

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-009262**Date Inspected:** 28-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Zhu Tian Shu	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 date Caltrans OSM Quality Assurance (QA) Inspector, Larry Viars was present during the times noted above for observations relative to the work being performed.

OBG Trial Assembly-

The Caltrans Quality Assurance (QA) Inspector observed that ZPMC personnel have removed a small section of the lower Floor Beam and replaced this section with an unknown steel material insert plate. The contractor had removed two (2) existing fillet welds, cut out a portion of the lower Floor Beam and added a new un-approved complete joint penetration (CJP) and 2 fillet welds without the Engineers approval. This un-approved repair was performed at OBG Segment 5BW lower Floor Beam (FB5A) to Bottom Panel at panel point 33 between the 4th and 5th stiffeners. Caltrans QA issued a Incident Report this date for the above mentioned unauthorized repair. For further information, please see the attached pictures below.

Bay 2-

This QA Inspector observed the following work in progress: FCAW welding of OBG Floor Beam weld FB3043-001-012. ZPMC welder was identified as 203871. ZPMC QC is identified as Zhu Tian Shu. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2132-3.

Bay 3-

WELDING INSPECTION REPORT

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This QA inspector performed Ultrasonic Testing (UT) verification of the areas previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member was identified as Floor beam FB023-010. The weld identification numbers are as follows: FB023-010-125, 126 and 127.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

Only general conversation occurred between QC and QA this date.

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, 150 0042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Viars,Larry	Quality Assurance Inspector
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Reviewed By:	Carreon,Albert	QA Reviewer
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