

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-008470**Date Inspected:** 16-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:** Li Yan 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 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 068753 perform FCAW welding on OBG segment 9BE weld joint identified as DP474-001-033. 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-T-2133.

This QA observed ZPMC qualified welding personnel identified as 070046 perform FCAW welding on OBG segment 9BE weld joint identified as DP474-001-039. 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-T-2132.

OBG assembly bay 14

This QA observed ZPMC qualified welding personnel identified as 045265 perform SAW welding on OBG segment 9CW weld joint identified as SEG053A-007. ZPMC QC identified as Mr. Xu Tao 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.

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This QA observed ZPMC qualified welding personnel identified as 204730 perform FCAW root weld on OBG segment 9AW weld joint identified as SEG049*-007. ZPMC QC identified as Mr. Xu Tao 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-2231-B-U2-F.

Outside OBG segment 6AW

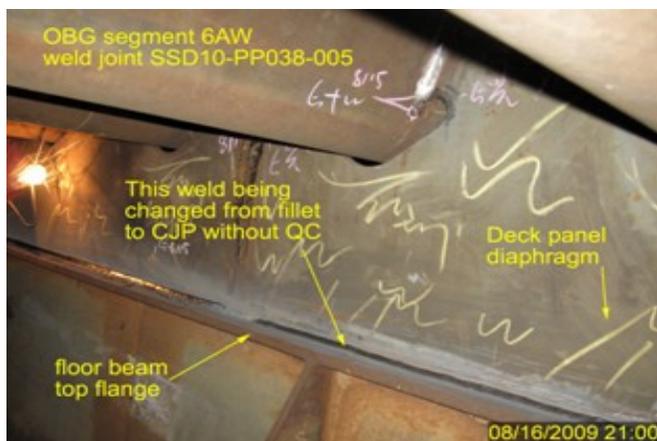
Between the times of 20:25 and 21:05 this QA observed ZPMC qualified welding personnel identified as 062708 and 058245 perform FCAW weld repairs on OBG segment identified as 6AW weld joint identified as SSD10-PP038-005. The contractors Quality Control inspector (QC) was not present to monitor the repairs. The projects contract special provisions section 8-3.01 states "QC inspections shall be provided to ensure continuous inspection when any welding is being performed. Continuous inspection, as a minimum, shall include (1) having QC Inspectors continually present on the shop floor or project site when any welding operation is being performed, and (2) having a QC Inspector within such close proximity of all welders or operators so that inspections by the QC Inspector of each operation, at each welding location, shall not lapse for a period exceeding 30 minutes". ZPMC QC identified as Mr. Wang Xiang Pin arrived in the vicinity of this segment at approximately 21:05 hrs. This QA asked Mr. Wang if he could show QA the weld monitoring report for this weld and welders. Mr. Wang was unable to produce any information regarding compliance to an applicable WPS. This QA informed Mr. Wang that an incident report would be generated for this issue.

NOTE: This weld currently has at least one outstanding/unresolved incident report issued by other Caltrans QA inspectors, dated 06/24/09, concerning the contractor changing the joint design from a fillet weld to a Complete Joint Penetration (CJP) weld without the approval of the Engineer.

Outside OBG segments 7DW, 7BW, 7EW and 6C

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.



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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
Reviewed By:	Prue,Erik	QA Reviewer
