

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-008728**Date Inspected:** 30-Aug-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:** Li Zhi Jiang**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 crossbeams**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 cross beam CB7 bay 1

This QA observed ZPMC qualified welding personnel identified as 215326 perform SMAW repair welding on various weld joints. ZPMC QC identified as Mr. Tian 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-P-2112 and WPS-B-P-2113.

OBG cross beam CB15 bay 1

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

OBG cross beam CB14 bay 3

This QA observed the contractor performing flame straightening on 15mm material without the Engineers approval. The procedure presented to this QA on the shop floor (HSR1(B)-7358) indicated that the distortion was

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5mm. This QA measured the distortion at 24mm in 1000mm. The weld joint is identified as CB202E-014-001. The contract Special Provisions section 8-3.01 states “for material equal to or less than 16mm, the contractor shall not heat straighten members more than 6 in 1000 without prior approval of the Engineer”. This QA informed ZPMC QC CWI identified as Mr. Li Zhi Jiang that an incident report would be generated for this issue. See attached photos for details.

OBG cross beam CB11 bay 5

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

OBG cross beam CB8 bay 6

This QA observed ZPMC qualified welding personnel identified as 053742 perform FCAW welding on weld joint identified as FB205-019-026. ZPMC QC identified as Mr. Liu Chuan Gang 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-B-U2-F-1.

This QA observed ZPMC qualified welding personnel identified as 019206 perform FCAW welding on weld joint identified as FB204-017-060. ZPMC QC identified as Mr. Liu Chuan Gang 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-B-U2-F-1.

OBG cross beam CB9 bay 6

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

OBG cross beam CB12 bay 8

This QA observed ZPMC qualified welding personnel identified as 066687 perform FCAW welding on weld joints identified as FB205-033-037. ZPMC QC identified as Mr. Zhang Jing Xin 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 observed ZPMC qualified welding personnel identified as 069118 perform FCAW welding on weld joint identified as FB205-036-025. ZPMC QC identified as Mr. Zhang Jing Xin 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-B-U2-F.

OBG cross beam CB13 bay 8

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

OBG cross beam CB10 outside trial assembly area

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

OBG cross beam CB1 outside trial assembly area

This QA observed that no significant work was being performed on this crossbeam 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.

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.

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