

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-008957**Date Inspected:** 12-Sep-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:** 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 punch list items 1610 and 1611. The weld designations reviewed are as follows:

2AE

1. SEG007F-83~87, 101~105, 137~141, 146~150, 173~177, 040~043, 022~026

2. SSD18-PP016-186

Punch List Items

3. #1610: SEG008C-001

4. #6011: SEG008B-001

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2AE

SMAW welding of drip plates on crossbeam side located between panel point 13 and 14.
Welder is identified as Mr. Hu Yanming (062092). ZPMC QC is identified as Xu Yumin.
The welding variables recorded by QC appeared to comply with WPS-B-P-2213-B-U2-FCM-1.

1AW

SMAW welding of weld joints 37, 75, 91 and 97 located on SSD34-PP8.5.
Welder is identified as Mr. Li Guangzu (069493). ZPMC QC is identified as Xu Yumin.
The welding variables recorded by QC appeared to comply with WPS-345-SMAW-3G (3F)-FCM-Repair.

5BE

FCAW welding of weld joints 006, 26 and 024 located on SEG024B-001.
Welder is identified as Mr. Li Shuqiang (053609). ZPMC QC is identified as Xu Yumin.
The welding variables recorded by QC appeared to comply with WPS-345-SMAW-3G (3F)-FCM-Repair and repair procedure WR7430.

5BE and 5CE

FCAW welding of weld joints 013 and 014 located on EP52A-001.
Welder is identified as Mr. Cai Fei (220077). ZPMC QC is identified as Xu Yumin.
The welding variables recorded by QC appeared to comply with WPS-B-T-2232-B-U2-F.

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 12.5 on Segment 1BE.
2. Side plate splice (SP181A to SP651) at panel point 18 crossbeam side of Segment 2BE.

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. Air arc gouging of UT discontinuities at weld seam OBE1-004 located on bike path side of segment 1AAE & 1AE. Location of area being excavated is approximately 300mm off of the side plate to bottom plate weld joint.
2. ZPMC paint department was observed grit blasting external of diaphragm located at panel point 19 of segment 3BW.

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3. Air arc back gouging of cjp at floor beam member to longitudinal shear plate located in 1AE at panel point 8.5. Work was performed per B-CWR667.

4. This QA Inspector observed that heat straightening was performed on deck plate stiffener member RS390 and also performed on opposite side (deck plate) as well.

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.

Inspected By:	Alaniz,Joe	Quality Assurance Inspector
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Reviewed By:	Carreon,Albert	QA Reviewer
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