

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-003369**Date Inspected:** 28-Jul-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**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 flame straightening EP-004A by blocking up one end of the plate and applying mechanical force and heat. The use of blocks is not referenced in the approved heat straightening procedure in ZPMC's WQCP section 11. An incident report has been generated concerning this discrepancy. See attached photos.

QA observed ZPMC qualified welding personnel FCAW R1 UT repair on SEG-018B-002 following the guide lines of WPS-345-FCAW-1G (1F)-repair-1. QC monitored the weld repair process continuously until complete. 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: 29 Amps: 280 Travel speed: 495mm/min

Welder ID: 058551

QA observed ZPMC qualified welding personnel SAW on SEG-017-006 following the guide lines of WPS-B-T-2221-B-L2c-S-2. QC monitored the welding process continuously through out the evening. The welder

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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:

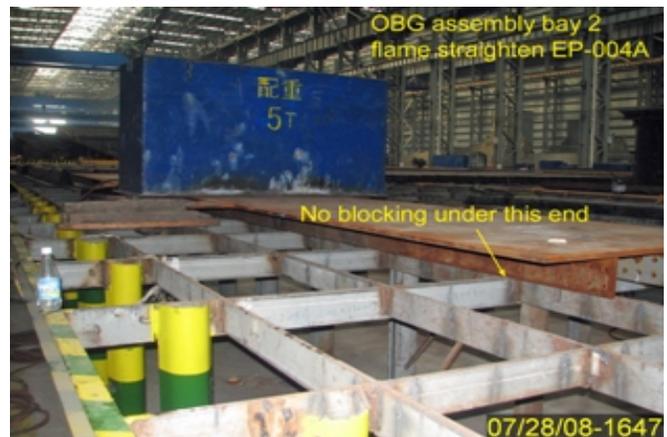
Volts: 35.2 Amps: 574 Travel speed: 512mm/min
Welder ID: 045265

QA observed ZPMC qualified welding personnel SMAW on SP-038-001-070, 069, 068, 067 and 066 following the guide lines of WPS-B-P-2213-Tc-U4b-FCM. QC monitored the welding process continuously through out 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: 24.4 – 25.1 Amps: 188 - 210 Travel speed: 102 - 105mm/min
Welder ID: 037997

QA observed ZPMC personnel fitting diaphragms in the 3rd corner assembly identified as CA-8A for OBG.

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



Summary of Conversations:

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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 Ryan Smith, (858) 232-6799, who represents the Office of Structural Materials for your project.

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