

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-006396**Date Inspected:** 19-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 and crossbeam**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 3AW and 3BW

This QA received ZPMC Non Destructive Testing (NDT) notification No. 002706 and performed Ultrasonic Testing (UT) on welds identified as BP007-001-037~042, BP008-001-038~042, BP009-001-037~042, SP018-001-049 & 048, SP026-001-037, 038, 040 & 042, SP047-001-044 & 046, DP011-001-025, DP009-001-025, EP006-001-018, EP001-001-017, SP035-001-033 & 034, SP002-001-031 & 032, SP071-001-039 & 040 and SP059-001-038 & 039. All welds tested appeared to comply with AWS D1.5 2002 and the contract documents.

OBG outside assembly CB3

This QA observed ZPMC qualified welding personnel identified as 062738 and 062735 perform FCAW welding on weld joints identified as BP219-031~048. ZPMC QC identified as Mr. Xu 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-TC-U4c-F and WPS-B-T-2232-B-U2-F.

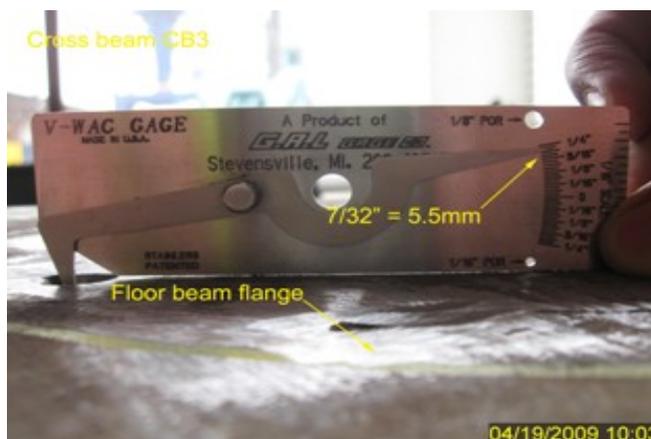
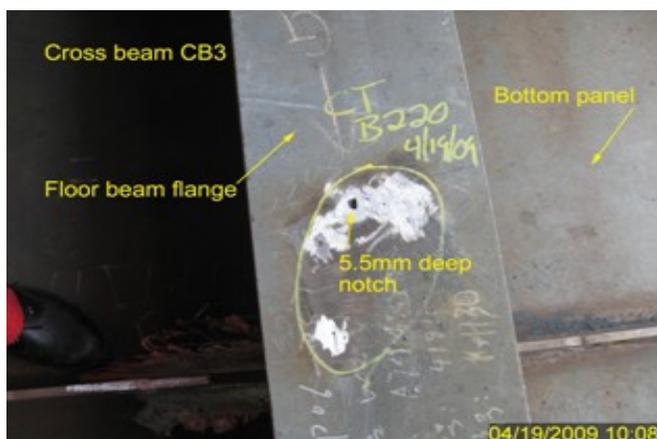
During random visual inspection of this crossbeam, this QA noted that the contractor was in the process of removing temporary bracing from the floor beams. The areas where the bracing was removed exhibited numerous

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nicks and notches in the surface of the base metal. At least one of the notches measured 5.5 mm in depth (see attached photo). This QA informed ZPMC QC identified as Mr. Xu Tao of these material surface discontinuities. Mr. Xu told this QA that ZPMC QC department would evaluate the condition of the surfaces in question and perform repairs as required per the contract documents.

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
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Reviewed By:	Carreon,Albert	QA Reviewer
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