

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-008720**Date Inspected:** 17-Aug-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:** Li Yan Hua**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 segments**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 13

This QA observed ZPMC qualified welding personnel identified as 049339 perform SMAW welding on OBG segment 8CW weld joint identified as SEG047H-018 and 015. ZPMC QC identified as Mr. Guo Xing Hui 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-2214-Tc-U4b-FCM-1 (weld 018) and WPS-B-P-2213-Tc-U4b-2 (weld 015).

This QA observed ZPMC qualified welding personnel identified as 044772 perform SMAW welding on OBG segment 8CW weld joint identified as SEG047J-009 and 021. ZPMC QC identified as Mr. Guo Xing Hui 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-2213-Tc-U4b-2 (weld 009). and WPS-B-P-2214-Tc-U4b-FCM-1 (weld 021).

OBG assembly bay 14

This QA observed ZPMC qualified welding personnel identified as 055491 perform FCAW weld on OBG segment 9BE weld joint identified as SEG052C-004. ZPMC QC identified as Mr. Zhong Guo Hui was present to

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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-Tc-U4b-F.

This QA observed ZPMC qualified welding personnel identified as 043661 perform SMAW welding on OBG segment 9BE weld joint identified as SEG052B-054 and 055. ZPMC QC identified as Mr. Zhong Guo Hui 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-2214-Tc-U4b-FCM-1.

This QA observed ZPMC qualified welding personnel identified as 200113 perform SMAW welding on OBG segment 9BE weld joint identified as SEG052C-052~056. ZPMC QC identified as Mr. Zhong Guo Hui 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-2214-Tc-U4b-FCM-1.

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

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

Trial Assembly Lift 4E

This QA observed ZPMC personnel rigging the floating crane in preparation for transporting and loading OBG lift 4E onto the ship.

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.

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