

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-007640**Date Inspected:** 04-Jul-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:** Zhoa Chen Sun**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:** various subassemblies**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 bay 5

This QA observed that ZPMC has commenced fitting floorbeam sections to the side panels of CB11. No other significant work was observed in this bay during the time QA was present.

OBG bay 6

This QA observed ZPMC qualified welding personnel identified as 046830 perform SAW welding on weld joint identified as BP3003-001-115. ZPMC QC CWI identified as Mr. Zhoa Chen Sun 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-2231-B-L2c-S-2.

This QA observed ZPMC personnel flame straightening OBG side panels identified as SP203-009 and SP206-009. The flame straightening appeared to be compliant with the applicable flame straightening procedure and the contract documents.

OBG bay 8

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This QA observed that ZPMC has spliced OBG deck panels identified as DP201A and DP203A. The FCAW root pass has been completed and ZPMC personnel are preparing the joint for SAW welding by grinding.

Tower bay 12

This QA received ZPMC Non Destructive Testing (NDT) notification No. 003589 and performed Ultrasonic Testing (UT) of approximately 10% of the welds previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA generated a UT report for this date. The weld designation is as follows: TR6C-PP014-005. Due to inaccessibility issues QA was unable to test this weld per AWS D1.5 2002 UT procedure. QA was instructed by Caltrans QA lead inspector to test the weld using a smaller transducer than what is specified in AWS D1.5 2002.

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

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