

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-008730**Date Inspected:** 01-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhao Chen Sun**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:** Crossbeams and OBG sub assemblies**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 CROSS BEAM CB1

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

OBG CROSS BEAM CB2

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

OBG CROSS BEAM CB3

This crossbeam has been loaded on the ship.

OBG CROSS BEAM CB4

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

OBG CROSS BEAM CB5

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

OBG CROSS BEAM CB6

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

OBG CROSS BEAM CB7

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

OBG CROSS BEAM CB8

This QA observed ZPMC qualified welding personnel identified as 058174 perform FCAW welding on weld joints identified as FB204-018-57 and 058. ZPMC QC identified as Mr. Meng Lin Nan 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-B-U2-F-1.

This QA observed ZPMC qualified welding personnel identified as 019006 perform FCAW welding on temporary lifting lugs. ZPMC QC identified as Mr. Meng Lin Nan 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-2231-B-U2-F.

This QA observed ZPMC qualified welding personnel identified as 069493 and 066456 perform SMAW repair welding on various weld joints. ZPMC QC identified as Mr. Meng Lin Nan 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 and WPS-B-P-2112.

OBG CROSS BEAM CB9

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

OBG CROSS BEAM CB10

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

OBG CROSS BEAM CB11

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

OBG CROSS BEAM CB12

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

OBG CROSS BEAM CB13

This QA observed ZPMC personnel fitting and tack welding temporary stiffeners to the side panels. No other significant work was observed on this crossbeam during the time QA was present.

OBG CROSS BEAM CB14

This QA observed ZPMC personnel fitting and tack welding floor beam diaphragm sections to side panel identified as CB202D. No other significant work was observed on this crossbeam during the time QA was present.

OBG CROSS BEAM CB15

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

OBG ASSEMBLY BAY 6

This QA observed ZPMC qualified welding personnel identified as 048617 and 068659 perform SMAW welding on tower strut weld joint identified as WD1-A305-65m-1-9A. 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-P-2212-Tc-U5b.

This QA observed ZPMC qualified welding personnel identified as 053753 and 049769 perform SMAW welding on tower strut weld joint identified as WD1-A305-65m-4-10B. 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-P-2212-Tc-U5b.

This QA observed ZPMC personnel performing various tasks relative to the fabrication and inspection of the OBG and tower subassemblies including the following:

1. Personnel beveling the tower double diaphragm webs.
2. QC performing Visual Testing (VT) of welds on edge panel identified as EP3010B.

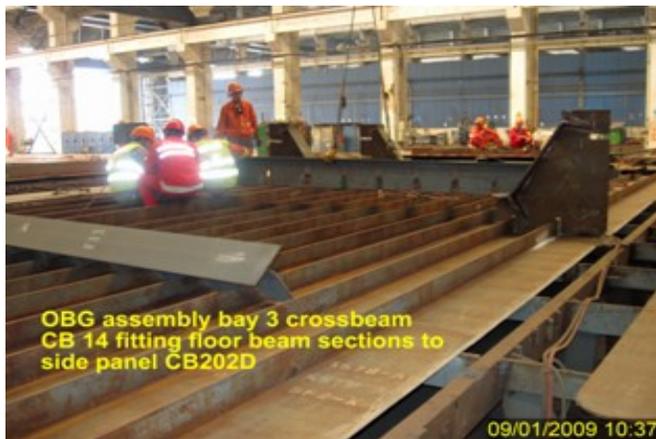
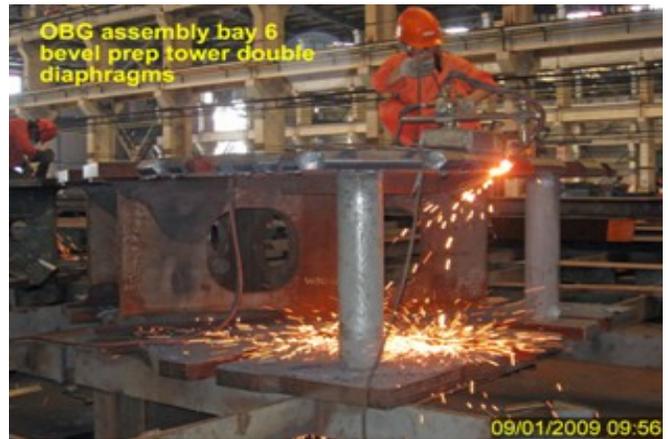
OBG ASSEMBLY BAY 9

This QA observed ZPMC personnel fitting and tack welding U-ribs to deck panel identified as DP3019 for OBG segment 12BE. No other significant work was observed on this bay during the time QA was present.

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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 QC and QA 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
