

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-002962**Date Inspected:** 18-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 and bottom 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 qualified welding personnel perform FCAW 3G welding on section 4BE floorbeam splice FL2-1 to FL1 south joint # SSD18-PP028-014 following the guide lines of WPS# WPS-B-P-2233-B-U2-F. 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: 24.6 Amps: 215 Travel speed: 110mm/min

Welder ID: 067079

QA observed ZPMC qualified welding personnel perform SAW on SEG-026A-001 SP-564 to SP-524 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:

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Volts: 30.4 Amps: 534 Travel speed: 505mm/min

QA observed ZPMC qualified welding personnel perform SAW on SEG-021A-001 SP-118 to SP-145 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: 30 Amps: 530 Travel speed: 660mm/min

Welder ID: 0201215

QA observed ZPMC QC Ultrasonic Testing (UT) technicians perform R1 repair UT on the following weld joints: section 3AE weld SEG-14A-031, section 4AE weld SEG-018A-008 and 007. All 3 welds were rejected by ZPMC technicians.

QA observed ZPMC personnel fitting floor beam FL1 south to FL2-1 & FL2-2 in OBG section 3AW @ PP-021.

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



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.

Inspected By: Hall, Steven Quality Assurance Inspector

Reviewed By: Cuellar, Robert QA Reviewer
