

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-006495**Date Inspected:** 25-Apr-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**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	

Summary of Items Observed:

On this day 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) at Changxing Island in Shanghai, China. QA Inspector observed and/or found the following:

Segment 1BW: QA Inspector received notification that segment 1BW exterior has been blast cleaned and the welds and base material have been visually inspected by ABF and ZPMC QC personnel and is ready for QA visual inspection. QA Inspector performed visual verification on QC inspectors accepted welds and base material on the exterior of the segment. QA Inspector marked twelve (12) indications (arc strikes, unacceptable weld profile, and base material mishandling) that are unacceptable to AWS D1.5 (02) section 6.26. QA Inspector informed ABF QC and ZPMC QC personnel of the indications marked. ABF QC and ZPMC QC concurred with QA Inspectors findings and marked indication areas for repair. ZPMC QC directed workers to repair the marked indications by grinding. QA Inspector marked ten (10) indications for weld repair. Indications are gouged areas on top of lift in deck panels > 7% of base material thickness. Weld repair areas are where temporary attachments were removed. The ten areas marked for weld repair will be corrected after painting when segment is moved to segment splicing area. Specific locations of areas requiring weld repair are tracked on segment tracking spread sheet. ABF QC and ZPMC QC will reinspect the areas repaired by grinding then inform QA Inspector when inspection is complete.

QA Inspector continued OBG Segment tracking documentation control for sub assembly green tagging, segment weld repairs after blast cleaning, and segment splicing fit up dimensions taken.

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

Summary of Conversations:

No significant conversations this day.

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:	Carreon,Albert	QA Reviewer
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