

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-013629**Date Inspected:** 24-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 UT of approximately 10% of the repaired area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member(s) is/are identified as OBG 1BW LD web to FB web. The weld designations reviewed are as follows:

1. SEG038C-009/007
2. SEG038B-022

8AE+8BE

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 041 located at DP667-001 cross beam side of segment. Welder is identified as Mr. Liu Qinqyong (066479). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-3213-B-U2b.

7CW+7DW

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 001 located at OBW7C counter weight side of segment. Welder is identified as Mr. Tian Zhaoquan (045246). 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-FCM-1.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 001 located at OBW7C cross beam side of segment. 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-FCM-1.

7DE

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 004 located at CA042 bike path side of segment. Welder is identified as Mr. Chen Renzhi (058087). 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 CWR1378 R2 repair procedure.

Y Location of repairs areas by above noted welder (058087) is located at 4500mm.

BP Member 25A-005

Shield Metal Arc Welding (SMAW) base metal repair welding was performed on bottom plate temporary attachment areas. Welder is identified as Mr. Jun Rong (066471). 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)-Repair-1 and WR12119 repair procedure.

Miscellaneous Work In Progress

QA Inspector observed ZPMC's personnel performing various job functions at Tail Assembly Yard. Locations and description of work are as followed:

8AE

1. Heat straightening was performed on LD located between PP49&PP50 counter weight side of segment per HSR1 (B)-8277. 3rd time this QA Inspector noted heat straightening performed at this area.
2. Removal of EP I rib welds for misalignment issues per WR12199 located on the crossbeam and bike path side.

NDT Observation

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

7DE+7EE

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

1. Side plate t stiffener hold back welds located on the bike path 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
Reviewed By:	Carreon,Albert	QA Reviewer
