

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-008407**Date Inspected:** 12-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:** Lu Li Qing**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**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 200432 perform SMAW welding on OBG segment 8AE weld joints identified as SEG044E-088. ZPMC QC identified as Mr. Guo Xing Hui 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.

OBG assembly bay 14

This QA observed ZPMC personnel inspecting bottom panel of OBG segment identified 9AW utilizing optical equipment.

This QA observed ZPMC personnel excavating welds rejected by ZPMC QC Ultrasonic Testing (UT) technicians on bottom panel of OBG segment identified as 9BW. Welds are identified as SEG051A-004 (QA noted 26 excavated areas) and SEG051A-005 (QA noted 34 excavated areas).

Outside OBG segment 6AW

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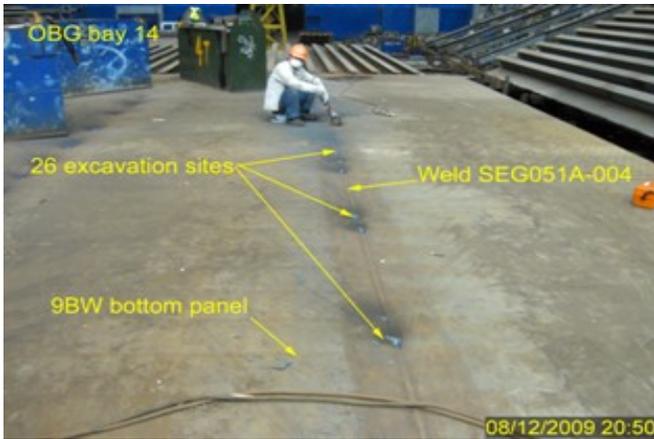
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This QA observed ZPMC qualified welding personnel identified as 045240 perform FCAW welding on OBG segment 6AW weld joint identified as SSD12-PP040-004. ZPMC QC identified as Mr. Yin Hai Peng was present to monitor the welding process. This QA observed that the contractor appears to have deviated from the weld joint design specified on the approved drawings for this weld. The contractor appears to have changed the weld joint from a fillet weld to a Complete Joint Penetration (CJP) weld without the Engineers approval. According to the contractors QC inspector identified as Mr. Yin Hai Peng the weld design was changed in order to compensate for a joint root opening in excess of 5mm. The QC inspector did not have an approved procedure in hand to change the required fillet weld to a CJP. This QA has submitted an incident report for this issue.

Outside OBG segments 7DW, 7BW, 7EW, 6CW, 6CE, 7EE, 7DE, 7CE, 6AE, 7CW, 7BE, 7AW, 6BE, 6BW and 7AE

This QA observed that no significant work was being performed on these segments during the time QA was present.

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.

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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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