

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-005487**Date Inspected:** 18-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 assembly bay 13

This QA observed ZPMC personnel drilling bolt holes for tab plates identified as X3T on floor beam identified as FB047-001 at PP014.5 on OBG segment 2AW.

No other significant work was being performed in this bay while QA was present.

OBG assembly bay 14

This QA observed ZPMC qualified welding personnel identified as Miss Wang Lanying (045265) perform SAW welding on weld joints identified as SEG039A-014 and SEG027B-019 (side panel splices). ZPMC QC identified as Mr. Wu Bin 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-2221-B-L2c-S-2.

This QA observed ZPMC qualified welding personnel identified as Mr. Feng Changdou (067572) and Mr. Li Zaijun (037996) perform SMAW welding on weld joint identified as SEG027B-019. ZPMC QC identified as Mr. Li Ming Yong 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-P-2214-B-U2-FCM.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

This QA observed ZPMC qualified welding personnel identified as Miss Hong Yongli (044801) perform FCAW welding on weld joints identified as DP-586-001-156, 123, 105, 089, 079, 088 and 096. ZPMC QC identified as Mr. Li Ming Yang 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 and WPS-B-T-2233-Tc-U4b-F.

This QA observed ZPMC personnel fitting and tack welding floor beam sub assembly identified as FB004-028 in OBG segment 7CW. This floor beam is being fit at PP055.

OBG outside assembly (OBG segment 4AW)

This QA received ZPMC Non Destructive Testing (NDT) notification No. 002008 and performed R1 repair UT on two welds repaired by the contractor. ZPMC Quality Control (QC) personnel retested and accepted these welds. This QA generated a UT report for this date. The weld designations are as follows: SSD14A-PP025-256 and SEG017A-009.

This QA along with Caltrans QA Mr. Rodney Paterson performed final Visual Testing (VT) prior to sand blasting of the segment welds after ZPMC QC and ABF QA completed their final VT. This QA inspector marked approximately twenty areas for repair. ZPMC personnel performed the repairs and this QA re inspected the repaired areas. The repaired areas appeared to comply with the contract documents.

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



WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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 Patrick Lowry (858)-344-2712, who represents the Office of Structural Materials for your project.

Inspected By:	Hall,Steven	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
