

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-008724**Date Inspected:** 22-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:** Pan Wan Long**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 Trial assembly westline

This QA received ZPMC Non Destructive Testing (NDT) notification No. 004041 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 segment is identified as 2AE. The weld designations are as follows: SEG008B-035, 043 and 048, SEG008C-035, 043 and 048.

This QA observed ZPMC qualified welding personnel identified as 053742 perform FCAW welding on OBG segment 5CW weld joints identified as BP138-001-024, 026, 028 and 030. ZPMC QC identified as Mr. Pan Wen Long 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-2233-B-U2-F.

This QA observed ZPMC qualified welding personnel identified as 220063 perform FCAW welding on OBG segment 5CW weld joint identified as OBW5A-011. ZPMC QC identified as Mr. Pan Wen Long 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-2233-T.

OBG Trial assembly eastline

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

This QA observed the contractors personnel perform various tasks relative to the fabrication and assembly of the Self Anchored Suspension (SAS) span including the following: cleanup and grinding of interior and exterior surfaces and welds, drilling bolt holes in splice plates on the ground near the assembly, back gouging and grinding welds and removing temporary fixtures.

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
