

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-006003**Date Inspected:** 26-Mar-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 630**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Peng Fei and Chen Likun**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:** Tower and 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:

This QA Inspector performed Ultrasonic Testing (UT) on approximately 15% of CJP on the OBG Lift 11 I-Beam welds previously accepted by ZPMC ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3. The QA Inspector observed no rejectable indications at the time of testing. The QA Inspector generated a TL-6027 UT report on this date. Welds UT verified were identified as listed below

Bay 7

SP142-001-039, 041, 042, 043, 045, 047

SP169-001-041, 047, 049

SP355-001-047, 051, 053

SP115-001-044, 045, 054, 058, 060

SP328-001-054, 056

SP382-001-037, 038, 051, 053

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This QA Inspector observed the following work in progress:

Bay 10

ZPMC's qualified welding personnel's are identified as Mr. Yu Jun (201825), Mr. Wang Kui (203977), Mr. Jin Xiaogang (053474), Mr. Zhu Zhong Yun (057194) perform FCAW welding on weld joint identified as SSD1-FASA3-1E/E-42,43, NSD1-A112B/H-4A and NSD1-A166E/J-23B. ZPMC QC identified Mr. Chen Likun was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-TC-U2b-F, WPS-B-T-2332-TC-P5-F-1.

ZPMC's qualified welding personnel's are identified as Mr. Lu Zhengshu (044500), Mr. Shi Xingyu (052930) and Wang Chong (062199) perform SMAW welding on weld joint identified as SSSD1-A164 E/J-245B and SSD1-FCSA3-1B/C-56A. ZPMC QC identified Mr. Wu Zhi Feng was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-2G (2F) and WPS-B-T-2211-B-U3B.

Bay 11

ZPMC's welding personnel's are identified as Mrs. Deng Junfeng (202756) and Mrs. Shen Mei (041716) performing groove welding of weld joint ESD1-FBSA3-2A/C-24A, 1A and ESD1-FBSA3-2A/B-9B and 7B. The personnel were observed welding in the 1G (flat) position utilizing a Submerged Arc Welding (SAW) process. ZPMC QC identified Mr. Li Hong Wei and was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-U3C-S-1.

ZPMC's qualified welding personnel's are identified as Mr. Yang Lei (040690), Mr. Yang Zaihua (040669) perform FCAW welding on weld joint identified as ND1-A468-23M-1-28B, 6A and 1A. ZPMC QC identified Mr. Li Peng Fei was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3212-TC-U5b-1 and WPS-B-T-2212-TC-U5b-1.

OBW3

ZPMC's qualified welding personnel identified as Mr. Fang Huai (205715) perform SMAW (Fit up) welding on weld joint identified as OBW3-008. ZPMC QC identified Mr. Shi Ling was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2112-FCM.

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 (134-8257-0045), who represents the Office of Structural Materials for your project.

Inspected By:	Alaniz,Joe	Quality Assurance Inspector
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Reviewed By:	Carreon,Albert	QA Reviewer
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