

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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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-009590**Date Inspected:** 09-Oct-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:** 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 Crossbeams and cantilever brackets**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 crossbeam has been loaded on the ship.

**OBG CROSS BEAM CB2**

This crossbeam has been loaded on the ship.

**OBG CROSS BEAM CB3**

This crossbeam has been loaded on the ship.

**OBG CROSS BEAM CB4**

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

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### 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 053742 perform FCAW welding on weld joint identified as FB205-018-029. ZPMC QC identified as Mr. Liu Chuan Gang 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 053609 perform FCAW welding on weld joint identified as FB205-018-032. ZPMC QC identified as Mr. Liu Chuan Gang 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.

This QA observed ZPMC qualified welding personnel identified as 058174 perform FCAW welding on weld joint identified as FB205-020-032. ZPMC QC identified as Mr. Liu Chuan Gang 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.

### 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

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

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present.

### OBG CROSS BEAM CB12

This QA observed ZPMC qualified welding personnel identified as 060687 perform FCAW welding on weld joint identified as CB201G-035-168. ZPMC QC identified as Mr. Sun Yan Fei 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-2132-3.

### OBG CROSS BEAM CB13

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

### OBG CROSS BEAM CB14

This QA observed that no significant work was being performed 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 CROSS BEAM CB16

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

### OBG BAY 5

This QA observed ZPMC personnel buttering (build up with weld) the backing bar splice welds inside of the bike path cantilever brackets utilizing the SMAW method. The cantilever brackets are identified as BK001-031, 032, 033, 034, 035 and 036.

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.

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<b>Inspected By:</b>	Hall, Steven	Quality Assurance Inspector
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<b>Reviewed By:</b>	Patterson, Rodney	QA Reviewer
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