

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-008956**Date Inspected:** 11-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 644**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:** 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

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 2AW and 2AE. The weld designations reviewed are as follows:

2AW

- SSD25-PP25-013~022, 043, 044, 055, 056, 064, 067, 068, 105, 106, 091~094, 110~112, 129, 130, 144
177, 178, 161, 162
- FB037-001-16~20

2AW

- SSD17-PP015-163, 167
- SSD54-PP014-174, 184
- SSD18-PP016-174
- OBW2-011~015
- OBW2A-019~23
- OBE2-011~015

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

1AE

SMAW welding of weld joint 153 located on SSD34A-PP8.5.

Welder is identified as Mr. Li Jian (067829). ZPMC QC is identified as Xu Yumin.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G (2F)-FCM-Repair and repair procedure B-WR7432.

SMAW welding of weld joint 153 located on SSD34A-PP8.5.

Welder is identified as Mr. Yan Ailong (067103). ZPMC QC is identified as Xu Yumin.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G (2F)-FCM-Repair and repair procedure B-WR7432.

NDT Observation

QA Inspector observed ZPMC Magnetic Particle (MT) Technician performing MT on various locations in the trial assembly yard. Locations are as followed:

1. Diaphragm to floor beam at panel point 8.5 on Segment 1AW.

Miscellaneous Work In Progress

QA Inspector observed ZPMC's personnel performing various job functions in the trial assembly yard. Locations and description of work are as followed:

1. Mechanical flame torch beveling of side plate (field splice edge) on cross beam and counter weight side of segment 5CW at panel point 36.
2. ZPMC paint department were observed grit blasting various internal locations of segment 3BW.
3. Air arc gouging of UT discontinuities was performed on bottom plate stiffeners to floor beam member located in 1AE at panel point 8.5. SSD34-PP8.5-59, 61, 63, 67, 75, 79 and 77 were the welds being worked on at noted location.

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

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.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By:	Alaniz, Joe	Quality Assurance Inspector
----------------------	-------------	-----------------------------

Reviewed By:	Carreon, Albert	QA Reviewer
---------------------	-----------------	-------------