

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-005766**Date Inspected:** 15-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**CWI Name:** Shen Fuyou/Lu Li Qing**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 and Bike path**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 received ZPMC Non Destructive Testing (NDT) notification No. 002287 and 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: DP600-001-060 (lot testing covered welds 051, 069, 078 and 087).

This QA received ZPMC Non Destructive Testing (NDT) notification No. 002287 and performed 100% Final Visual Testing (FVT) for the U-rib to deck panel Partial Joint Penetration (PJP) welds on deck panels identified as DP555-001, DP570-001 and DP600-001. All welds tested appeared to be compliant with the contract documents.

This QA observed ZPMC qualified welding personnel identified as Miss Wang Lanying (045265) perform SAW welding on weld identified as SEG004*-004. ZPMC QC identified as Mr. Zhang Xiao 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-2221-B-L2c-S-2.

OBG assembly bay 19

WELDING INSPECTION REPORT

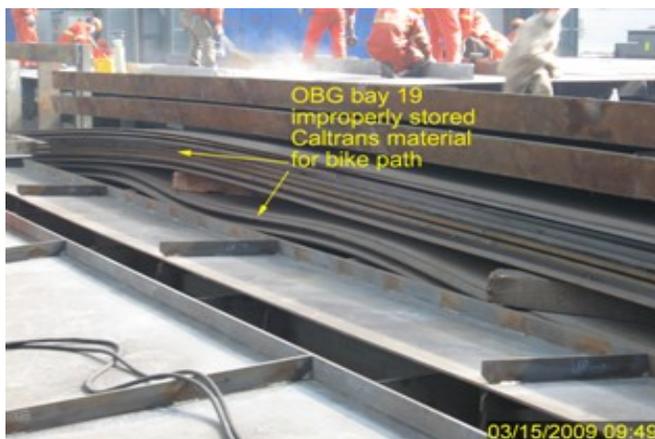
(Continued Page 2 of 3)

This QA observed ZPMC qualified welding personnel identified as Mr. Wang Shengrong (062378), Mr. Wang Yong (062807), Mr. Sun Zhaowen (062735) and Mr. Liu Dafu (062756) perform FCAW welding on bike path welds identified as BK6-14~17, 22, 23, 25, 26, 36, 37, 40~43, 51, 52, 56, 57, 62, 63, 66, 67, 76, 77, 82, 83, 91~94 and 96~98. ZPMC QC identified as Mr. Zhou Jie 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-2132-3.

This QA observed ZPMC qualified welding personnel identified as Mr. Xu Aihua (062816) perform SAW welding on weld identified as BP025A-004-002. ZPMC QC identified as Mr. Lu Li Qing 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 numerous cross beam and bike path components in this bay that appear to have received damage due to material miss handling and/or improper storage (see attached photos). QA has informed ZPMC QC identified as Mr. Shen Xuejun and ABF representative identified as Mr. Steve Lawton of this discrepancy and that an incident report will be issued.

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



Summary of Conversations:

As mentioned above.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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
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