

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-008722**Date Inspected:** 20-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 and tower skin E**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-119. ZPMC QC identified as Mr. Wang 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-2213-Tc-U4b-FCM-1.

This QA observed ZPMC qualified welding personnel identified as 051359 perform SMAW welding on OBG segment 8CW weld joint identified as SEG047H-164. ZPMC QC identified as Mr. Wang 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-2213-Tc-U4b-FCM-1.

This QA observed ZPMC qualified welding personnel identified as 058551 perform FCAW welding on OBG segment 9BE weld joint identified as CA060-004. ZPMC QC identified as Mr. Zhang Xian Ji 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-2232-Tc-U4b-F.

OBG assembly bay 14

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This QA observed ZPMC qualified welding personnel identified as 045265 perform SAW welding on OBG segment 9BW weld joint identified as SEG051A-031. ZPMC QC identified as Mr. Liu Wan Ning 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.

This QA observed ZPMC qualified welding personnel identified as 050323 perform SAW welding on OBG segment 10AW weld joint identified as SEG059A-017. ZPMC QC identified as Mr. Liu Wan Ning 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.

This QA received ZPMC Non Destructive Testing (NDT) notification No. 004022 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 designations are as follows: Corner assemblies for OBG segment 9AE, welds CA057A-003 and 004, CA058A-003 and 004.

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.

Tower Bay 11

This QA observed ZPMC personnel preheating the doubler plates on west tower skin plate E for lift four, in preparation for welding. This QA noted that the preheating was being performed utilizing ceramic heating pads. ZPMC QC inspectors appeared to be monitoring the process in accordance with the contract documents.

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

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your project.

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