

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-006435**Date Inspected:** 26-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:** Chen Xi / Li Yang**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:** crossbeams and superstructure 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 cross beam CB1

This QA observed ZPMC personnel perform clean up and grinding. No other significant work was observed on this cross beam during the time QA was present.

OBG cross beam CB2

No significant work was observed on this cross beam during the time QA was present.

OBG cross beam CB3

This QA observed ZPMC personnel perform clean up and grinding. QA observed ZPMC Non Destructive Testing (NDT) sub-contractor perform Magnetic particle Testing (MT) on bottom panel stiffener and floorbeam fillet welds. No other significant work was observed on this cross beam during the time QA was present.

OBG cross beam CB4

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This QA observed ZPMC personnel perform clean up and grinding. No other significant work was observed on this cross beam during the time QA was present.

OBG cross beam CB5

This QA observed ZPMC personnel perform clean up and grinding. No other significant work was observed on this cross beam during the time QA was present.

OBG cross beam CB6

This QA observed ZPMC qualified welding personnel identified as 215185 perform FCAW welding on weld joint identified as CB202G-010-145. ZPMC QC CWI identified as Mr. Li Yang 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-2232-3.

This QA observed ZPMC qualified welding personnel identified as 217185 perform FCAW welding on weld joint identified as CB202G-011-185. ZPMC QC CWI identified as Mr. Li Yang 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-2232-3.

OBG Superstructure Assembly East line

This QA observed ZPMC personnel perform various functions relative to the fabrication and assembly of the OBG superstructure assembly including the following: Install permanent bolts in OBG segment 2BE at the floorbeam diagonal bracing connections to the upper and lower floorbeam sections. Prepare ends of bottom panel T-stiffeners for splicing segment 2BE to 3AE. Install and match drill deck panel u-rib splice plates at 4AE to 4BE splice.

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



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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 Eric Tsang (15000422372), who represents the Office of Structural Materials for your project.

Inspected By:	Hall,Steven	Quality Assurance Inspector
Reviewed By:	Prue,Erik	QA Reviewer
