

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-005173**Date Inspected:** 11-Jan-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Shen Fuyou**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:** cross braces and OBG segments**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 assembly bay 19

QA observed no activities in this bay at the time QA was present.

OBG outside assembly (OBG segment 3BW)

QA observed ZPMC personnel fitting small section of flange on bottom section of floor beam identified as FB4A @ PP023.

QA observed ZPMC personnel removing cross braces @ PP023 in preparation for blast and painting of the faying surfaces between gussets and brace.

QA observed ZPMC welding personnel preparing to perform weld repairs on Complete Joint Penetration (CJP) weld identified on the material as SEG015A-009. This QA reviewed the approved Critical Weld Repair (CWR) procedure provided to QA by ZPMC QC CWI identified as Mr. Shen Fuyou and determined that the procedure was unacceptable due to the fact that the weld joint is in the over head (4G) position and the procedure indicated that the joint to be in the horizontal (2G) position. The WPS that was referenced on the CWR also indicated the joint be welded in the 2G position. ZPMC QC CWI identified as Mr. Shen Fuyou informed this QA that he would

WELDING INSPECTION REPORT

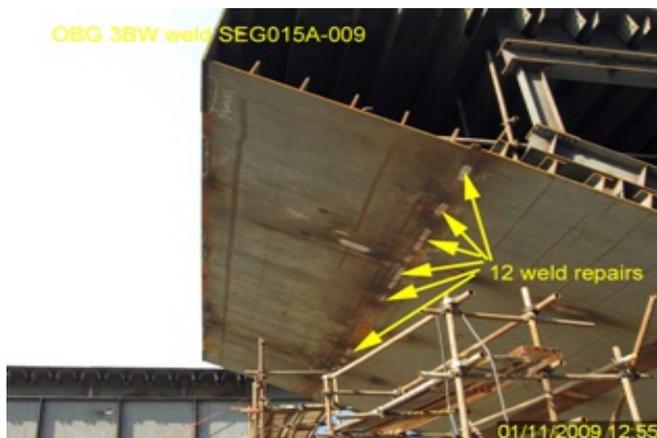
(Continued Page 2 of 2)

not allow the welders to commence welding the excavated areas on this joint until the procedure was revised and approved by the engineer. QA observed ZPMC welding personnel remove the welding equipment from this area.

QA observed ZPMC welding personnel perform weld repairs on CJP weld joints SEG015*-013, SEG015A-010 and CA005-003. This QA requested to review the WPS's applicable to these joints. ZPMC QC CWI identified as Mr. Shen Fuyou was unable to provide the documents. This QA informed Mr. Fuyou that the lack of WPS's in the vicinity of the welding for both the welding personnel and the inspectors to review was in violation of AWS D1.5 2002 section 6.3.1 and that an incident report would be issued for this non-conformance.

OBG outside assembly (OBG segment 5BW)

QA observed ZPMC welding personnel perform weld repairs on CJP weld joint SEG023*-001. This QA requested to review the WPS's applicable to these joints. ZPMC QC identified as Mr. Wu Zhigao was unable to provide the documents. This QA informed Mr. Zhigao that the lack of WPS's in the vicinity of the welding for both the welding personnel and the inspectors to review was in violation of AWS D1.5 2002 section 6.3.1 and that an incident report would be issued for this non-conformance.



Summary of Conversations:

As mentioned above.

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, 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Hall,Steven	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
