

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-008047**Date Inspected:** 03-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: Zhang Xian Ji
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: Yes No N/A
Verified Joint Fit-up: Yes No N/A
Approved WPS: Yes No N/A
Delayed / Cancelled: Yes No N/A

Bridge No: 34-0006**Component:** OBG segments**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 044779 perform SMAW welding on OBG segment 8AE weld joint identified as SEG-044D-018. ZPMC QC identified as Mr. Wang Xu 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-P-2213-Tc-U4b-FCM.

This QA observed ZPMC qualified welding personnel identified as 069683 perform SMAW welding on OBG segment 8CW weld joint identified as SEG-047*-048. ZPMC QC identified as Mr. Wang Xu 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-P-2214-Tc-U4b-FCM-1.

This QA observed ZPMC qualified welding personnel identified as 049339 perform SMAW welding on OBG segment 8CW weld joint identified as SSD10A-PP068-131~138. ZPMC QC identified as Mr. Wang Xu 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-P-2114-FCM-1.

This QA observed ZPMC qualified welding personnel identified as 044772 perform SMAW welding on OBG segment 8CW weld joint identified as SSD022-PP69.5-123~178. ZPMC QC identified as Mr. Wang Xu was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

appeared to be in general compliance with WPS-B-P-2114-FCM-1.

OBG assembly bay 14

This QA observed ZPMC qualified welding personnel identified as 044795 perform FCAW welding on OBG segment 9AE weld joint identified as SSD19A-PP073-107~124. ZPMC QC CWI 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 051356 perform FCAW welding on OBG segment 9AE weld joint identified as SSD19-PP072-071~106. ZPMC QC CWI 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 201215 perform FCAW welding on corner assembly CA059 for OBG segment 9BW weld joint identified as CSD2-PP73.5-023, 024, 019, 020, 015 and 016. ZPMC QC identified as Mr. Li Ming Yang 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 202122 perform FCAW welding on corner assembly CA059 for OBG segment 9BW weld joint identified as CSD3-PP76-086, 090 and 094. ZPMC QC identified as Mr. Li Ming Yang 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-2233-Tc-U4b-F.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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 Eric Tsang (15000422372), who represents the Office of Structural Materials for your project.

Inspected By:	Hall,Steven	Quality Assurance Inspector
Reviewed By:	Prue,Erik	QA Reviewer
