

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-005411**Date Inspected:** 19-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:** Zhong Bao Lei**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 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

No Caltrans work being performed in this bay at the time this QA was present.

OBG outside assembly (OBG segment 4BW)

This QA observed ZPMC qualified welding personnel identified as Mr. Feng Hua Jun (066258) perform SMAW welding on weld joint identified as SEG019E-064. ZPMC QC identified Mr. Zhang Xiao 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-B-P-2213-TC-U4b-FCM.

This QA observed ZPMC qualified welding personnel identified as Mr. Feng Hua Jun (066258) perform SMAW Critical Weld Repairs (CWR) on weld joints identified as SEG019E-079, 088, 097, 038, 133 and 151 and SEG019D-051. ZPMC QC identified Mr. Zhang Xiao 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 CRW# B-CWR265 and WPS-345+485-SMAW-3G(3F)-FCM-repair-1.

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OBG outside assembly (OBG segment 5BW)

No Caltrans work being performed on this segment at the time this QA was present.

OBG outside assembly (OBG segment 5AW)

No Caltrans work being performed in this bay at the time this QA was present.

OBG outside assembly (OBG segment 5CW)

This QA observed ZPMC qualified welding personnel identified as Mr. He Jun Rong (201215) perform FCAW welding on weld joint identified as SS14A-PP035-128. ZPMC QC identified 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-B-T-2231-Tc-U4b-F.

This QA observed ZPMC qualified welding personnel identified as Mr. Feng Chang Dou perform SMAW welding on weld joints identified as SEG025B-027 & 028. ZPMC QC identified 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-B-P-2111 and WPS-B-P-2114.

OBG outside assembly (OBG segment 3AW)

This QA observed ZPMC qualified welding personnel identified as Mr. Yun Chengxian (045138) perform SMAW welding on weld joint identified as SS10A-PP022-256. ZPMC QC identified Mr. Yang Ding 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-2G (2F)-FCM-repair.

This QA observed ZPMC qualified welding personnel identified as Mr. Wang Chang Ming (067864) perform SMAW welding the rat hole on weld joint identified as SSD10-PP020-127. ZPMC QC identified Mr. Yang Ding was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with ZPMC repair procedure# B-CW1996 and WPS-B-P-2211-TC-u5b.

OBG outside assembly (OBG segment 3BW)

QA observed ZPMC personnel tack welding angle braces to the top side of the T stiffeners on the side and bottom panels.

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
Reviewed By:	Carreon,Albert	QA Reviewer
