

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-004606**Date Inspected:** 11-Nov-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Hu Gui Hua**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 Office of Structure Materials (OSM) Quality Assurance Inspector (QA) Raymond Lara was present at jobsite in Zhenhua Port Machinery Company facility on Changxing island, China for the purpose of observing and monitoring the fabrication of the SAS Superstructure.

Bay 1

The Quality Assurance Inspector observed ground tack welds DP396-001 staged and ready for magnetic particle testing by ZPMC Quality Control Inspectors.

The Quality Assurance Inspector performed a visual observations on tack welds on DP396-001 and DP342-001. The tack welds observed by the Quality Assurance Inspector appears to meet contract requirements.

The Quality Assurance Inspector observed ZPMC personnel in process of removing the height on tack weld areas in the gas metal arc welding filler metal prior to welding the sub merged arc welding process on DP231-001.

The Quality Assurance Inspector observed ZPMC personnel in process chalking lay out lines used to aid in the fit up of U-ribs for DP341-001.

The Quality Assurance Inspector performed a visual observation on U-rib bevel production the QA measured the root face on several U-ribs to measure 2 to 2.2mm in width with a bevel angle of 43 to 45 degree. The QA observation appears to be in accordance with WPS-B-T-2342-U5.

WELDING INSPECTION REPORT

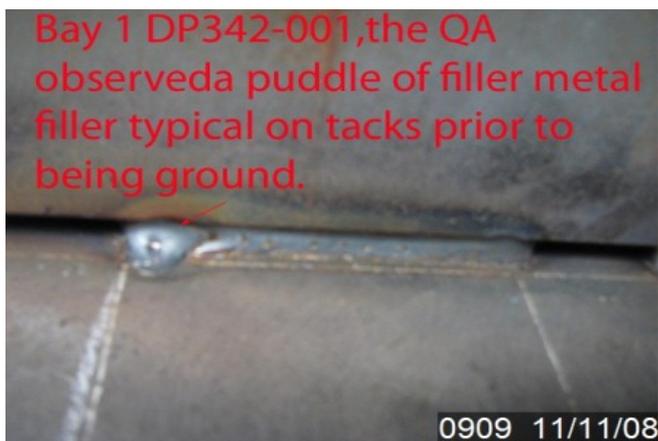
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DP151-001

The Quality Assurance Inspector observed ZPMC welder 059421, utilizing the sub merged arc welding process on a partial penetration weld joint on DP151-001 weld 1. The Quality Assurance Inspector observed ZPMC Quality Control Personnel record parameters and verify preheat temperatures. The welding parameters observed by the Quality Assurance Inspector appeared to be within welding procedure specification WPS-B-T-2342 (U rib)-4.

DP151-001

The Quality Assurance Inspector observed ZPMC welder 201840, utilizing the sub merged arc welding process on a partial penetration weld joint on DP151-001 weld 9. The Quality Assurance Inspector observed ZPMC Quality Control Personnel record parameters and verify preheat temperatures. The welding parameters observed by the Quality Assurance Inspector appeared to be within welding procedure specification WPS-B-T-2342 (U rib)-4.



Summary of Conversations:

No relevant conversations on 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 Peter Dautermann 150 0219 9593, who represents the Office of Structural Materials for your project.

Inspected By: Lara, Raymond

Quality Assurance Inspector

Reviewed By: Wright, Mark

QA Reviewer