

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-005414**Date Inspected:** 21-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 Fu You**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 and crossbeams**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 flame straightening tower base plates. ZPMC QC was observed by this QA monitoring the process. The procedure appeared to be in general compliance with AWS D1.5 2002 and the contractors WQCP section 11.

This QA also took an inventory of the fabricated components to date for the OBG crossbeams. This list was compiled for QA information only and has not been included in any permanent QA record.

OBG outside assembly (OBG segment 3BW)

This QA assisted Caltrans QA inspector Mr. Rodney Paterson perform Visual weld inspection (VT) after ZPMC QC inspectors completed their VT on the deck panel to diaphragm welds at PP023. This QA discovered numerous noncompliant base metal and weld discontinuities not marked for repair by the contractors QC. After the inspection was completed, ZPMC personnel appeared to commence repairing the areas marked by QC as well as QA. A verification inspection by Caltrans QA will be done after ZPMC QC have inspected and accepted the repairs.

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OBG outside assembly (OBG segment 3AW)

This QA observed ZPMC qualified welding personnel identified as Mr. Wang Chang Ming (047864) perform SMAW Critical Weld Repair (CWR) on weld joint identified as SEG013A-010. ZPMC QC identified as Mr. Geng Wei was present to monitor the weld repair process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with CWR #B-CWR238 rev. 1 and WPS-345-SMAW-4G (4F)-FCM-repair as referenced on the CWR.

This QA observed ZPMC qualified welding personnel identified as Mr. Feng Hua Jun (066258) perform SMAW Critical Weld Repair (CWR) on weld joint identified as SEG013A-016. ZPMC QC identified as Mr. Geng Wei was present to monitor the weld repair process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with CWR #B-CWR243 and WPS-345-SMAW-4G (4F)-FCM-repair as referenced on the CWR.

This QA observed ZPMC qualified welding personnel identified as Mr. Ni Lei Jiang (037723) perform SMAW Critical Weld Repair (CWR) on weld joint identified as SEG013A-026. ZPMC QC identified as Mr. Geng Wei was present to monitor the weld repair process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with CWR #B-CWR242 and WPS-345-SMAW-4G (4F)-FCM-repair as referenced on the CWR.

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



Summary of Conversations:

only general conversation was held between QA and QC concerning this project.

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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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