

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-002765**Date Inspected:** 01-Jun-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

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|------------------------------------|-------------------------------|-----------|------------|----------------------------------|------------|-----------|------------|
| CWI Name: | Chen Chih-Ming / An Qingxiang | | | 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 side and bottom panels and tower skin p**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 performed 10% verification Magnetic particle Testing (MT) on the following side and bottom panel joints: SEG-13A-004 and SEG-19A-004. Both welds appeared to be compliant with AWS D1.5 2002 and the contract documents.

QA performed 10% verification Ultrasonic Testing (UT) on side panel joint SEG-019A-022. This weld appeared to be compliant with AWS D1.5 2002 and the contract documents.

QA observed ZPMC personnel installing floor beam in the OBG fixture section FL2-1 and FL2-2 at PP-021 segment 3A east (SEG 14).

QA observed ZPMC qualified welding personnel perform FCAW root pass on SP-032 to BP-0024 joint# SEG-020A-031 following the guide lines of WPS# WPS-B-T-223(2)-1T. 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:

Volts: 28.5 Amps: 290 Travel speed: 203mm/min

Other general observations include ZPMC personnel grinding side and bottom panels and weld bevel prep.

WELDING INSPECTION REPORT

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New Tower Bay 1

QA observed ZPMC qualified welding personnel perform FCAW welding on skin plate joint# SSD1-SA159D/J-27A following the guide lines of approved WPS# WPS-B-T-2231-B-U3-F and. 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:

Volts: 29.8 Amps: 305 Travel speed: 305mm/min



Summary of Conversations:

Only general conversations were 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 Patrick Lowry (858)-344-2712, who represents the Office of Structural Materials for your project.

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| Inspected By: | Hall,Steven | Quality Assurance Inspector |
| Reviewed By: | Cuellar,Robert | QA Reviewer |
