

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-003386**Date Inspected:** 30-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/Li Jia**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 and tower**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 bay 7

QA performed 10% verification Magnetic particle Testing (MT) on the following floor beam fillet welds: FB-003-025-002 thru 005, 011 thru 018, 023 thru 030, 035 thru 042 and 047 thru 102 // FB-003-045-002 thru 005, 011 thru 018, 023 thru 030, 035 thru 042 and 047 thru 102. All welds that were examined appeared to comply with AWS D1.5 2002 and the contract documents.

OBG new assembly bay 2

QA observed ZPMC qualified welding personnel SAW SEG-022A-004 following the guide lines of WPS-B-T-2221-B-U2-L2c-S-2. 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: 30.2 Amps: 572 Travel Speed: 512

Welder ID: 048296

QA observed ZPMC personnel fitting floor beam @ PP-036 OBG section 5CE/D6.

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QA observed ZPMC QC Ultrasonic Testing (UT) technicians UT the following CJP welds on OBG section 5CE/D6: SEG-026A-007 (SP-604 to BP-166) and SEG-026A-008 (SP-360 to BP-112). Neither weld was UT'ed completely by ZPMC on this day.

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:

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
