

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-008058**Date Inspected:** 04-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 two ZPMC personnel back gouging Complete Joint Penetration (CJP) welds inside segment 8AE where parts identified as X37 weld to the corner assembly edge plate at or near E5.

No other significant work was being performed in this bay during the time QA was present.

OBG assembly bay 14

This QA observed ZPMC qualified welding personnel identified as 202122 and 058275 perform FCAW welding on corner assembly CA059 for OBG segment 9BW weld joint identified as CA59-004. 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-2232-Tc-U4b-F.

This QA observed approximately six to eight ZPMC personnel fitting and tack welding floorbeams in segment 10AE at panel points PP087 and PP088.

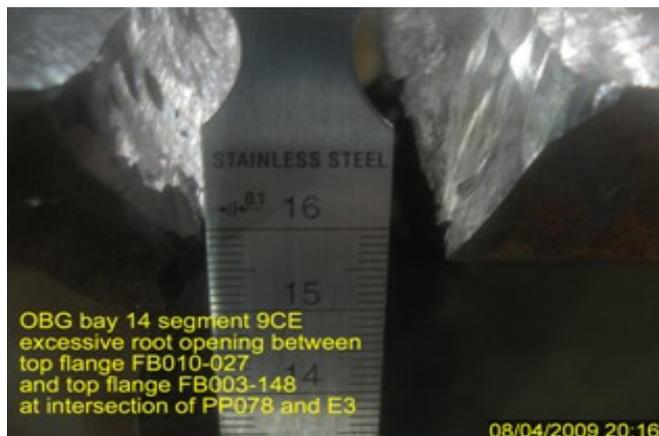
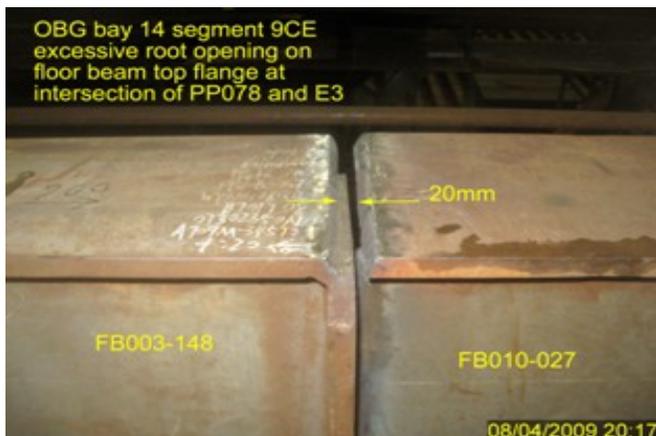
During random in process fit up inspection this QA observed a CJP weld excessive root opening of approximately 20mm. This joint is located on the top flange of floor beams identified as FB010-027 and FB003-148 at the intersection of PP078 and E3 on OBG segment identified as 9CE. This QA informed American

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Bridge Fluor (ABF) inspector identified as Mr. Bao Qian and ZPMC QC inspector identified as Mr. Guo Xing Hai of this discrepancy. Both inspectors indicated that ZPMC would “butter” (build up with weld) the weld joint prior to commencing with the welding of this joint. Mr. Bao and Mr. Guos’ proposal to “butter” the weld joint appears to be an acceptable method of repair according to AWS D1.5 2002. See attached photos.

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



Summary of Conversations:

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

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