

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-015065**Date Inspected:** 21-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

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 X8E to edge plate. The weld designations reviewed are as follows:

8AW

1. SEG043E-13~15, 31~33
2. SEG043D-65~67, 42~43, 83~85, 101~103, 128~130

8AE

Shield Metal Arc Welding (SMAW) VT repair welding was performed various locations on the FL3 horizontal stiffeners cross beam side of segment. Welder is identified as Mr. Cheng Zhenghua (220066). 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 CWR1414 procedure.

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Shield Metal Arc Welding (SMAW) VT repair welding was performed various locations on the FL3 horizontal and bottom plate stiffeners cross beam side of segment. Welder is identified as Mr. Hu Yanming (062092). 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 CWR1414 procedure.

8AW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 222 located at SSD25-PP63 cross beam side of segment. Welder is identified as Mr. Ni Leijiang (037723). 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 170 located at SSD10A-PP62 cross beam side of segment. Welder is identified as Mr. Hao Jianxiang (067665). 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.

8CW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 223 and 221 located at SSD25-PP69 cross beam side of segment. Welder is identified as Mr. Jiang Zhen (068917). 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.

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:

8 East and 8 West

1. Sea fasteners and cable trays are being installed at various locations inside segment.

7 West

1. Grit blasting at various locations (internal/ external) on segment.

NDT Observation

This QA Inspector observed ZPMC Ultra Sonic Testing (UT) Technician performed UT on various locations in the trial assembly yard. Locations are as followed:

1. Performed on the FL3 hold back welds located at panel points 68 thru 70.

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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:

8CW

1. Side plate, bottom plate, edge plate and deck plate T stiffeners/ I ribs hold back welds at panel point 70.

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
