

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-007279**Date Inspected:** 04-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Chih Chien**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 trial assembly**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 observed ZPMC personnel grinding and general clean up on this crossbeam. This QA along with Caltrans QA task leader Mr. John Kinsey verified several punch list items generated by ABF inspectors for this crossbeam. The items listed included deburring bolt holes in the side, bottom and deck panel stiffener ends and grinding limited areas of the side, bottom and deck panel butt welds flush at the north and south ends of the crossbeam in order to provide full contact with the splice plates. Both of these punch list items appeared to have been completed and in general compliance with the contract documents.

OBG cross beam CB4

This QA observed that this crossbeam is still in the paint bay. No significant work was observed on this crossbeam during the time QA was present.

OBG cross beam CB5

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

This QA observed ZPMC personnel grinding and general clean up on this crossbeam. No other significant work was observed during the time QA was present.

OBG cross beam CB6

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

OBG cross beam CB7

This QA was informed by Caltrans QA task leader that the contractor had notified Caltrans of their intentions of cutting a 300mm section of weld from weld joint identified as CB201F-007-002. This QA determined the purpose for the contractor cutting this area was due to a misalignment between the two plates of approximately 2mm which exceeded the tolerances specified in AWS D1.5 2002 of 10% of the thickness of the thinner part, in this case 1.4mm. No other significant work was observed during the time this QA was present.

OBG cross beam CB8

This QA observed ZPMC personnel fitting floorbeam diaphragm sections for the bottom panel of this crossbeam. No other significant work was observed during the time this QA was present.

OBG bay 5 bike path cantilever brackets

This QA observed that no significant work was being performed on any of the cantilever brackets during the time this QA was present.

Suspension Brackets

During random visual inspection of the suspension brackets currently in the superstructure trial assembly this QA found that the contractor appears to have a small area of unfinished weld on each of the brackets. This QA informed ZPMC QA identified as Mr. Wang Lu of this discrepancy. Mr. Wang told this QA that he would look at the drawings to determine why these areas may have been left unwelded. As of the end of this shift this QA is still waiting for Mr. Wang to respond to this issue. See attached photos.

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
