

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-007276**Date Inspected:** 09-Jun-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 Chih Chien**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 bike path cantilever brackets**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 installing the frame of the catwalk. No other significant work was observed during the time QA was present.

OBG cross beam CB2 (in superstructure trial assembly)

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

OBG cross beam CB3

This QA observed that this crossbeam has been moved to the paint bay. No significant work was observed on this crossbeam during the time QA was present.

OBG cross beam CB4

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This QA observed that this crossbeam has been moved to the area behind bay 13. No significant work was observed on this crossbeam during the time QA was present.

OBG cross beam CB5

This QA observed that ZPMC has not yet performed MT on weld CB202C-001-003. This weld was MT'ed by ZPMC on 06-08-09. This QA rejected the MT by the contractor due to the fact that the contractor did not clean the weld prior to testing. This QA issued an incident report for this issue. No other significant work was observed during the time QA was present.

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

OBG cross beam CB8

This QA observed ZPMC personnel flame straightening bottom panel weld identified as CB202C-008-001. QA observed that ZPMC and Caltrans QA have already performed MT on this weld. This QA informed ZPMC QA identified as Mr. Wang Lu that according to the contract documents, this weld will require re-testing. Mr. Wang indicated that ZPMC would re-test the weld and notify Caltrans QA when testing is complete and ready for QA verification.

OBG bay 5 bike path cantilever brackets

This QA observed ZPMC personnel flame beveling various components for the cantilever brackets. No other significant work was observed during the time QA was present.

OBG cross beam CB10

This QA observed ZPMC qualified welding personnel identified as 066746 perform FCAW welding on weld joint identified as FB294-025-031. ZPMC QC identified as Mr. Yin Dong Hai 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-U4b-F.

This QA observed ZPMC qualified welding personnel identified as 044780 perform SAW welding on weld joint identified as CB202C-010-004. ZPMC QC identified as Mr. Yin Dong Hai 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-L2c-S-2.

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OBG cross beam CB16

This QA observed ZPMC qualified welding personnel identified as 037748 perform SMAW repair welding on weld joints identified as BP205-016-001 and 002. ZPMC QC identified as Mr. Chen Chih Chien 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-345-SMAW-2G (2F)-FCW-repair.

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



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
