

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-008958**Date Inspected:** 14-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 1BW. The weld designations reviewed are as follows:

1BW

1. SEG005C-021

2. SEG005B-021/022

This QA Inspector performed MT of area previously tested and accepted by Quality Control on 1AW. MT was performed on Diaphragm to Floor beam at panel point 10.5 (repair areas). QA Inspector observed one transverse indication, measuring approximately 3mm in length respectively. Noted transverse indication is located underneath U Rib 7 and 8 from the counter weight. The QA Inspector generated a TL-6028 MT report on this date. Weld MT verified was identified as listed below:

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

1AW

3. SSD44A-004

1BE

SMAW welding (repair) on bottom plate stiffeners on panel point 12.

Welder is identified as Mr. Chen Zhenghua (220067). ZPMC QC is identified as Xu Yumin.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G (2F)-Repair.

1AAW

SMAW welding of weld joints 119, 120, 123 and 124 located on OBW1.

Welder is identified as (220064). ZPMC QC is identified as Xu Yumin.

The welding variables recorded by QC appeared to comply with WPS-B-T-2133.

NDT Observation

QA Inspector observed ZPMC Ultra Sonic (UT) Technician performing UT on various locations in the trial assembly yard. Locations are as followed:

1. Bottom plate weld seam OBW1A-003 (1AAW & 1AW).
2. Deck plate weld seam (1AAW & 1AW) on cross beams side of segment.

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. QA Inspector noted area was repaired (surface weld) on 1AAE at weld splice on the bike path side of segment. B-WR7494.
2. Air arc gouging of UT discontinuities at weld seam OBW1A-007 per B-WR7252 procedure.

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
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Reviewed By:	Carreon,Albert	QA Reviewer
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