

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-006395**Date Inspected:** 18-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:** Luan Zhuo Gang**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 outside assembly 3AE, 3BE, 4AE, 4BE and 5AE

This QA observed ZPMC qualified welding personnel identified as 066261 perform SMAW welding on weld joint identified as DP012-001 welds 023, 024 and 025 and DP022-001 welds 023, 024 and 025. ZPMC QC identified as Mr. Zhang Jing Xin 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-3213-B-U2b.

This QA observed ZPMC qualified welding personnel identified as 218976 perform FCAW welding on weld joint identified as BP010-001 welds 037~042. ZPMC QC identified as Mr. Zhang Jing Xin 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-2223-B-U2-F.

This QA observed ZPMC qualified welding personnel identified as 220067 perform FCAW welding on weld joint identified as OBE4A-003. ZPMC QC identified as Mr. Chen Bo 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-2231T.

This QA observed ZPMC qualified welding personnel identified as 048617 perform SMAW welding on weld joint identified as OBE4-005. ZPMC QC identified as Mr. Chen Bo was present to monitor the welding process.

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The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2214-B-U2-FCM.

This QA observed ZPMC qualified welding personnel identified as 220068 perform FCAW welding on weld joint identified as OBE4-001. ZPMC QC identified as Mr. Chen Bo 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-2233T.

This QA observed ZPMC qualified welding personnel identified as 053748 and 054458 perform SAW welding on weld joint identified as OBE4-003. ZPMC QC identified as Mr. Zhang Zheng Mao 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-L2a-S-3.

This QA observed ZPMC QC Non-Destructive Testing (NDT) sub-contractor performing Ultrasonic Testing (UT) at the bottom panel splice joint between 3AE and 3BE.

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
