

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-009139**Date Inspected:** 23-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 and 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

SMAW welding of weld joint 003 located on OBE1A.

Welder is identified as Mr. Zang Yanbo (045196). ZPMC QC is identified as Xu Yumin.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-1G (1F)-Repair and repair procedure WR7764.

SMAW welding of weld joints 083 and 084 located on OBE1A.

Welder is identified as Mr. Li Bo (050433). ZPMC QC is identified as Xu Yumin.

The welding variables recorded by QC appeared to comply with WPS-B-P-2113-FCM-1.

FCAW welding of weld joint 003 located on OBE1A.

Welder is identified as Mr. Zang Yanbo (045196). ZPMC QC is identified as Xu Yumin.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G (4F)-Repair and repair procedure WR7764.

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NDT Observation

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

1. ZPMC MT technician performed MT at excavation on OBE1A-003 UT reject (discontinuity). Y location is approximately 2760mm from bottom plate edge (bike path side).
2. MT was performed on drip plate on bike path side of segment 1AE at panel point 9.

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

1. UT was performed on weld OBE1-001 (various locations) with a 45° wedge. Scanning “D” pattern was observed at time of UT inspection.

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. Installing lifting lug assembly onto segment 3W.
2. ZPMC workers removing grit from internal of segment 2E for coating process.
3. ZPMC worker performing the excavation on OBE1A-003 UT reject (discontinuity). Y locations are approximately 2760m from bottom plate edge (bike path side).
4. Cable tray test fit up is still in progress at 1E segment 1AAE and 1AE weld splice.
5. Grit blasting of various internal areas in segment 4W.
6. ZPMC workers removing surface defects with handheld grinder at panel point 29 (floor beam to diaphragm) on segment 5AE.

Note:

Due to inclement weather, work was limited in the OBG Trail Assembly Yard on today’s work shift.

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.

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