

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-005415**Date Inspected:** 22-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:** Shi 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 outside assembly (OBG segment 3AW)

This QA observed ZPMC qualified welding personnel identified as Mr. Ni Lei Jiang (037723) perform SMAW Weld Repair on weld joint identified as SSD12-PP022-232. ZPMC QC identified Mr. Yang Diang 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 weld repair report #B-WR1970 and WPS-345-SMAW-4G-(4F)-FCM-repair as referenced on the repair report.

This QA observed ZPMC qualified welding personnel identified as Mr. Yun Chengxian (045138) perform SMAW Weld Repair on weld joint identified as CA001-054. ZPMC QC identified Mr. Yang Diang 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 WPS-B-T-4113-2.

This QA observed ZPMC qualified welding personnel identified as Mr. Lua Xuanping perform SMAW 4 Weld Repairs on weld joint identified as SEG-013A-032. ZPMC QC identified Mr. Yang Diang was present to monitor the weld repair process. The welding parameters as measured using QC's calibrated instruments appeared to be in

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

general compliance with WPS-345-SMAW-4G-(4F)-FCM-repair.

This QA observed ZPMC qualified welding personnel identified as Mr. Li Bo (005043) perform SMAW Welding on weld joints identified as SSD21-PP019.5-001 thru 122. ZPMC QC identified Mr. Yang Diang 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 WPS-B-T-4113-2.

This QA observed ZPMC and ABF personnel perform the daily stud welding test for the above mentioned OBG segment. The test performed appeared to be in compliance with AWS D1.5 2002 and the contract documents. After the completion of the test QA observed ZPMC welding personnel commence welding the studs on the applicable edge plate on this segment.

OBG outside assembly (OBG segment 5CW)

This QA observed ZPMC qualified welding personnel identified as Mr. Feng Hua Jun (066258) perform SMAW weld repair on weld joint identified as SEG-025-030. ZPMC QC identified Mr. Wang Wei Ming 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 WPS-345-SMAW-4G-(4F)-FCM-repair.

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



Summary of Conversations:

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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
