

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-005340**Date Inspected:** 23-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 3BW, AM: QA Inspector observed ABF QC Inspectors perform visual inspection on the inside of OBG segment 3BW after ZPMC QC personnel performed final visual inspection on completed welds and base material on inside and outside not including the top of lift 3BW. ZPMC QC informed ABF QC Inspectors that visual inspection was complete. QA Inspector observed ABF QC Inspectors mark areas inside and outside the lift that needed repair by grinding and or grinding/welding. QA Inspector verified areas marked by ABF QC Inspectors and concur with their findings.

Outside Paint Shop lift 3BW, PM: ZPMC informed ABF and Caltrans QA Inspector that areas marked for repair on lift 3BW were complete and ready for re-inspection. QA Inspector along with ABF QC Inspectors verified areas inside and outside lift 3BW were repaired. Lift 3BW appear to be in compliance with the contract documents, AWS D1.5 (02), and special provisions. The top of lift 3BW still has some areas to be ground (temporary attachment welds) and or weld repaired before it is ready for 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.

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

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