

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-006955**Date Inspected:** 27-May-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**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 crossbeams**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 (in superstructure trial assembly)

This QA observed that the contractors personnel are continuing to align this crossbeam to the east and west lines. No other significant work was observed on this crossbeam during the time QA was present.

OBG cross beam CB2 (in superstructure trial assembly)

This QA observed ZPMC personnel installing side panel stiffener splice plates. No other significant work was observed on this crossbeam during the time QA was present.

OBG cross beam CB3 (in superstructure trial assembly)

This QA observed no significant work was being performed on this crossbeam during the time QA was present.

OBG cross beam CB4

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This QA observed that this crossbeam is still in the paint bay. The contractor has blasted and primed the outside surfaces. Inside surfaces have not yet been blasted. No significant work was observed on this crossbeam during the time QA was present.

OBG cross beam CB5

This QA observed ZPMC qualified welding personnel identified as 065947 perform FCAW welding on weld joint identified as CB202A-001-017. ZPMC QC identified as Mr. Guo Yuan Ting 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-Tc-U4b-F.

This QA observed ZPMC qualified welding personnel identified as 204338 perform FCAW welding on weld joint identified as FB205-005-037 and 038. ZPMC QC identified as Mr. Guo Yuan Ting 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-Tc-U4b-F.

This QA observed ZPMC qualified welding personnel identified as 069089 perform FCAW welding on weld joint identified as CB202G-006-148 and 166. ZPMC QC identified as Mr. Guo Yuan Ting 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-2132-3.

This QA observed ZPMC welding personnel welding SPCM material using the FCAW process. The weld joint is identified as CB202A-001-017. According to the date and time written on the side of the spool, the welding electrode being used appears to have been exposed to the atmosphere for a period exceeding 24 hours. This is non compliant to AWS D1.5 2002 section 12.6.7.4 which states "Electrodes not consumed within 24 hours of accumulated exposure outside sealed or heated storage shall be redried by baking as described in 12.6.7.6. Electrodes shall be identified to facilitate monitoring of total atmospheric exposure time. This QA informed ZPMC QA identified as Mr. Shen Xujun and ABF inspector identified as Mr. Kelvin Chueng of this issue and informed both that an incident report would be generated for this non compliance.

OBG cross beam CB6

This QA observed that no significant work was being performed on this crossbeam during the time this QA was present.

OBG cross beam CB7

This QA observed ZPMC personnel beveling one of the deck panel for this crossbeam. No other significant work was observed on this crossbeam during the time QA was present.

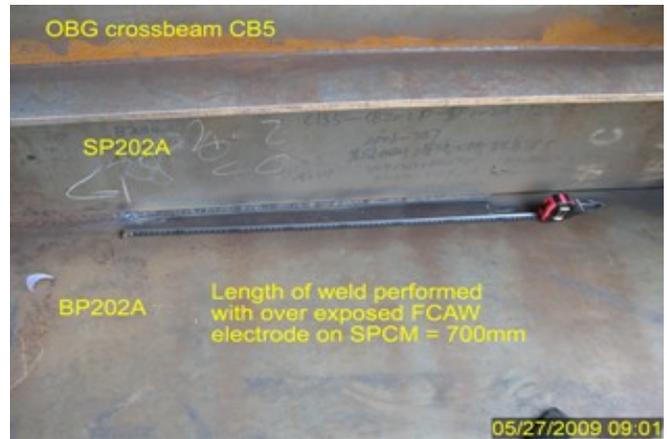
OBG cross beam CB8

This QA observed that the contractor is fitting and tack welding the east side panel to the deck panel. No other significant work was observed on this crossbeam during the time QA was present.

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:

As mentioned above.

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