

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-014367**Date Inspected:** 20-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 8AW, 8BW and 8CW X37 to I ribs. The weld designations reviewed are as follows:

8AW

1. CA047-49~54, 37~42
2. SEG043D-57~61

8BW

1. CA047-49~54, 61~66
2. SEG050-61~66, 73~78

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8CW

1. CA053-73~078, 85~90
2. SEG047J-5~8, 74, 75, 78~81

7DW+7EW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 059 and 58 located at SP447-001 cross beam side of segment. Welder is identified as Mr. Tian Zhaoquan (045246). 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 WR12988 and WR12989 repair procedure.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 027 located at EP070-001 cross beam side of segment. Welder is identified as Mr. Tian Zhaoquan (045246). 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 WR12773 repair procedure.

8AW

Flux Core Arc Welding (SMAW) welding was performed on weld joint 024 located at SEG039A cross beam side of segment. Welder is identified as Mr. Bi Laishu (045280). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-FCAW-3G (3F)-FCM-Repair-1 and WR12774 procedure.

8BW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 049 located at SEG045A cross beam side of segment. Welder is identified as Mr. Zai Dawei (068097). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2214-B-U2-FCM-1.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 002 located at SEG050 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-T-2214-B-U2-FCM-1.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 005 located at CA049 counter weight side of segment. Welder is identified as Mr. Zang Wei (066413). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2214-Tc-U4b-FCM-1.

8CW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 049 located at SEG047B counter weight side of segment. Welder is identified as Mr. Zai Dawei (068097). ZPMC QC is identified as Li Yang. 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 043 located at SEG047* 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-T-2214-B-U2-FCM-1.

7CW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 007 located at SEG037C 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)-FCM-Repair-1 and WR12955 procedure.

Flux Core Arc Welding (SMAW) welding was performed on weld joint 006 and 24 located at SEG037C cross beam side of segment. Welder is identified as Mr. Bi Laishu (045280). 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)-FCM-Repair-1 and WR12964 and WR12965 procedure.

7AE

Shield Metal Arc Welding (SMAW) plug welding on bottom plate at panel point 48 cross beam side of segment. Welder is identified as Mr. Han Xiaofeng (054467). 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-Missdrilled hole and WR12899 procedure.

8CE

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 029 located at SEG048B cross beam side of segment. Welder is identified as Mr. Zang Feng (049769). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2214-B-U2-FCM-1.

Flux Core Arc Welding (FCAW) welding was performed on weld joint 048 located at SEG048B bike path side of segment. Welder is identified as Mr. Li Shuqiang (053609). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2231-B-U2-F.

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
Reviewed By:	Carreon,Albert	QA Reviewer
