

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-010033**Date Inspected:** 09-Nov-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 Wu Zhi Cheng**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

CB1

This QA Inspector performed Ultra Sonic (UT) inspection of side plate to deck plate weld joint on CB1 (pp14) and CB2 (pp20) utilizing scanning pattern D to detect transverse indication reflectors. Noted UT inspection was performed in conjunction with ABF UT Department.

See Caltrans's Ultrasonic Transverse Indication Evaluation report sheet dated 11-09-09 for future information on inspection performed on this work day.

2AE+2BE

SMAW repair welding on weld joint 004 located on OBE2A.

Welder is identified as Mr. Hu Yanming (062092). ZPMC QC is identified as Li Yang.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair-1.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

1BE

SMAW repair welding on excavation on weld joint 004 located on CA097.

Welder is identified as Mr. Wu Haijun (201087). ZPMC QC is identified as Xu Yumin.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G (2F)-FCM-Repair-1 and CWR repair procedure #868.

Y location of excavation areas noted welder (201087) performed the repair work is at 14850mm of the side plate and bottom plate weld joint.

SMAW repair welding on excavation on weld joint 004 located on CA097.

Welder is identified as Mr. Kua Wenshan (054013). ZPMC QC is identified as Xu Yumin.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G (2F)-FCM-Repair-1 and CWR repair procedure #868.

BK1

FCAW welding on weld joint 047 located on BK001-020.

Welder is identified as Mr. Zhang Hanming (220066). ZPMC QC is identified as Xu Yumin.

The welding variables recorded by QC appeared to comply with WPS-345-FCAW-1G (1F)-Repair-1 and repair procedure 8429.

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:

1BE

Excavation areas at edge plate to deck plate weld joint on cross beam side of segment. Y locations and numbers of MT Indications observed are as followed:

1. Y location 2380mm. 2 MT transverse indications observed.
2. Y location 2140mm. 5 MT transverse indications observed.
3. Y location 6000~6500mm. 11 MT transverse indications observed.

1BE

Excavation areas at edge plate to deck plate weld joint on cross beam side of segment. Y locations and numbers of MT Indications observed are as followed:

1. Y location 10660mm. 4 MT transverse indications observed.
2. Y location 13661mm. 2 MT transverse indications observed.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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
---------------------	----------------	-------------