

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-006811**Date Inspected:** 16-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 Zhae 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:** Superstructure Assembly**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector Rory O'Kane was present during the times noted above for observations relative to the work being performed.

Outside Assembly Area

This QA Inspector observed ZPMC bolting personnel perform structural bolting in accordance with turn-of-the-nut bolting procedures in OBG segment assemblies designated as 3AW, 3BW, 4AW and 4BW. In process structural bolting appears to be progressing in compliance with the supplied ZPMC bolting procedure.

This QA Inspector observed ZPMC welding personnel performing Flux Core Arc Welding (FCAW) of the Complete Joint Penetration (CJP) edge, side and floor panel splice welds between segment assemblies designated as 3AE to 3BE. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedures as follows:

Monitoring of welding personnel qualifications in accordance with the applicable Welding Procedure Specification as follows:

Welders Name: Li Guimin

Welder ID # 220069

Process Qualified: FCAW

Position Qualified: 3G

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Expiration Date: 03-20-2012

Welders Name: Cao Caijun

Welder ID # 220064

Process Qualified: FCAW

Position Qualified: 3G

Expiration Date: 03-29-2012

Welders Name: Shen Wei

Welder ID # 218976

Process Qualified: FCAW

Position Qualified: 3G

Expiration Date: 03-20-2012

This QA Inspector performed fit-up measuring of the 4AE to 4BE segment splice. These measurements included root opening, off-set and groove angle/bevel preparation. See on-going field data reports.

This QA Inspector observed activity that did not appear to be in conformance with Caltrans project requirements. See submitted Incident Report.

This QA Inspector reviewed the contract files and tracking logs for the Magnetic Particle Testing (MT), Ultrasonic Testing (UT), Welding Procedure Specifications (WPS), Procedure Qualification Records (PQR), and QC Inspector records to this date.

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

Inspected By:	O'Kane,Rory	Quality Assurance Inspector
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Reviewed By:	Carreon,Albert	QA Reviewer
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