

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-003144**Date Inspected:** 28-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/Zhao Chen Sun/Hui Ping Pang/Chen X			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, deck panels, floor beams a**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 floor beam @ PP-021 joint# SSD11A-PP021-130 and joint# SSD11A-PP021-013 following the guide lines of WPS# WPS-B-T-2233-B-U2-F. QC monitored the welding process continuously throughout the evening. The welder ID and welding parameters as measured with Quality Controls calibrated instruments appeared to be in conformance with the posted WPS's and were as follows:

Volts: 24.8 – 25.9 Amps: 211 - 215 Travel speed: 109 - 114mm/min

Welder ID's: (weld 130) 066012 (weld 013) 051348

QA observed ZPMC qualified welding personnel perform FCAW welding on floor beam @ PP-021 joint# SEG-14A-015-016 OBG segment 3AE following the guide lines of WPS# WPS-B-T-2233-B-U4b-F. QC monitored the welding process continuously throughout the evening. The welder ID and welding parameters as measured with Quality Controls calibrated instruments appeared to be in conformance with the posted WPS's and were as follows:

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Volts: 25 Amps: 215 Travel speed: 118mm/min
Welder ID: 064795

QA observed ZPMC personnel flame straightening side panel for girder 5BE joint SEG-024A-002 following the guide lines of approved standard flame straightening procedure defined in ZPMC WQCP section 11 and recorded on heat straightening report# HSR1 (B)-1329. According to the report the distortion appeared to be caused by the welding process.

Other general observations include ZPMC personnel fitting and welding OBG temporary support columns, grinding and weld bevel prep on various OBG components.

OBG bay 1

QA observed ZPMC qualified welding personnel welding the final SAW pass on DP-222-001 on gantry 1. QA also noted that the welding on DP-617-001 has been completed.

OBG bay 2

QA noted that there was no Caltrans work being performed in this bay on this day.

OBG bay 3

QA noted that there was no welding being performed in this bay on this day. QA observed ZPMC personnel preparing parts for fit up and welding; (cutting parts, drilling and weld bevel prep.

OBG bay 7

QA observed ZPMC personnel fit and SMAW tack welding stiffeners to floor beam web identified as FB-028-002 and FB-025-002.

QA observed ZPMC qualified welding personnel FCAW fillet welds on the following stiffener to floor beam web plate joints: FB-011-001-018, FB-010-004-043 and FB-010-009-001.

OBG bay 8

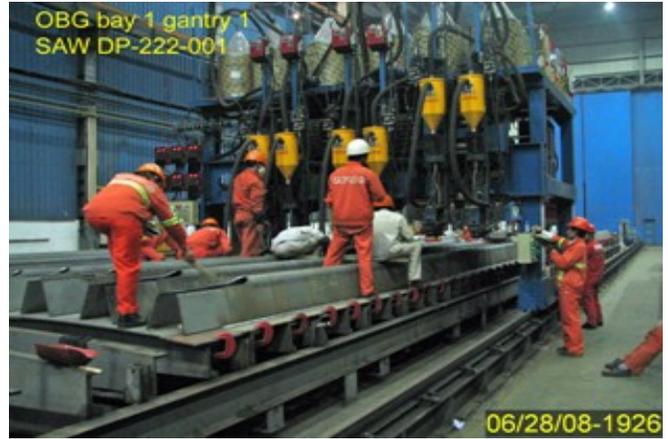
QA observed ZPMC personnel fit and SMAW tack welding stiffeners to floor beam web identified as FB-045-002.

QA noted ZPMC was welding and back gouging two tower diaphragm practice plates.

No welding operations were observed in this bay today.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



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
