

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-007930**Date Inspected:** 25-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 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 3

This QA observed ZPMC qualified welding personnel identified as 058102 perform SMAW welding in OBG crossbeam CB10 on weld joints identified as CB202G-026-132 and 141. 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-027-116 and 132. 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.

OBG assembly bay 6

This QA observed ZPMC qualified welding personnel identified as 037932 perform SMAW welding on tower strut weld joints identified as WD1-A305-65M-2-9B and 1A. 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-2212-Tc-U5b.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

This QA observed ZPMC qualified welding personnel identified as 037780 perform SMAW welding on tower strut weld joints identified as WD1-A305-65M-2-7B. 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-3212-Tc-U5b.

OBG segments 6AW, 7EW, 7BW, 7DW and 6CW

No work was observed on the above mentioned segments during the time this QA was present.

OBG assembly bay 14

This QA received ZPMC Non Destructive Testing (NDT) notification No. 003716 to perform Magnetic particle Testing (MT) of approximately 15% of the welds previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA along with ZPMC QC inspector identified as Mr. Guo Xing Hai were unable to locate any of the welds listed on this notification. Mr. Guo made several phone calls, presumably to other QC inspectors, in an attempt to locate these welds. This notification was previously submitted to Caltrans QA on July 17, 2009. Caltrans QA identified by lot number B255, indicated on the NDT tracking log that the welds were not ready for QA examination at this time.

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
