

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-006202**Date Inspected:** 09-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:** Li Yung**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 segment assembly**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 outside assembly 4AW and 4BW

This QA observed ZPMC qualified welding personnel identified as 220064 and 220067 perform FCAW welding at the ends of the T-Ribs that were left unwelded in order to facilitate stiffener alignment at assembly. ZPMC QC identified as Mr. Zhang Hai Tao 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 QC Non-Destructive Testing (NDT) sub-contractor performing Ultrasonic Testing (UT) at the splice joint between 4AW and 4BW. QA observed that QC has completed the UT on the bottom panel splice and appears to have rejected 48 indications on this joint. QC has not completed UT of the side panels or the deck panel at this time.

OBG outside assembly 4BE, 3AE and 3BE

This QA observed ZPMC personnel fitting and tack welding the splice joint between 3AE and 3BE. The edge plates appear to be 100% fit, side panels approximately 75% complete, deck panel approximately 50% complete

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and the bottom panel 0% complete.

This QA observed ZPMC personnel welding stiffeners to the underside of deck panel on 3AE in the area of the cross beam where the deck plate cantilevers over the edge plate.

This QA observed ZPMC personnel moving segment 4BE into its position on the east bound segment assembly.

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
