

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-008278**Date Inspected:** 29-Jul-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Wu Zhi Cheng and 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	

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:

OBG Assembly Yard

4BW Segment

SMAW repair welding of weld joints 003 and 004 located on SSD11-PP027.

Welder is identified as Mr. Lv Peng (048617). ZPMC QC is identified as Mr. Wu Zhi Cheng.

The welding variables recorded by QC appeared to comply with WPS-B-P-2112 and CWR procedure B-CWR614.

SMAW repair welding of weld joints 003 and 004 located on SSD10-PP026.

Welder is identified as Mr. Han Xiaofeng (048617). ZPMC QC is identified as Mr. Wu Zhi Cheng.

The welding variables recorded by QC appeared to comply with WPS-B-P-2112 and CWR procedure B-CWR614.

SMAW repair welding of weld joints 004 and 005 located on SSD12-PP028.

Welder is identified as Mr. Lv Peng (048617). ZPMC QC is identified as Mr. Wu Zhi Cheng.

The welding variables recorded by QC appeared to comply with WPS-B-P-2112 and CWR procedure B-CWR614.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

3AW & 3BW Segment

FCAW repair welding of weld joints 46, 47 and 003~ 006 located on SEG015B.

Welder is identified as Mr. Cao Caijun (220064). ZPMC QC is identified as Mr. Wu Zhi Cheng.

The welding variables recorded by QC appeared to comply with WPS-B-T-2232-Tc-U4b-F.

4AW & 4BW

SMAW repair welding of horizontal stiffeners located on Panel Point 26~28.

Welder is identified as Mr. Zhang Xiaochong (202841). ZPMC QC is identified as Mr. Wu Zhi Cheng.

The welding variables recorded by QC appeared to comply with WPS-345-FCAW-4G (4F)-FCM-Repair.

SMAW repair welding of weld joints 20, 21 and 38 located on SEG17A.

Welder is identified as Mr. Chen Zhenghua (220067). ZPMC QC is identified as Mr. Wu Zhi Cheng.

The welding variables recorded by QC appeared to comply with WPS-B-T-2232-Tc-U4b-F.

3AE Segment

FCAW repair welding of weld joint 005 located on SEG14A.

Welder is identified as Mr. Zhang Hanming (220066). ZPMC QC is identified as Mr. Xu Yumin.

The welding variables recorded by QC appeared to comply with WPS-345-FCAW-1G (1F)-Repair-1 and WWR procedure B-WR6492.

FCAW repair welding of weld joints 020 and 021 located on SEG14B.

Welder is identified as Mr. Zhang Hanming (220066). ZPMC QC is identified as Mr. Xu Yumin.

The welding variables recorded by QC appeared to comply with WPS-345-FCAW-1G (1F)-Repair-1 and WWR procedure B-WR6492.

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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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
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Reviewed By:	Carreon,Albert	QA Reviewer
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