

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-005689**Date Inspected:** 07-Mar-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:	Shen Fuyou/Yu Dong Ping	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 segments and suspension brackets**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 assembly bay 13

This QA observed ZPMC qualified welding personnel identified as Mr. Wang Linjiang (051356) perform FCAW welding on weld joint identified as SSD20A-PP017-124. ZPMC QC identified as Mr. Zhang Xian Ji was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132.

This QA observed ZPMC qualified welding personnel identified as Mr. Liu Xiaolin (067079) perform FCAW welding on weld joint identified as SSD20-PP017-128. ZPMC QC identified as Mr. Zhang Xian Ji was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2133.

This QA observed ZPMC qualified welding personnel identified as Mr. Wang Linjiang (051356) perform FCAW welding on weld joint identified as SSD19-PP019-135. ZPMC QC identified as Mr. Zhang Xian Ji was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2133.

OBG assembly bay 14

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This QA received ZPMC Non Destructive Testing (NDT) notification No. 002179 and performed Ultrasonic Testing (UT) of approximately 10% of the welds previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA generated a UT report for this date. The weld designations are as follows: DP545-002-011, 013, 015, 017 and 104. DP545-002-071, 082 and 093 were covered through lot testing of weld 104.

This QA observed ZPMC qualified welding personnel identified as Mr. Liu Zipei (062406) perform SAW welding on weld joint identified as SEG038A-004. ZPMC QC identified as Mr. Shi Lei was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-L2c-S-2.

This QA observed ZPMC qualified welding personnel identified as Mr. Wang Lanying (045265) perform SAW welding on weld joint identified as SEG004*-003. ZPMC QC identified as Mr. Zhang Xiao Ming was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-L2c-S-2.

This QA observed ZPMC qualified welding personnel identified as Miss. Xie Jinxia (048038) perform FCAW buttering (build with weld) on floor beam identified as FB020A-001 OBG segment 6AE. According ZPMC Weld Repair Report #B-WR2839 buttering was being performed due to the web plate being beveled on the wrong side at the splice joint to another section of the floor beam. ZPMC QC identified as Mr. Shi Lei was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-FCAW-1G-(1F)-FCM-repair. ZPMC QC appears to have laid out a 100mm reference mark on the plate in order to monitor the amount of buttering being applied to the edge of the plate.

OBG assembly bay 19

This QA observed ZPMC qualified welding personnel identified as Mr. Liu Hoanguang (062794) and Mr. Yu Binge (062737) perform FCAW welding on suspension bracket identified as SB007-044. ZPMC QC CWI identified as Mr. Xu Tao Qing was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132-3.

This QA received ZPMC Non Destructive Testing (NDT) notification No. 002177 and performed Ultrasonic Testing (UT) of approximately 10% of the welds previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA generated a UT report for this date. The weld designations are as follows: BP028-001-002 and 003. This QA noted that ZPMC QC UT technicians have rejected weld identified as BP028-001-001.

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:

Only general conversation was 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:	Carreon,Albert	QA Reviewer
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