

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-009589**Date Inspected:** 08-Oct-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:** Chen Xi**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 and cantilever brackets**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 CB1

This crossbeam has been loaded on the ship.

OBG CROSS BEAM CB2

This crossbeam has been loaded on the ship.

OBG CROSS BEAM CB3

This crossbeam has been loaded on the ship.

OBG CROSS BEAM CB4

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

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

OBG CROSS BEAM CB5

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

OBG CROSS BEAM CB6

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

OBG CROSS BEAM CB7

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

OBG CROSS BEAM CB8

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

OBG CROSS BEAM CB9

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

OBG CROSS BEAM CB10

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

OBG CROSS BEAM CB11

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

OBG CROSS BEAM CB12

This QA observed ZPMC qualified welding personnel identified as 060687 perform FCAW welding on weld joint identified as CB201G-034-166. ZPMC QC identified as Mr. Sun Yan Fei 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.

OBG CROSS BEAM CB13

WELDING INSPECTION REPORT

(Continued Page 3 of 4)

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

OBG CROSS BEAM CB14

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

OBG CROSS BEAM CB15

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

OBG CROSS BEAM CB16

This QA observed ZPMC qualified welding personnel identified as 215248 perform SAW welding on weld joint identified as CB202C-016-001. ZPMC QC identified as Mr. Zhong Chong Biao 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.

This QA observed that ZPMC welding personnel have completed all of the weld repairs on the FB205 floor beam corner sections mentioned in this QAs daily reports dated 10/06/09 and 10/07/09. The repaired welds do not appear to have been re-tested at the time QA was present.

This QA observed that ZPMC Ultrasonic Testing (UT) technicians appear to have tested and accepted the following intermediate panel welds: CB202E-016-001, 002 and 003.

OBG BAY 2

This QA observed that ZPMC personnel appear to be re-stacking lift 12 floor beam components that were improperly stored. The re-stacking of this material appears to be in response to an incident report that this QA issued on 10/07/09 concerning improper storage of these components.

OBG BAY 5

This QA observed ZPMC personnel removing the backing bar splice welds inside of the bike path cantilever brackets utilizing the carbon arc gouging method. The cantilever brackets are identified as BK001-031, 032, 033, 034, 035 and 036.

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

WELDING INSPECTION REPORT

(Continued Page 4 of 4)



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:	Patterson,Rodney	QA Reviewer
