

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-012338**Date Inspected:** 01-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**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

6BE

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joints 001 and 002 located at CA028 on the cross beam side of segment. Welder is identified as Mr. Dai Lu (044779). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair-1 WR 10757.

6CE

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joints 001 and 002 located at CA030 on the cross beam side of segment. Welder is identified as Mr. Dai Lu (044779). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair-1 WR 10757.

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Shield Metal Arc Welding (SMAW) repair welding was performed on weld joints 005 located at CA030 on the bike path side of segment. Welder is identified as Mr. Niu Duojun (044779). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair-1 WR 10758.

6AE

Shield Metal Arc Welding (SMAW) VT repair welding was performed on various horizontal stiffeners at panel points 38, 39 and 40 cross beam side of segment. Welder is identified as Mr. Dong Haitao (067183). 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.

6AW

Shield Metal Arc Welding (SMAW) VT repair welding was performed on various horizontal stiffeners at panel points 38, 39 and 40 cross beam side of segment. Welder is identified as Mr. Zang Wai (066413). 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.

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:

6AE

1. Performed on horizontal stiffeners panel point 39 hold back welds at cross beam side of segment.
2. Performed on temporary attachment areas on side plate panel point 37 located on the bike path side of segment.

6AW

1. Performed on horizontal stiffeners panel point 38 hold back welds at cross beam side of segment.

7CE

1. UT being performed on the edge to deck plate weld joint located on the bike path side of segment.

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:

5AE

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1. Grit blasting in progress at various internal locations of segment.

6AW

1. Observed excavations being performed on various horizontal stiffeners located at panel point 40 on cross beam side.

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.

Inspected By:	Alaniz,Joe	Quality Assurance Inspector
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Reviewed By:	Miller,Mark	QA Reviewer
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