

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-002231**Date Inspected:** 12-May-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Chen Xi, Chen Chih-Ming, An 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:	Side, bottom and deck panels		

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 new assembly bay 2

QA observed ZPMC personnel installing the first floor beam (FB13A) in OBG SEG# 3BE/PP23. QA noted that there wasn't any welding being performed in this bay at the time QA was present. Other general observations include ZPMC personnel grinding side and bottom panels.

OBG new assembly bay 1

QA arrived at approximately 1600 hrs to perform Visual Testing (VT) of completed Partial Joint Penetration (PJP) welds joining U-Ribs to deck plates. QA noted that there were 18 deck panels ready for QA VT however, all of the panels were inaccessible.

OBG bay 1

QA observed ZPMC qualified welding personnel perform the SAW welds joining the closed U-Ribs to deck panels DP-549-002 and DP-554-001 on weld gantry 1. QA observed 2 ZPMC QC inspectors in the vicinity of the

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

welding operations including ZPMC CWI identified as Chen Xi. There were also 3 American Bridge/Fluor (ABF) inspectors in the area as well. QA noted that there appeared to be four deck panels ready for QA VT however, all of the panels were inaccessible.

New Tower Bay 1

No welding being performed in this bay at the time QA was present.

New Tower Bay 2

QA observed ZPMC qualified welding personnel perform SAW on one side of the groove weld joining tower skin plates, weld# WSD1-SA107B/T-17B and WSD1-SA107B/T-16B following the guide lines of approved WPS# WPS-B-T-2221-B-U3c-S and WPS-B-T-2221-B-U3c-S-1. QA observed 3 ZPMC Quality Control (QC) inspectors in the vicinity of the welding operations including ZPMC CWI identified as An Qingxiang. There was also 1 American Bridge/Fluor (ABF) QC inspector in the area as well. QC monitored the welding process continuously throughout the evening. The welding parameters as measured with Quality Controls calibrated instruments appeared to be in conformance with the posted WPS's and were as follows:

WSD1-SA107B/T-17B SAW

Volts: 32.6 Amps: 636 Travel speed: 611mm/min

WSD1-SA107B/T-16B SAW

Volts: 32.6 Amps: 650 Travel speed: 595mm/min

Other general observations in the New Tower bays include ZPMC tack welding tower skin plates, weld bevel preparation, flame straightening, CNC parts cutting and grinding.



Summary of Conversations:

as noted 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 Patrick Lowry (858)-344-2712, who represents the Office of Structural Materials

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

for your project.

Inspected By:	Hall,Steven	Quality Assurance Inspector
----------------------	-------------	-----------------------------

Reviewed By:	Cuellar,Robert	QA Reviewer
---------------------	----------------	-------------