

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-009266**Date Inspected:** 01-Oct-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

2AE

SMAW plug welding of bottom plate stiffeners located between panel point 13.5 & 14.

Welder is identified as Mr. Hu Yangming (062092). ZPMC QC is identified as Xu Yumin.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-1G (1F)-Repair- missdrilled holes and repair procedure CWR755.

1AE

SMAW repair welding of weld joints 023~026 located on OBE1.

Welder is identified as Mr. Yun Chengxian (045138). ZPMC QC is identified as Xu Yumin.

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

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

SMAW repair welding of weld joints 035, 036, 041 and 042 located on OBE1.
Welder is identified as Mr. Liu Houkuan (045133). ZPMC QC is identified as Xu Yumin.
The welding variables recorded by QC appeared to comply with WPS-B-P-2113-FCM-1.

NDT Observation

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 2AE and 2BE bottom plate areas performed by Caltrans and ABF with a 70° transducer. Y locations of areas inspected by ZPMC are 4325, 4355 and 5425mm. Measurements were pulled from bike path side of segment.

Note:

Due to inclement weather and China National Holiday, 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.

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