

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-003091**Date Inspected:** 27-Jun-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1000**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2000**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Chih-Ming**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 side, bottom and deck panels**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 new assembly bay 2

QA observed ZPMC qualified welding personnel perform SAW on SEG-025A-006 BP-031 to BP-139 following the guide lines of WPS# WPS-B-T-2221-B-L2c-S-1. QC monitored the welding process continuously throughout the evening. The welding parameters as measured with Quality Controls calibrated instruments appeared to be in conformance with the posted WPS's and were as follows:

Volts: 31 Amps: 536 Travel speed: 569mm/min

QA observed ZPMC qualified welding personnel perform FCAW 3G welding on floor beam @ PP-021 FL2-1 to FL1 south joint# SSD11A-PP021-130 and FL2-1 to FL1 north joint# SSD11A-PP021-013 following the guide lines of WPS# WPS-B-T-2233-B-U2-F. QC monitored the welding process continuously throughout the evening. The welding parameters as measured with Quality Controls calibrated instruments appeared to be in conformance with the posted WPS's and were as follows:

Volts: 24.2 – 26.5 Amps: 205 - 215 Travel speed: 109 - 120mm/min

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QA performed 10% Ultrasonic Testing (UT) verification on the following floor beam weld joints on segment 4AW: FB-001-PP025-021 and 026 / FB-004-PP025-002 and 020, FB-003-PP025-010, 022, 034 and 046. All welds examined appeared to be compliant with AWS D1.5 2002 and the contract documents.

Other general observations include ZPMC personnel fitting and welding OBG temporary support columns, grinding and weld bevel prep on various OBG components.



Summary of Conversations:

Only general conversations were held between QA and QC concerning this project.

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
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Reviewed By:	Cuellar,Robert	QA Reviewer
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