

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-012714**Date Inspected:** 13-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

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) is/are identified as 6CE Segment Tag #6. The weld designations reviewed are as follows:

6CE

1. SEG032H-111, 112, 126, 127, 044, 045
2. SEG032J-063, 064, 081, 082, 106, 109

7AW+7BW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 002 located at OBW7 deck plate weld splice. Welder is identified as Mr. Ji Yunfeng (067589). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2214-B-U2-FCM-1.

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Shield Metal Arc Welding (SMAW) welding was performed on weld joint 003 located at OBW7 deck plate weld splice. Welder is identified as Mr. Zang Yanbo (045196). 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-U4b-FCM-1.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 003 located at OBW7 deck plate weld splice. Welder is identified as Mr. Li Zai Jun (037996). 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.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 003 located at OBW7 deck plate weld splice. Welder is identified as Mr. Zhang Quanfa (066326). 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.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 003 located at OBW7 deck plate weld splice. Welder is identified as Mr. Jiang Jinyong (066361). 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.

7AE

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 004 located at CA033 on the cross beam side of segment. Welder is identified as Mr. Yan Yunfeng (215553). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-2G (2F)-FCM-Repair-1 and CWR1210 repair procedure.

Y Location of repairs areas by above noted welder (215553) is located at 4190mm~4300mm and 3700mm.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 004 located at CA033 on the cross beam side of segment. Welder is identified as Mr. Wang Zhengbin (216086). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-2G (2F)-FCM-Repair-1 and CWR1210 repair procedure.

Y Location of repairs areas by above noted welder (216086) is located at 1790mm~1960mm.

7BE+7CE

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 002 located at OBW7 at bike path side of segment. Welder is identified as Mr. Chen Zhenghua (220067). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2214-B-U2-FCM-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:

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7AW

1. Ut reject excavation in progress at the longitudinal flange to floor beam web weld joint SEG033B-001, located at panel point 48 counter weight side of segment.

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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