

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-007905**Date Inspected:** 24-Jul-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**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 assembly FBs, CBs and tower struts**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 assembly bay 2

This QA observed ZPMC qualified welding personnel identified as 250050 perform SAW welding on OBG floorbeam on weld joint identified as FB305B-001-080. ZPMC QC identified as Mr. Zhan Hai Feng 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 assembly bay 3

This QA observed ZPMC qualified welding personnel identified as 058102 perform SMAW welding in OBG crossbeam CB10 on weld joints identified as CB202G-026-145 and 163. ZPMC QC identified as Mr. Zhang Ya Xu 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-P-2113.

This QA observed ZPMC qualified welding personnel identified as 051359 perform SMAW welding in OBG crossbeam CB10 on weld joints identified as CB202G-027-140 and 158. ZPMC QC identified as Mr. Zhang Ya Xu 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-P-2113.

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OBG assembly bay 6

This QA observed ZPMC qualified welding personnel identified as 068091 perform SMAW welding on tower strut weld joints identified as WD1-A305-77M-2-012 and 013. ZPMC QC identified as Mr. Zhang Bao Bo 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-2113.

This QA observed ZPMC qualified welding personnel identified as 066456 perform SMAW welding on tower strut weld joints identified as WD1-A305-77M-2-058 and 059. ZPMC QC identified as Mr. Zhang Bao Bo 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-2113.

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.

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