

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-013628**Date Inspected:** 23-Apr-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 X371 to X74 fillet welds. The weld designations reviewed are as follows:

1. SSD27-001-089~92, 95, 96, 001, 017~022, 101, 102
2. SSD27-001-165~167, 175, 176, 129, 130, 55, 55

8AE

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 002 located at CA048 bike path 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-Tc-U4b-FCM-1.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 044 located at SEG044* cross beam

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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-Tc-U4b-FCM-1.

7EE

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 002 located at CA046 bike path 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-Tc-U4b-FCM-1.

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joints 010 and 012 located at EP083-001 cross beam side of segment. Welder is identified as Mr. Chen Hongjun (067609). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair-1 and WR12199 repair procedure.

8AE+8BE

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 003 located at OBE8B bottom plate of segment. Welder is identified as Mr. Zhang Hanming (220066). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2231T.

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 003 located at OBE8B bottom plate of segment. Welder is identified as Mr. Chang Zhenghua (220069). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2231T.

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 003 located at OBE8B cross beam side of segment. Welder is identified as Mr. Chang Zhenghua (220069). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2231T.

7CW+7DW

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 009 located OBE7A bottom plate splice of segment. Welder is identified as Mrs. Liu Xie (066236). 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-1.

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 002 located OBW7C counter weight side of segment. Welder is identified as Mr. Jin Rong (066421). 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-1.

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

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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:	Carreon,Albert	QA Reviewer
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