

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-008672**Date Inspected:** 19-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

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) is/are identified as OBG 3AW, 3BW, OBW3, 2AE and 2BE. The weld designations reviewed are as follows:

3AW

1. SEG013A-031
2. SEG15A-007
3. OBW3A-002/003

3BW

4. LD011-001-012,011,007,008,004
5. LD012-001-007,008

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3AW

6. LD017-001-001,002

2AE

7. SSD55-PP055-201,202

2BE

8. FB016-015-024,025,041,042

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector observed a rejectable indication at the time of testing. The QA Inspector generated a TL-6028 MT report on this date. Welds MT verified was identified as listed below:

3BW

1. LD011-001-003

This QA Inspector observed a linear porosity in the above noted welds accepted by ZPMC QC MT personal. This QA Inspector issued an incident report on the above noted MT rejection.

1AAE +1AE

FCAW welding of weld joints 498~501 located on SEG2E.

Welder is identified as Mr. Yun Chuanshan (050316). ZPMC QC is identified as Li Jia.

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

FCAW welding of weld joints 502~506 located on SEG2E.

Welder is identified as Mr. Ji Hongwei (058245). 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 004 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-345-SMAW-4G (4F)-FCM-Repair-1.

2BE

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

Welder is identified as Mr. Zhang Xiaochong (220069). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-B-P-2114-FCM-1.

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:	Carreon,Albert	QA Reviewer
