

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-014810**Date Inspected:** 10-Jun-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

8BW+8CW

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 003 located at OBW8A deck plate splice of segment. Welder is identified as Mr. Ni Leijiang (045240). 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 CWR1612 procedure.

Y Location of repairs areas by above noted welder (045240) is located at 16220mm.

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 003 located at OBW8A deck plate splice of segment. Welder is identified as Mr. Cao Xinglong (069683). 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 CWR1612 procedure.

Y Location of repairs areas by above noted welder (069683) is located at 22240mm.

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Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 003 located at OBW8A deck plate splice of segment. Welder is identified as Mr. Zhai Dawei (068097). 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 CWR1612 procedure.

Y Location of repairs areas by above noted welder (068097) is located at 6290mm.

8AW

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 016 and 017 located at SEG430 cross beam side of segment. Welder is identified as Mr. Zhao Guanglin (044779). 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 WR13262 procedure.

9BW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 5~16 located at SP769-001 cross beam side segment. Welder is identified as Mr. Li Zaijun (037996). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2112-FCM-1.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 036~049 located at SP491-001 cross beam side 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-P-2112-FCM-1.

9AW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 25~32 located at SP768-001 cross beam side segment. Welder is identified as Mr. Li Zaijun (037996). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2112-FCM-1.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 029~042 located at SP490-001 cross beam side 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-P-2112-FCM-1.

Travel Rail Brackets

Flux Core Arc Welding (FCAW) welding was performed on weld joint 002 located at TR1D-PP069 for counter weight side of segment 8CW. Welder is identified as Mr. Wang Bing (048696). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2132-Tc-U4b-F.

NOTE

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Due to inclement weather at the am part of work shift, work was limited in the trail assembly yard.

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
