

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-005288**Date Inspected:** 18-Jan-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Listed below**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 Segment**Summary of Items Observed:**

CALTRANS OSM Quality Assurance (QA) Inspector, Erik Prue was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island in Shanghai, China. QA Inspector and/or found the following:

Outside Paint Shop lift 5AE: QA Inspector observed ZPMC QC CWI inspectors perform visual inspection on the inside of OBG segment 5AE after ZPMC personnel finished sand blasting the interior of this segment. QA Inspector was informed by ZPMC QA Mr. Wang Li that the scheduled inspection would have to be postponed until 0930 due to ZPMC personnel were not finished cleaning the expended blast medium (sand) from the inside of this segment in order to facilitate inspection.

At approximately 0930 QA Inspector with Caltrans QA Inspector Mr. Steve Hall observed ZPMC QC CWI inspectors Mr. Shen Fu You, Mr. Li yan hua and Mr. Luan Zhao Gang along with ABF inspectors perform visual inspection on the interior welds and base material of segment. At approximately 1030 hrs ZPMC QC Mr. Wang Li informed QA Inspectors that ZPMC QC had completed the visual inspection of the interior of this segment. QA Inspector along with Caltrans QA Inspector Mr. Steve Hall observed numerous non conforming weld and base metal discontinuities that ZPMC QC did not mark for repair. Caltrans QA Inspector informed ZPMC QA Mr. Wang Li of these discontinuities. Mr. Wang scheduled another three party inspection for 1330 hrs.

QA Inspector along with Caltrans QA Mr. Steve Hall returned at approximately 1330 hrs to observe the above mentioned ZPMC QC CWI inspectors perform the rescheduled visual inspection. QA Inspectors observed that visual inspection areas marked for repair earlier were not completed. QA Inspectors were notified that when repairs were completed ZPMC QC would request QA inspection verification.

At approximately 1700 QA Inspectors were notified by Mr. Wang Li that the marked repairs had been

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completed by ZPMC and were ready for re-inspection. Mr. Wang Li informed QA Inspectors that ZPMC QC had not verified that the repairs had been completed. QA Inspector informed Mr. Wang Li that ZPMC QC must verify that the repairs comply with the contract documents prior to QA verification inspection. Mr. Wang Li also informed QA Inspectors that only the grinding repairs had been completed and that ZPMC could not perform any weld repairs on the welds requiring weld repair at this time due to the fact that the segment is located inside of the paint bay and any welding operations would be a safety hazard. Mr. Wang Li informed QA Inspectors that ZPMC would place tape over these areas prior to painting and perform the weld repairs at a later date. QA Inspector asked Mr. Wang Li how ZPMC QC intended to track and control the weld repairs on this segment. Mr. Wang was unable to give a definitive answer at this time. QA Visual inspection verification is not complete at this time. Lift 5AE will be reblasted and reinspected by ZPMC and ABF QC Inspectors tomorrow morning, QA Inspector will observe the QC inspection.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

Conversations noted above in Items Observed.

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 Eric Tsang, 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Prue,Erik	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
