

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-006201**Date Inspected:** 11-Apr-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: Yu Dong Ping
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: Yes No N/A
Verified Joint Fit-up: Yes No N/A
Approved WPS: Yes No N/A
Delayed / Cancelled: Yes No N/A

Bridge No: 34-0006**Component:** OBG segments and cross beams**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 058087 perform SMAW welding on weld joint identified as SEG-007-038 and 041. ZPMC QC identified as Mr. Wang Xu 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-4213-Tc-U4b-2.

This QA received ZPMC Non Destructive Testing (NDT) notification No. 002593 in order to finish Ultrasonic Testing (UT) performed on the previous shift on welds identified as FB059-002 welds 011, 021, 031, 036, 041 and 046, FB059-003 welds 011, 021, 031, 036, 041 and 046. The welds in question only required 25% UT by ZPMC. This criteria had been met when ZPMC UT lot testing of welds FB059-002 welds 016 and 026, FB059-003 welds 016 and 026 which are also listed on the above mentioned NDT notification. This QA noted that Caltrans QA had already performed the required 10% verification testing on these welds.

OBG assembly bay 19

This QA received ZPMC Non Destructive Testing (NDT) notification No. 002611 and performed Ultrasonic

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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: BP026-007-001, 002 and 003, BP026-008-001, 002 and 003.

No other significant work was being performed by the contractor in this bay during the time this QA was present.

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
Reviewed By:	Carreon,Albert	QA Reviewer
