

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-007280**Date Inspected:** 03-Jun-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:** Shi Lin**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 superstructure trial assembly east line

During random visual inspection of segment 4AE/4BE this QA observed the following: fillet welds joining longitudinal diaphragm LD16F and LD15F to the bottom panel of segment 4AE are over the specified size of 8mm and 6mm respectively. The weld sizes are 42mm at LD16F and 26mm at LD15F. See attached photos. Side and bottom panel T-stiffener bolt holes @ 3BE connection need to be deburred, paint runs on underside of side and bottom panel stiffeners @ 5AE connection, slag trapped between the faying surfaces of FL3 bottom flange and bolt on bottom plate @ PP026 on segment 4BE.

This QA observed that the contractor appears to have performed base metal edge weld repair without cleaning and removing slag prior to welding. The part is identified as X82V. The part is located on FL3 floorbeam identified as FB018A @ PP026 on OBG segment 4BE. AWS D1.5 2002 section 3.7.1 states..."The surface shall be thoroughly cleaned before welding." This QA informed ZPMC QC inspector identified as Mr. Zhang Hai Jun and ABF QA inspector identified as Mr. Li Jing Bo that an incident report would be generated for this issue.

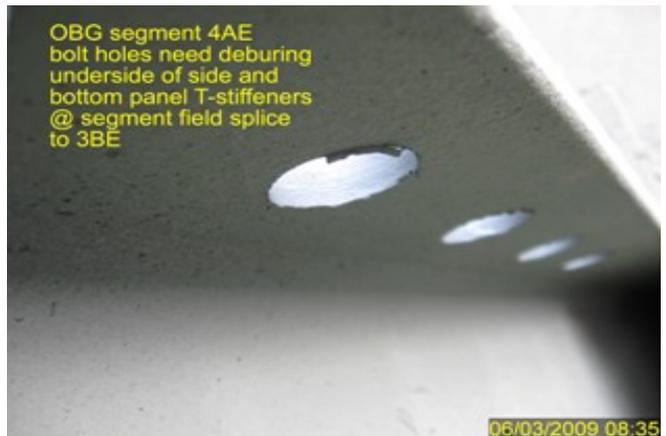
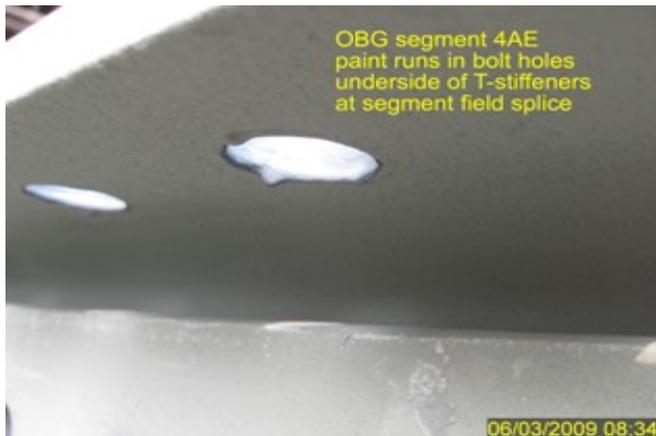
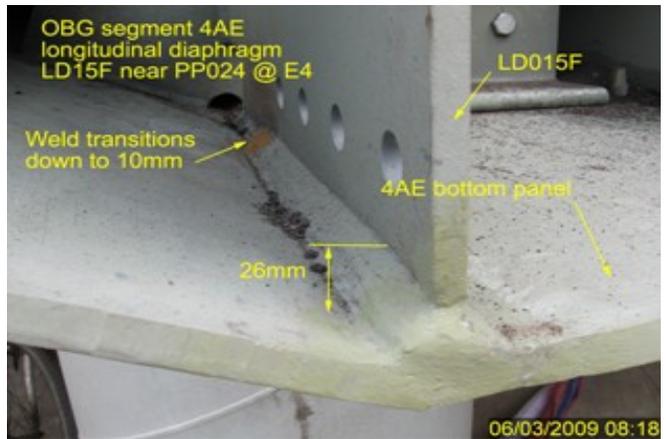
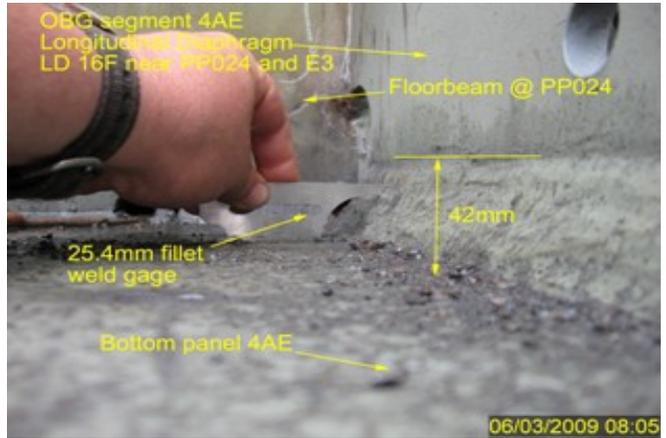
OBG superstructure trial assembly west line

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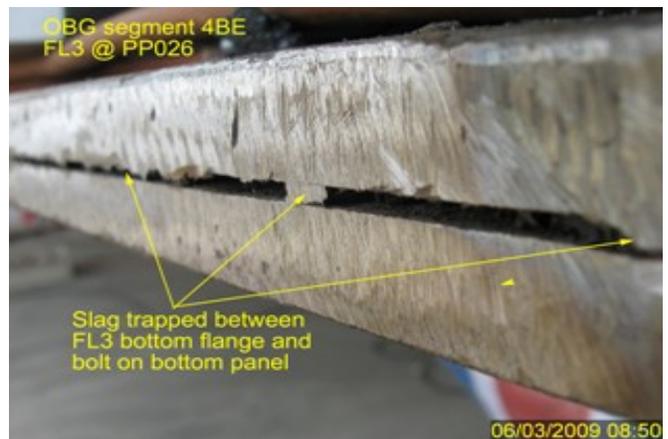
This Quality Assurance (QA) inspector observed the contractors welding personnel perform base metal edge weld repair without preheating. The parts are identified as X38L and X38K. It appears the contractor has repaired approximately 35 of these parts. Approved Weld Procedure Specification # WPS-345-FCAW-1G (1F)-Repair specifies 60 deg. minimum preheat for material equal to or less than 20mm thick. This QA informed ZPMC QC identified as Mr. Shi Lin (CWI) and ABF QA inspector identified as Mr. Kevin Chen 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.



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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
