

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-007277**Date Inspected:** 07-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 no significant work was being performed on this crossbeam during the time this 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 no significant work was being performed on this crossbeam during the time this QA was present.

OBG cross beam CB4

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This QA observed that this crossbeam is still in the paint bay. No significant work was observed on this crossbeam during the time QA was present.

OBG cross beam CB5

This QA received ZPMC Non Destructive Testing (NDT) notification No. 003343 and performed Ultrasonic Testing (UT) of approximately 10% of the welds previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA generated an UT report for this date. The weld designations are as follows: CB202B-001-003, CB202C-001-003, CB202A-001-005, CB202A-001-017 and CB202B-001-004.

NOTE: weld CB202B-001-004 was not part of the above mentioned NDT notification. This QA noted that the UT of this weld had been performed and accepted by ZPMC UT personnel on 3/26/09 according to the markings on the material.

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 qualified welding personnel identified as 053748 perform SAW welding on weld joint identified as CB202C-008-004. ZPMC QC identified as Mr. Huang Ming 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.

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

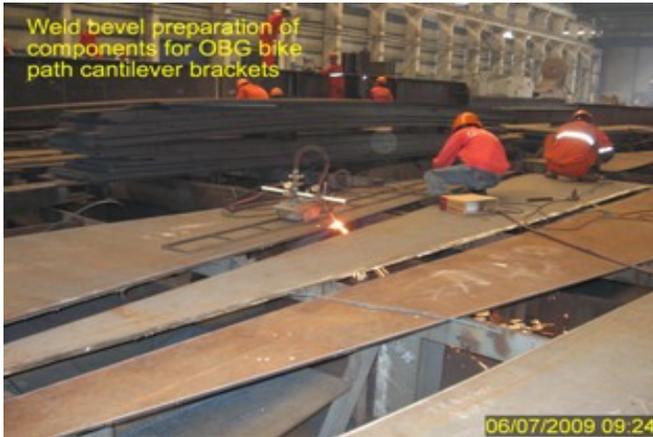
This QA observed ZPMC qualified welding personnel identified as 066746 perform FCAW welding on weld joints identified as FB294-025-028 and 034. ZPMC QC identified as Mr. Yin Dong Hai was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2233-Tc-U4b-F-3G.

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

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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
