

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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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-005690**Date Inspected:** 09-Mar-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

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|------------------------------------|-----------------------------|-----------|------------|----------------------------------|--------------|-----------|------------|
| CWI Name: | Shen Fuyou / Chen Chih-Ming | | | 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 qualified welding personnel identified as Mr. Zhou Jibo (051356) perform FCAW welding on weld joint identified as S EG006-PP12.5-001 and 012. ZPMC QC identified as Mr. Zhang Xian Ji 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-2233-B-U2-F.

This QA observed ZPMC qualified welding personnel identified as Mr. Han Kun (066751) perform SMAW welding on weld joint identified as SEG006-PP12.5-041. ZPMC QC identified as Mr. Zhang Xian Ji 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-2213-B-U2-FCM.

This QA observed ZPMC qualified welding personnel identified as Mr. Liu Hengli (068048) perform FCAW welding on weld joint identified as SSD44A-PP10.5-062. ZPMC QC identified as Mr. Guo Wei 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 received ZPMC Non Destructive Testing (NDT) notification No. 002198 and performed Ultrasonic Testing (UT) of approximately 10% of the welds previously tested and accepted by ZPMC Quality Control (QC)

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personnel. This QA generated a UT report for this date. The weld designations are as follows: SEG009*-001 and 002.

OBG assembly bay 14

This QA received ZPMC Non Destructive Testing (NDT) notification No. 002198 to perform Ultrasonic Testing (UT) of approximately 10% of the welds previously tested by ZPMC Quality Control (QC) personnel. This QA noted ZPMC UT technicians have rejected the following welds: SEG005*-005 and 006 and SEG031B-031.

This QA performed Ultrasonic Testing (UT) of approximately 10% 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: SEG005*-003 and 004. QA did not receive NDT notification for these welds.

OBG assembly bay 19

This QA observed ZPMC personnel have commenced assembling cross beam identified as CB3. QA noted that the contractor has only fit two of the temporary shipping diaphragms to the deck panel at this time. see attached photos.

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 Patrick Lowry (858)-344-2712, 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