

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-003550**Date Inspected:** 20-Aug-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 performed 10% verification MT on the following side and bottom panel T-rib to panel fillet welds: SP563A, SP523A, SP603A, SP421A, SP420A, SP522A, SP522B, SP602B, SP748A, SP510A & SP510B. All welds tested appeared to conform to the quality requirements of AWS D1.5 2002 and the contract documents.

QA observed ZPMC personnel fitting north side floor beam section to center floor beam section @ PP-033 on OBG section 5BE. This operation was still in process when QA departed the area.

QA observed ZPMC personnel fitting longitudinal shear plate identified as LD-001 @ PP-036 on the north side of OBG section 5CE. This operation was still in process when QA departed the area.

QA observed ZPMC qualified welding personnel build-up by welding (buttering) one edge of floor beam FB 14B @ PP-027 OBG section 4BE in order to close up an excessive root opening of 14mm at the weld joint between the north side floor beam section and the center floor beam section. The welder followed the guide lines of WPS-B-T-2233-B-U2c-F-1. ZPMC CWI identified as Mr. Chen Chih Ming as well as one ABF inspector were on hand to monitor the process. QC recorded the parameters on weld repair report# B-WR779. 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:

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Volts: 24.5 Amps: 208 Travel speed: 108mm/min

Welder ID: 058551

QA observed ZPMC qualified welding personnel perform FCAW on the root pass of joint SEG-020-002 joining deck panels DP-042 and DP-080 following the guide lines of WPS-B-T-2231-B-U2-F-1. 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: 28.3 Amps: 280 Travel speed: 480mm/min

Welder ID: 055491

QA observed ZPMC personnel preparing to splice deck panels DP-077A to DP-078A joint # SEG-020-004.

QA observed ZPMC qualified welding personnel SAW SEG-013-005 joining DP-052A to DP-002A 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 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 Amps: 580 Travel speed: 480mm/min

Welder ID: 065265

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



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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
