DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-005707
Date Inspected: 01-Mar-2009

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 645
OSM Departure Time: 1645
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

Summary of Items Observed:

On this day Caltrans OSM Quality Assurance (QA) Inspector Erik Prue 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 Inspector observed and/or found the following:

Bay 14: QA Inspector randomly observed ZPMC qualified welder ID #049339 repair welding lifting lugs segment 3AE SSD18A PP 022-222. Welder was observed welding in the 4G (horizontal) position utilizing the Shielded Metal Arc Welding (SMAW) process. QA Inspector observed the ZPMC QC Inspector Geng Wei verifying welding parameters and pre-heat were in accordance with the Welding Procedure Specification (WPS). QA Inspector with QC Inspector observed parameters taken for welder # 049339 as follows: preheat temperature to be at 172°C and measured the welding parameters to be 180 amps, 25.2 volts, a travel speed of 120 mm/min. Welding parameters verified by QA Inspector appear to be in general compliance with the approved WPS-345-SMAW 4G-FCM-Rep and Weld Repair Report B-WR2508.

Tower Bay 12: QA inspector received notification from day shift task leader to perform conventional Ultrasonic (A scan) Inspection for tack welds on deck panels. The inspection is preliminary prior to using the phased array system to verify indications found with conventional Ultrasonic testing. QA inspector performed UT on deck panel DP114-002, 4 ribs, 8 welds, 144 total tack welds inspected. Weld 1 scanned 18 locations with no indications, weld 2 scanned 18 locations with 1 indication, weld 3 scanned 18 locations with 4 indications, and weld 4 scanned 18 locations with no indications. Welds 5 through 8 were scanned by QA UT Inspector Hiranch Patel, weld 5 scanned 18 locations with 1 indication, weld 6 scanned 18 locations with no indications, weld 7 scanned 18 locations with 1 indication, and weld 8 scanned 18 locations with no indications. All indication locations are

marked on top of u-ribs for PAUT investigation. Please see U-rib Deck Panel Tack Weld Assessment report dated 01 March, 2009 for specific locations of indications.

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

Summary of Conversations:

No significant conversations this day.

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:	Prue,Erik	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer