

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-006652**Date Inspected:** 06-May-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:** Chen Xi**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 crossbeams**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 cross beam CB1

During random Visual Testing (VT) this QA observed two cracks in two Complete Joint Penetration (CJP) welds identified as SB215-001-048 and FB206-001-028. Weld SB215-001-048 is joining one of the west side panel stiffener ends to the floorbeam diaphragm nearest to the south end of the crossbeam. Weld FB206-001-028 is joining one of the intermediate panel stiffener ends to the floorbeam diaphragm nearest to the north end of the crossbeam. This QA informed The contractors Quality Control (QC) Certified Welding Inspector (CWI) identified as Mr. Chen Xi as well as American Bridge Fluor (ABF) lead inspector identified as Mr. Kelvin Cheung of this issue. Mr. Cheung informed this QA that he instructed the contractors personnel to grind the cracked areas in order to determine the extent of the cracks. At this time this QA does not know exactly what the contractor intends to do to repair these cracks. This QA has informed the contractors QA identified as Mr. Wang Lu and ABF representative identified as Mr. Noe Pasiola that an incident report would be submitted for this issue.

OBG cross beam CB3

This QA observed that no significant work was being performed on this crossbeam during the time QA was

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

present.

OBG cross beam CB4

This QA observed that no significant work was being performed on this crossbeam during the time QA was present.

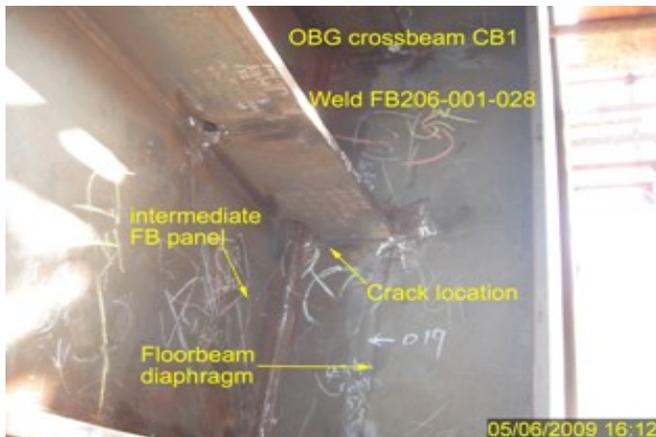
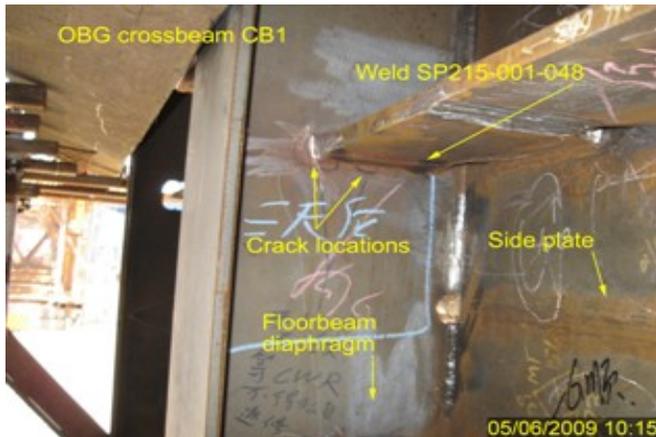
OBG cross beam CB5

This QA observed that no significant work was being performed on this crossbeam during the time QA was present.

OBG cross beam CB6

This QA observed That ZPMC personnel are continuing to fit and tack weld floorbeam diaphragm sections in this crossbeam.

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 3 of 3)

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:	Prue,Erik	QA Reviewer
