

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-005410**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:** see 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:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Steve Hall 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) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG outside assembly (OBG segment 5AE)

This QA arrived on site at 0730 to observe 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. This QA was informed by ZPMC QA identified as Mr. Wang Li (Testino) that the scheduled inspection would have to be postponed until 0930 due to the fact that 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 this QA along with Caltrans QA Mr. Eric Prue observed ZPMC QC CWI inspectors identified as Mr. Shen Fu You, Mr. Li yan hua and Mr. Luan Zhao Gang along with ABF inspectors perform the visual inspection on the interior of this segment. At approximately 1030 hrs ZPMC QA Mr. Wang Li informed Caltrans QA that ZPMC QC had completed the visual inspection of the interior of this segment. This QA along with Caltrans QA Mr. Eric Prue observed numerous non conforming weld and base metal discontinuities that ZPMC QC did not mark for repair. (See attached photos) Caltrans QA informed ZPMC QA Mr. Wang Li of these discontinuities. Mr. Wang scheduled another three party inspection for 1330 hrs.

This QA along with Caltrans QA Mr. Eric Prue returned at approximately 1330 hrs to observe the above mentioned ZPMC QC CWI inspectors perform the rescheduled visual inspection. This QA along with Mr. Prue

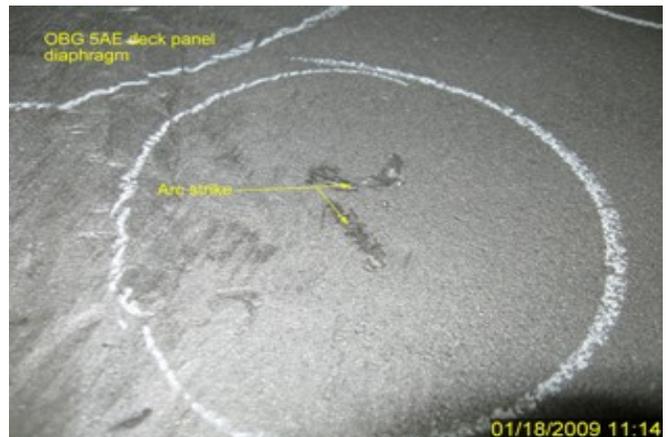
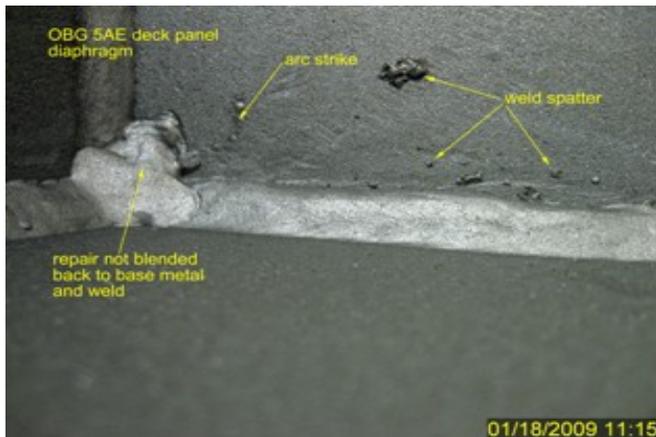
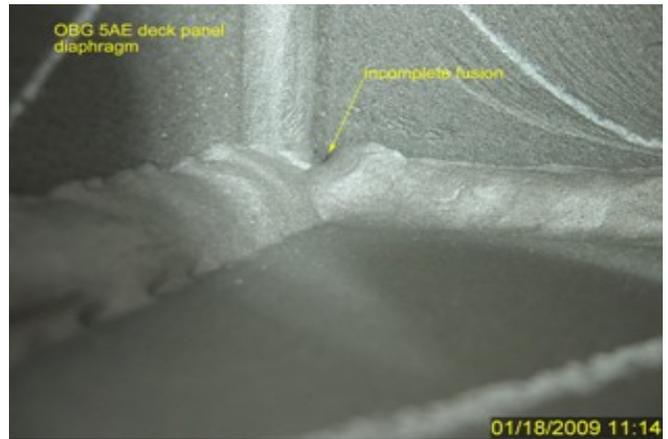
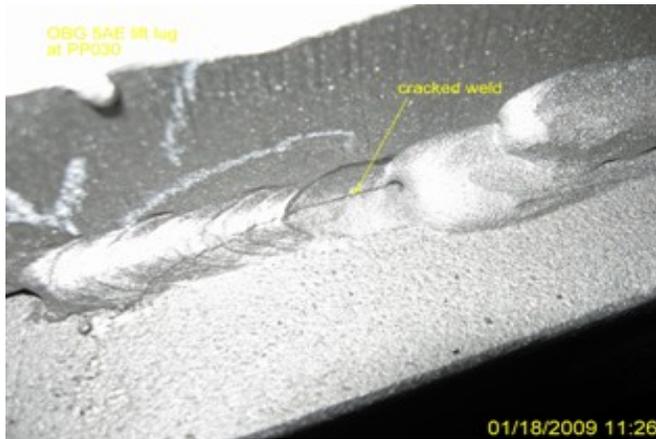
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observed that this visual inspection by ZPMC QC appeared to be compliant with AWS D1.5 and the contract documents.

At approximately 1700 hrs Mr. Wang Li notified this QA that the marked repairs had been completed by ZPMC and were ready for re-inspection. When this QA arrived to observe the re-inspection Mr. Wang Li informed QA that ZPMC QC had not verified that the repairs had been completed. QA 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 that only the grinding repairs had been completed and that ZPMC could not perform any weld repairs at this time due to the fact that this segment is located inside of the paint bay and any welding operations would be a safety hazard. Mr. Wang informed this QA that ZPMC would place tape over these areas prior to painting and perform the weld repairs at a later date. This QA asked Mr. Wang 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.

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



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Summary of Conversations:

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

Inspected By:	Hall,Steven	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
