

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-005176**Date Inspected:** 14-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

This QA observed ZPMC personnel tack welding cross beam diaphragm sub assembly identified on the material as mark# FB209A.

This QA noted that ZPMC has what appears to be tower base plates in this bay according to markings on the material. No other markings were visible on the material.

OBG outside assembly (OBG segment 3BW)

This QA observed ZPMC qualified welding personnel identified as Mr. Ni Lei Jiang (037723) performing SMAW weld repairs on Complete Joint Penetration (CJP) weld identified on the material as SEG015A-010. QC identified as Mr. Wang Wei Ming was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-4G (4F)-repair (FCM).

OBG outside assembly (OBG segment 4BW)

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This QA observed ZPMC qualified welding personnel identified as Mr. Bai Jin Hu (067756) and Mr. Zang Wei (066413) perform SMAW welding on weld joints identified as SSD11A-PP027-217 and SSD12A-PP028-011. ZPMC QC identified Mr. Wang Tai was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2214-B-U2-FCM.

OBG outside assembly (OBG segment 5BW)

This QA observed ZPMC qualified welding personnel identified as Mr. Li Zai Jun (037996) performing SMAW welding on Complete Joint Penetration (PJP) weld identified on the material as SEG023A-035. QC identified as Mr. Wu Shigai was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-4G (4F)-repair (FCM).

OBG outside assembly (OBG segment 5AW)

This QA observed ZPMC qualified welding personnel identified as Mr. Li Zai Jun (037996) performing SMAW weld repairs on Complete Joint Penetration (PJP) weld identified on the material as SEG021A-001. QC identified as Mr. Wu Shigai was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-4G (4F)-repair (FCM).

OBG outside assembly (OBG segment 5CW)

This QA observed ZPMC qualified welding personnel identified as Mr. Chen Hong Jun (067609) performing SMAW welding on Complete Joint Penetration (PJP) weld identified on the material as SEG025A-007. QC identified as Mr. Wang Tai was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2214-B-U2-FCM.

This QA observed ZPMC personnel removing temporary fixtures from the outside of this segment using the arc gouging method and grinding.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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Summary of Conversations:

Only general conversation was 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 Eric Tsang, 15000422372, who represents the Office of Structural Materials for your project.

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