

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-011810**Date Inspected:** 07-Feb-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:** 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

7CW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 006 located at OBW7A edge plate weld splice on counter weight side of segment. Welder is identified as Mr. Niu Duojun (037932). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2214-B-U2-FCM-1.

7BW+7CW

Flux Core Arc Welding (FCAW) welding was performed on weld joint 007 located at OBW7B side plate splice on cross beam side of segment. Welder is identified as Mr. Wang Quanlin (066746). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2233T.

7BW

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Flux Core Arc Welding (FCAW) welding was performed on weld joint 010 located at OBW7B side plate splice on cross beam side of segment. Welder is identified as Mr. Wang Quanlin (066746). ZPMC QC is identified as Wu Zhi Cheng. 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 010 located at OBW7B deck side plate splice on cross beam side of segment. Welder is identified as Mr. Jiang Zhen (068917). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2233T.

NDT Observation

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

6AW+6BW

1. Side plate weld splice OBW6B-001/002 temporary attachment areas on counter weight side of segment.
2. Side plate weld splice OBW6B-004/005 temporary attachment areas on cross beam side of segment.

6AE+6BE

1. Side plate weld splice OBW6B-002/003 temporary attachment areas on cross beam side of segment.

7CW

This QA Inspector observed welding being performed on side plate t stiffener (SP052-001-009) located at counter weight side of segment. This noted upon completion of noted weld joint, this QA Inspector observed rain water ran directly over weldment. This QA Inspector issued an incident report for today's work shift.

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 (150-0042-2372), 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: | Miller,Mark | QA Reviewer |
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