

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-005435**Date Inspected:** 17-Feb-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:** Luan Zhao Gang**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. Bao Jin Hu (067756) perform SMAW welding on weld joint identified as SSD018-PP022-243. ZPMC QC identified as 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-2214-Tc-U5b.

This QA observed ZPMC qualified welding personnel identified as Mr. Li Yong Shui (067656) perform SMAW welding on weld joint identified as SSD018A-PP022-243. ZPMC QC identified as 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-2214-Tc-U5b.

This QA observed ZPMC personnel carbon air arc gouging areas of weld joint identified as SEG016A-010 that have been rejected by ZPMC QC Ultrasonic Testing (UT) technicians. According to ZPMC QC identified as Mr. Wang Wei Ming, these repairs have been classified as Critical Weld Repairs (CWR).

OBG outside assembly (OBG segment 4AE)

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This QA observed ZPMC qualified welding personnel identified as Mr. Jin Cheng Mao (058551) perform FCAW welding on weld joints identified as SSD029-PP24.5-133 and 166. ZPMC QC identified as 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-2133.

This QA observed ZPMC qualified welding personnel identified as Mr. Wu Wan Yong (050242) perform FCAW welding on weld joints identified as SSD029-PP25.5-133 and 166. ZPMC QC identified as 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-2133.

OBG outside assembly (OBG segment 4AW)

This QA received ZPMC Non Destructive Testing (NDT) notification No. 001998 and performed UT of approximately 10% lot testing of the welds previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA generated a UT report for this date. The weld designations are as follows: SSD013A-PP024-128,134 and 131. SSD14A-PP025-128 and 198. SSD013-PP024-132 and 138. SSD14-PP025-132 and 202. SEG017C-001 and 009. SEG017B-001 and 009.

OBG outside assembly (OBG segment 3BE)

No significant work was being performed on this segment 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:

As mentioned above.

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
