

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-005418**Date Inspected:** 27-Jan-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Sha Zhi**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 3AE)

This QA observed ZPMC qualified welding personnel identified as Mr. Hao Jian Xiang (067665) perform SMAW weld repair on weld joint identified as SEG-014*-031. ZPMC QC identified Mr. Wu Shi Gao 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)-repair.

This QA observed ZPMC qualified welding personnel identified as Mr. Fang Xinyou (0037748) perform SMAW weld repair on weld joint identified as SEG-014A-041. ZPMC QC identified Mr. Wu Shi Gao 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.

OBG outside assembly (OBG segment 3AW)

This QA observed ZPMC qualified welding personnel identified as Mr. Feng Changhou (067572) perform SMAW welding on weld joints identified as SSD11A-204 thru 216. ZPMC QC identified Mr. Yang Ding was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments

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appeared to be in general compliance with WPS-B-P-2114-7c-U5c-FCM.

This QA observed ZPMC QC Magnetic particle Testing (MT) technician testing the following corner assembly welds: CA001-008, 009, 012, 013,016 & 017, CA001A-008, 009, 012, 013, 016 & 017. According to QC all welds appeared to comply with the contract documents.

OBG outside assembly (OBG segment 4AW, 5CE, 3BE, 3BW and 4AE)

No significant work was observed on these segments while QA was present.

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.

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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