

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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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-005124**Date Inspected:** 03-Jan-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Fu You Saen**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 Assembly**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector was present during the times noted above for observations relative to the work being performed.

Segment Repair Yard (North of Bay 14)

Segment 5BW

This QA Inspector observed ZPMC welding personnel #067829 performing Shielded Metal Arc Welding (SMAW) of Complete Joint Penetration (CJP) weld joints in the 4G position, on the floor beam flange weld# FB011-006-133. In process SMAW appears to be progressing in compliance with approved contract documents.

This QA Inspector observed ZPMC welding personnel #066258 performing Shielded Metal Arc Welding (SMAW) of Complete Joint Penetration (CJP) weld joints in the 4G position, on the floor beam flange splice weld at panel point 32. In process SMAW appears to be progressing in compliance with approved contract documents.

Segment 5AW

This QA Inspector observed ZPMC welding personnel #047866 performing Shielded Metal Arc Welding (SMAW) of Complete Joint Penetration (CJP) weld joints in the 3G position, on the longitudinal diaphragm weld# LD015-011. In process SMAW appears to be progressing in compliance with approved contract documents.

Segment 4BW

This QA Inspector observed that there was no work being done on this segment.

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Segment Repair Yard (North of the Paint Shop)

Segment 5AE

This QA Inspector observed ZPMC welding personnel #200432, performing Shielded Metal Arc Welding (SMAW) of Complete Joint Penetration (CJP) weld joints in the 1G position, on the longitudinal truss bracket to side panel weld# CA018-010. In process SMAW appears to be progressing in compliance with approved contract documents.

This QA Inspector observed ZPMC welding personnel #067765 and #04472 performing Shielded Metal Arc Welding (SMAW) of Complete Joint Penetration (CJP) weld joints previously rejected by UT, in the 4G position, on the deck panel to corner assembly splice welds. In process SMAW appears to be progressing in compliance with approved contract documents.

This QA Inspector observed ZPMC personnel grit blasting the floor beam web plating in way of the bolt holes for the lug plates that were removed.

This QA inspector also observed ZPMC personnel removing the diagonal truss bolts at all panel points to prepare for coating.

Segment 3AW

This QA Inspector observed ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) repair welds of areas previously rejected by UT at repair 3, on the lifting lugs attached to the TL2-2 floor beam web at panel point 22 without an approved CWR. See incident report.

This QA Inspector observed ZPMC welding personnel performing air carbon arc weld excavation of CJP welds of areas previously rejected by UT on the edge plate# EP5A to deck plate# DP11A without an approved CWR. See incident report.

This QA Inspector observed ZPMC welding personnel #037723 performing Shielded Metal Arc Welding (SMAW) of Complete Joint Penetration (CJP) weld joints previously rejected by UT, in the 4G position, on the bottom panel to edge plate weld#CA001-003. In process SMAW appears to be progressing in compliance with approved contract documents.

This QA Inspector observed ZPMC welding personnel #045280 performing Shielded Metal Arc Welding (SMAW) of Complete Joint Penetration (CJP) weld joints previously rejected by UT, in the 4G position, on the bottom panel splice weld#SEG13A-032. In process SMAW appears to be progressing in compliance with approved contract documents.

This QA inspector also observed ZPMC personnel removing the diagonal truss bolts at all panel points to prepare for coating.

Segment 3BW

This QA Inspector observed that there was no work being done on this segment.

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Segment Repair Yard (South of the Paint Shop)

Segment 4AW

This QA Inspector observed that there was no work being done on this segment.

Unless otherwise noted, all work observed on this date appeared to generally comply with the applicable contract documents.

Summary of Conversations:

No relevant conversations.

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 Eric Tsang, (+86) 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Patterson,Rodney	Quality Assurance Inspector
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Reviewed By:	Clifford,William	QA Reviewer
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