

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-008511**Date Inspected:** 18-Aug-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:	Li Jia			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

1AAE + 1AE

FCAW welding of weld joints 512~514 located on SEGE.

Welder is identified as Mr. Jiang Yafei (067665). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-B-T-2233-B-U3-F.

SMAW welding of weld joint 001 located on OBE1.

Welder is identified as Mr. Yang Changming (058242). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-2214-B-U2-FCM-1.

SMAW welding of weld joint 001 located on OBE1.

Welder is identified as Mr. Zang Yanbo (045196). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-2214-B-U2-FCM-1.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

SMAW welding of weld joints 006/007 located on OBE1B.

Welder is identified as Mr. Zang Wei (066413). ZPMC QC is identified as Li Jia.

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

SMAW welding of weld joints 006/007 located on OBE1B.

Welder is identified as Mr. Hao Jianxiang (067665). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-2214-B-U2-FCM-1.

2BE

SMAW welding of weld joints 053/054 located on OB2B.

Welder is identified as Mr. Zhang Xiaochong (220068). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-2214-B-U2-FCM-1.

1AE + 1BE

SMAW welding of weld joint 008 located on OBE1A.

Welder is identified as Mr. Wang Changming (047864). ZPMC QC is identified as Li Jia.

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

2BE

This QA Inspector witness ZPMC and ABF representatives perform dimensional verification of Longitudinal Diaphragm LD33E (bike path side) and LD33A (cross beam side).

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
Reviewed By:	Carreon,Albert	QA Reviewer
