

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-006287**Date Inspected:** 31-Mar-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 630**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Li Hong Fei & Chen Chih Chen	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:	Tower and OBG	

Summary of Items Observed:

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz 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:

Bay 11

This QA inspector performed VT of the area previously tested and accepted by ZPMC Quality Control personnel. The member(s) is/are identified as Lift 2 East Tower Shaft. The weld designations reviewed are as follows:

Fit lug on skin A, B, C, and D from 56m to 62m diaphragm
Skin A, B, C, and D from 56m to 62m diaphragm

Bay 5

This QA Inspector performed Ultrasonic Testing (UT) on approximately 15% of CJP on the OBG CB6 welds previously accepted by ZPMC ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3. The QA Inspector observed no rejectable indications at the time of testing. The QA Inspector generated a TL-6027 UT report on this date. Welds UT verified were identified as listed below

CB202D-006:

001,002

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This QA Inspector observed the following work in progress:

Bay 10

ZPMC's welding personnel is identified as Mrs. Liu Xianoyan (207745) performing groove welding of weld joint SSD1-FDSA3-1B/C-25B. The personnel were observed welding in the 1G (flat) position utilizing a Submerged Arc Welding (SAW) process. ZPMC QC identified Mr. Wan Wenzhong and 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-U3C-S-1.

ZPMC's qualified welding personnel's are identified as Mrs. Bu Xuezhen (052075), Mr. Tao Qian (040457), Mr. Yu Chaoye (053869) and Mrs. Dong Yuqin (053869) perform FCAW welding on weld joints identified SSD1-A164-J/J-14, SSD1-A164-J/J-50, SSD1-A164-J/J-43 and SSD1-A164-J/J-13. ZPMC QC identified Mr. Li Hong 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-2233-B-U2a-F-1.

Bay 11

ZPMC's qualified welding personnel's are identified as Mr. Wang Yinsheng (040775), Mr. Li Zhaoqian (048820), Mr. Wang Bing (040713) and Mr. Zhang Binghoa (053316) perform FCAW welding on weld joints identified EDS1-FASA3-2E/E-60, EDS1-FASA3-2E/E-56A, EDS1-FASA3-2E/E-51A and EDS1-FASA3-2E/E-17A. ZPMC QC identified Mr. Li Hong 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-2231-Tc-U5-F.

Bay 7

ZPMC's qualified welding personnel's are identified as Mr. Wang Hongho (203206) and Chen Dingding (048923) perform SMAW (tack) welding on weld joints identified SP746-001-014,013 and SP746-001-020,019. ZPMC QC identified Mr. Chen Chih Chien 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-2112.

Bay 6

ZPMC qualified welding personnel Mr. Lei Hanjie (215672) perform SMAW (tack) welding on weld joint identified as BP202-008-006 and BP202-008-004. ZPMC QC identified Mr. Chen Chih Chien 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-2114.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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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 (134-8257-0045), who represents the Office of Structural Materials for your project.

Inspected By:	Alaniz,Joe	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
