

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-011635**Date Inspected:** 28-Jan-2010**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:** Li Yang**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

6CE

Shield Metal Arc Welding (SMAW) repair welding was performed on X35 stiffener located at cross beam side of segment between panel point 45 & 46. Welder is identified as Mr. Zhao Guanglin (044779). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-3G (3F)-FCM-Repair-1 and WR 10057 repair procedure.

Shield Metal Arc Welding (SMAW) repair welding was performed on X8E stiffener located at cross beam side of segment between panel point 45 & 46. Welder is identified as Mr. Hu Yacheng (049339). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-3G (3F)-FCM-Repair-1 and WR 10057 repair procedure.

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7BE+7CE

Flux Core Arc Welding (FCAW) welding was performed on weld joint 007 located at OBE7C side splice on cross beam side of segment. Welder is identified as Mr. Chen Zhenghua (220067). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2233T.

Flux Core Arc Welding (FCAW) welding was performed on weld joint 007 located at OBE7C side splice on cross beam side of segment. Welder is identified as Mr. Dian Yifa (068596). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2233T.

5BW

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 041 located at SEG023C on cross beam side of segment. Welder is identified as Mr. Han Xiaofeng (054467). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-2G (2F)-Repair-1 and WR 10494 repair procedure.

5AW+5BW

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joints 013 and 014 located at EP038-001 on cross beam side of segment. Welder is identified as Mr. Dai Lu (048659). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-1G (1F)-Repair-1.

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:

7AE+7BE

1. Back gouge of side plate weld splice OBE7B-001 and 002.

6CW

This QA Inspector observed ZPMC welder Liu Daiquan (066401) repair welding in the 4G position on weld joint OB6F-009 on the counter weight side of segment. QA Inspector asked for welder's qualification card to verify position qualified. QA Inspector noted welder was qualified in the 3G position and not the 4G position. (Welding out of position) This QA Inspector issued an incident report for noted issue.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

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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:	Miller,Mark	QA Reviewer
