

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-009592**Date Inspected:** 12-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:** Xu Yumin**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**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 ZPMC qualified welding personnel identified as 062092 perform SMAW repair welding on various side panel stiffener hold back welds on the inside of this crossbeam. ZPMC QC identified as Mr. Xu

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

Yumin 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-345-SMAW-2G (2F)-FCM-repair and WPS-345-SMAW-4G (4F)-FCM-repair-1.

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 is continuing to perform FCAW welding on weld joint identified as CB202A-008-017. ZPMC QC identified as Mr. Zhou Jie 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.

This QA observed ZPMC qualified welding personnel identified as 058174 is continuing to perform FCAW welding on weld joint identified as CB202A-008-005. ZPMC QC identified as Mr. Zhou Jie 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 CROSS BEAM CB9

This QA observed ZPMC personnel back gouging welds designed on the approved shop drawings as fillet welds. Due to a joint root opening in excess of 5mm the contractor has changed these joints to Complete Joint Penetration (CJP) welds. This deviation from the drawings has previously been recorded in the form of an incident report generated by Caltrans QA inspector Mr. Hiranch Patel Dated 8/22/09. No other significant work was observed 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

WELDING INSPECTION REPORT

(*Continued Page 3 of 4*)

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 ZPMC qualified welding personnel identified as 069118 perform FCAW welding on weld joint identified as CB201A-012-017. 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-2232-Tc-U4b-F.

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 ZPMC qualified welding personnel identified as 215478 perform SMAW tack welding on weld joint identified as CB202A-016-001. ZPMC QC identified as Mr. Zheng Zhi Wei 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-2211-B-U2.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 4 of 4)



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:	Patterson,Rodney	QA Reviewer
---------------------	------------------	-------------