

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-014364**Date Inspected:** 17-May-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 7BW LD to FB, Z plates and 8AE+8BE temporary attachment areas. The weld designations reviewed are as follows:

7BW

1. SEG035C-006

Z plates

1. SSD16-PP056-094

2. SSD18-PP058-093

3. SSD16-PP062-094

4. SSD18-PP064-093

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

5. SSD16-PP068-094

6. SSD18-PP070-093

8AE+8BE

1. OBE8-001~005

2. OBE8B-001~005

7DW+7CW

Shield Metal Arc Welding (SMAW) welding was performed at weld joint 004 located at OBW7C on side plate cross beam side of segment. Welder is identified as Mr. Zang Yanbo (045196). 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)-Repair-1 and WR12774 procedure.

8BW+8CW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 044 located at SP765-001 cross beam side of segment. Welder is identified as Mr. Ji Yi (045268). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2213-B-U2-FCM-1.

7EW+8AW

Shield Metal Arc Welding (SMAW) welding (VT repair) was performed at various locations on side plate stiffeners located at cross beam side of segment. Welder is identified as Mr. Li Zhengxu (066179). 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-1.

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:

8BE+8CE

1. Removal of weld from weld joint SP540A-001-026/27 and SP539A-001-033/034 located at side plate on cross beam side of segment. Per WR12852 repair procedure.

8AW

1. Removal of damaged floor beam to bottom plate at panel point 64 cross beam side, per ZPMC RFI # GGL-MQ-1573 procedure.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

9AE+9BE

1. Segments were moved to trail assembly yard for the required work.

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
