

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-005421**Date Inspected:** 29-Jan-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yan Hua**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 14

This QA observed ZPMC qualified welding personnel identified as Mr. Liu Zipei (062406) perform SAW welding on weld joint identified as SEG-006*-002. ZPMC QC identified as Mr. Wu Bin was present to monitor the weld process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-L2c-S-2.

This QA also noted various other tasks being performed by the contractor relative to the fabrication of the OBG segments including weld joint bevel preparation, hole drilling and grinding operations throughout the shop.

OBG assembly bay 13

This QA observed ZPMC qualified welding personnel identified as Mr. Fang Xin You (037748) perform SMAW weld repairs on weld joint identified as SEG-005A-004 on OBG segment identified as 1BW. ZPMC QC identified as Mr. Zhang Xian Ji 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.

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This QA observed ZPMC qualified welding personnel identified as Mr. Fang Xin You (037748) perform SMAW weld repairs on weld joint identified as SEG-005A-007 on OBG segment identified as 1BW. ZPMC QC identified as Mr. Zhang Xian Ji 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 QC inspector check and record joint root openings at fillet weld joints joining bottom panel stiffeners to floor beam clearance slots on several of the OBG segments in this bay (see photo).

This QA observed ZPMC personnel tack welding floor beam component identified as FB014-016 to FB022-003 and FB008-007 @ PP015 on OBG segment identified as 2AE.

This QA observed numerous floor beam components in this bay that have received damage due to the fact that the material has been miss handled and/or improperly stored (see attached photos). QA has informed ZPMC and ABF QA/QC of this discrepancy and that an incident report will be issued.

OBG outside assembly (OBG segment 3AE)

This QA observed ZPMC qualified welding personnel identified as Mr. Wang Li (044772) perform SMAW weld repair on weld joint identified as SSD17A-PP021_127. ZPMC QC identified as 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-B-T-2212-TC-U4c.

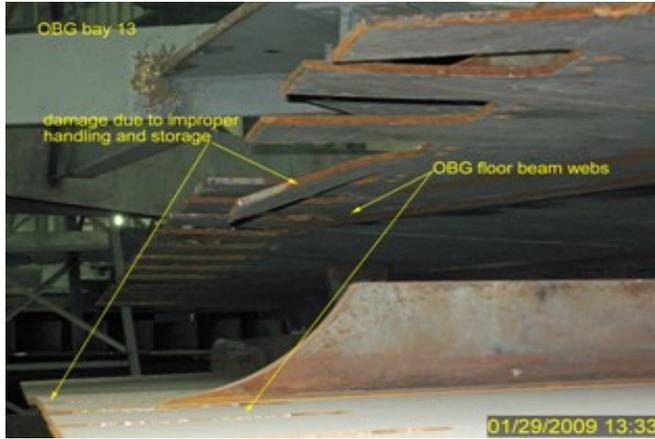
OBG outside assembly (OBG segments 4AW, 5CE,5BE, 4BE, 4AE and 3BE)

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.

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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
