

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-005559**Date Inspected:** 25-Jan-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**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:	N/A	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:

Bay 14 lift 2BE: QA Inspector observed ZPMC personnel fitting floor beams to side panel on lift 2BE. ZPMC workers are not tack welding the floor beams to the side panel at this time. Braces are being welded to the floor beams and welded to the side plates to facilitate proper fit up requirements of floor beams.

Outside Paint Shop: Lifts 3AW, 3AE, 3AW, and 4AE have 12 ZPMC personnel performing grinding operations inside lifts. Areas being ground are temporary attachment sites, weld spatter, mishandled areas on the edges of the stiffeners, and flame cut surfaces. No welding operations are being performed at this time.

BAY 14 Lift 1BE: QA Inspector verified the status of the green tagging of sub assemblies (side panels, longitudinal diaphragms, bottom plates, and floor beams) on lift 1BE by ABF QC. Eight (8) of the Twenty Six (26) sub assemblies checked have a current green tag affixed, Eighteen (18) sub assemblies do not have a green tag issued. QA Inspector informed ABF Inspector Mr. Warren Buehler of the status of lift 1BE green tagging of sub assemblies. Mr. Warren Buehler explained to QA Inspector that ABF is working on tagging the remaining sub assemblies and will inform Caltrans QA when green tagging is complete.

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

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

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
