

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-006948**Date Inspected:** 30-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:** Wu Zhi Cheng**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 crossbeam CB3**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 CB3 (in superstructure trial assembly)

This QA was instructed by Caltrans QA task leader to compile a punch list of outstanding issues concerning this cross beam as well as the external FL3 areas of OBG segments 4BE a 4BW (panel points 026 through 028). This QA compiled the following list and submitted it to Caltrans QA task leaders and Caltrans Island Structural Materials Representative (ISMR): PP026, 027 and 028 west line; Connection plate X27A still tack welded to OBG 4BW side panel, PP026 partial height diaphragm to FL3 west line; weld repair overlap, FL3 partial height diaphragms; No initial NDT has been performed by ZPMC, interior/exterior; needs touch up blast and paint, PP026, 027 and 028 east line; plate X27A not fit and welded to top of partial height diaphragms, FL3 stiffeners PP02, 027 and 028; numerous notches in edges of stiffeners need to be addressed, splice at east and west lines; numerous material surface gouges where splice plates were temporarily tacked, splice at east and west lines; CB side panel to FL3 splice not straight, PP027 partial height diaphragm to FL3 east line; weld repair overlap, PP028 partial height diaphragm to FL3 west line; weld repair overlap, various locations; stiffener pass through slots improper radius and Web splices on partial height diaphragms; cope holes improper radius.

This QA observed ZPMC personnel removing temporary tack welds from SPCM splice plate identified as X202E. This splice plate was temporarily tack welded to the outside of the bottom panel on the north end of CB3

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

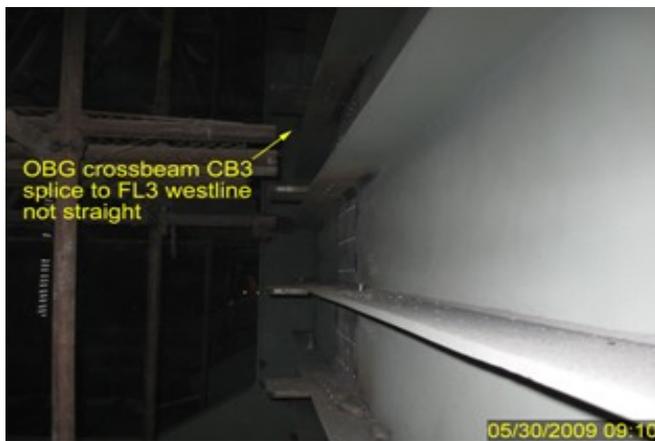
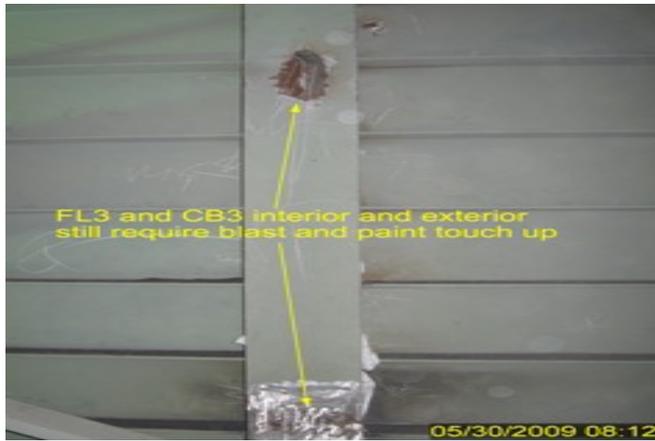
and OBG segment 4BW. The worker was using an oxy/fuel torch to remove the tack welds. The edge of the splice plate was damaged at 16 areas where these tack welds were removed. AWS D1.5 2002 section 3.3.7.3 states "Tack welds not incorporated into the final weld shall be removed in such a manner that the base metal is not nicked or undercut. Repair of base metal accidentally removed shall be approved by the Engineer prior to making the repair". See attached photos. This QA notified ZPMC QC CWI identified as Mr. Wu Zhi Cheng and ABF QA inspector identified as Mr. Ping Xing Chi of this non conformance and informed both that an incident report would be generated for this issue.

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 4)



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.

WELDING INSPECTION REPORT

(Continued Page 4 of 4)

Inspected By:	Hall, Steven	Quality Assurance Inspector
Reviewed By:	Prue, Erik	QA Reviewer