

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-002867**Date Inspected:** 10-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**CWI Name:** Chen Chih-Ming / 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 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 fitting floor beam FL1 south at panel point PP-021 OBG segment 3AE.

QA observed ZPMC qualified welding personnel tack welding side panel weld joint SEG-024A-004 BP-057 to BP-165.

QA observed ZPMC qualified welding personnel tack welding deck panels DP-016-001 to DP-014-001.

QA observed ZPMC qualified welding personnel preparing joint# SEG-013-031 SP-025 to BP-001 for fit up.

QA observed ZPMC qualified welding personnel perform SAW on SEG-024-002 SP-359 to SP-332 following the guide lines of WPS# WPS-B-T-2221-B-L2c-S-1. 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: 31.5 Amps: 530 Travel speed: 450mm/min

QA observed ZPMC qualified welding personnel perform 4G SMAW on SEG-017A-008 following the guide lines of WPS# WPS-B-T-2214-B-U2. QC monitored the welding process continuously throughout the evening.

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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: 23 Amps: 157 Travel speed: 85mm/min

QA observed ZPMC qualified welding personnel perform 4G SMAW on SEG-017A-007 following the guide lines of WPS# WPS-B-T-2214-B-U2. 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: 23.2 Amps: 149 Travel speed: 82mm/min

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

OBG Bay 1

QA observed ZPMC qualified welding personnel FCAW U-Rib diaphragms in U-Ribs U126 and U46.

QA observed ZPMC personnel fitting U-Ribs to deck plate DP-596-001.

QA observed ZPMC personnel setting PMT panels on gantry 1.

Other general observations by QA were as follows:

QA observed ZPMC has approximately 45 workers performing various functions relative to the fabrication of the OBG Deck Panels. These functions include; closed rib press forming, hole drilling at ends of U-Ribs using a drill template, PJP bevel preparation, closed rib splice FCAW welding, closed rib diaphragm fit-up and FCAW welding, closed rib to deck plate fit-up and tack welding.



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

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for your project.

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