

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-002235**Date Inspected:** 07-May-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	An Qingxiang	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:	Tower Skin Plates	

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:

New Tower Bay 1

QA observed ZPMC qualified welding personnel perform SAW on one side of the groove weld joining tower skin plates, weld# SSD1_SA173-13/k-7B and SSD1-SA179-A/E-4B following the guide lines of approved WPS# WPS-B-T-2221-B-U3c-S. QA observed 7 ZPMC Quality Control (QC) inspectors in the vicinity of the welding operations including ZPMC CWI identified as An Qingxiang. There was also 4 American Bridge/Fluor (ABF) QC inspectors in the area as well. QC monitored the welding process continuously until its completion. The welder identification and the welding parameters as measured with Quality Controls calibrated instruments appeared to be in conformance with the posted WPS's and were as listed below.

New Tower Bay 2

QA observed ZPMC QC Ultrasonic Testing (UT) Technician identified as Xue Hai Yong UT tower skin plate weld number ESD1-SA227A/4-15A. QC found this weld to be noncompliant with the contract documents.

QA observed ZPMC qualified welding personnel perform SAW on one side of the groove weld joining tower skin plates, weld# ESD1-SA216-J/K-3, ESD1-SA77A/E-43A and ESD1-SA294A/G-1A following the guide lines

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of approved WPS# WPS-B-T-2221-B-U3c-S. QA observed 5 ZPMC Quality Control (QC) inspectors in the vicinity of the welding operations. There were also 3 American Bridge/Fluor (ABF) QC inspectors in the area as well. QC monitored the welding process continuously until its completion. The welder identification and the welding parameters as measured with Quality Controls calibrated instruments appeared to be in conformance with the posted WPS's and were as listed below.

Other general observations

QA observed 100 to 120 ZPMC personnel flame straightening tower skin plate material, weld bevel preparation, back-gouging and grinding.



Summary of Conversations:

As noted 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 Patrick Lowry (858)-344-2712, who represents the Office of Structural Materials for your project.

Inspected By:	Hall,Steven	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer
