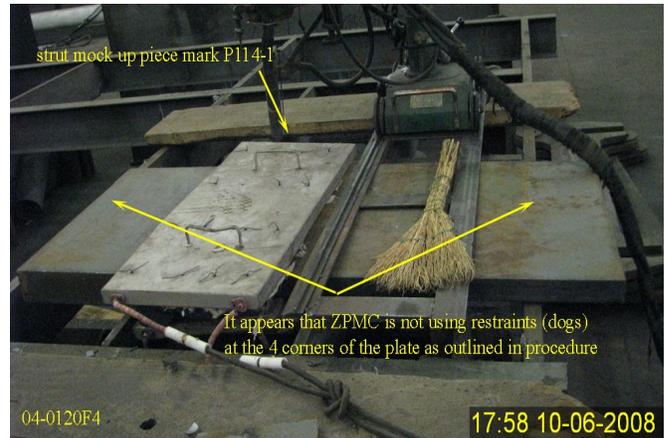
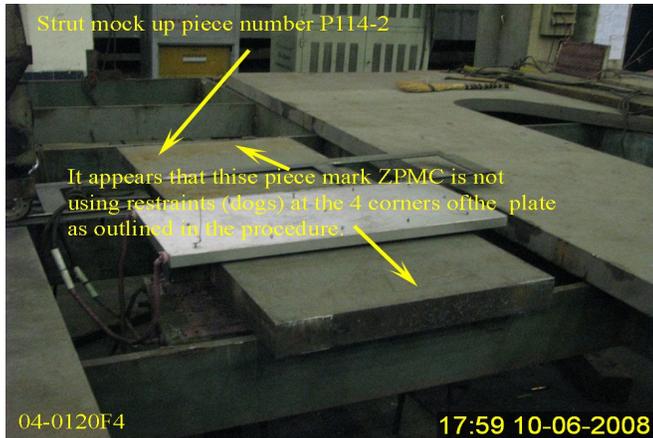
The Caltrans QA observed ZPMC has approximately thirty (30) to forty (40) workers performing various functions relative to the fabrication of the OBG Deck Panels. These functions include; closed rib milling, PJP weld joint beveling, drilling thru holes, press forming, closed rib splice welding, closed rib diaphragm fit-up and FCAW welding of splices, closed rib to deck plate fit-up and tack welding and the PJP welding of closed ribs to deck plates. Deck Plates at the gantry stations were, Gantry-1, DP499-001 was completed. DP585-001, DP411-001 and DP605-001 was stacked and stored at this station that had been completed on previous days. Gantry-2, DP560-001 is tack welded and ready for welding after PMT has been completed. DP148-001 and DP256-001 was stacked and stored at this station that had been completed on previous days. Tack weld table in this bay had deck plates DP585 and DP283 at this station being marked by ZPMC to receive the closed ribs.

Strut Mock-up Bay 4

This Caltrans QA observed ZPMC had been working on the strut mock swing shift QA did not observe any welding but did notice that the restraints (dogs) were not in place for welding as outlined in the welding mock up procedure at the time of the Caltrans QA observation. ZPMC had the SAW equipment set up and heating elements attached on piece marks P114-1 and P114-2. Piece mark MA26 appeared to be completed with the SAW welding as it was set off to the side.

WELDING INSPECTION REPORT

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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 Peter Dautermann 1-370-174-2104, who represents the Office of Structural Materials for your project.

Inspected By: Riley, Ken

Quality Assurance Inspector

Reviewed By: Carreon, Albert

QA Reviewer