

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-006165**Date Inspected:** 09-Apr-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:** Guo Peng and Liu Fawen**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:

Bay 11

This QA inspector performed VT of the area previously tested and accepted by ZPMC Quality Control personnel. The member(s) is/are identified as Lift 2 East Tower. The weld designations reviewed are as follows:

1. Welds and fit lug between the 53m diaphragm and skin A/D and E fit.

Bay 13

This QA inspector performed UT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member(s) is/are identified as 2BW Longitudinal Diaphragm. The weld designations reviewed are as follows:

1. SEG009C-009

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Bay 11

This QA Inspector observed the following work in progress:

SMAW welding of weld joint 17A-2 (17B-2) located on PCMK WSD1-FESA3-2A/D.
Welder is identified as Mr. Zhang Jianguo (204202). ZPMC QC is identified as Guo Peng.
The welding variables recorded by QC appeared to comply with WPS-B-P-2211-B-U3b.

SMAW welding of weld joint 23 and 24 located on PCMK WSD1-FESA3-2A/D.
Welder is identified as Mr. Wag Lei (205442). ZPMC QC is identified as Guo Peng.
The welding variables recorded by QC appeared to comply with WPS-B-T-2233-B-U3-F.

FCAW welding of weld joint 2 and 1 located on PCMK ESD1-A167B/H.
Welder is identified as Mr. Shi Jiabao (068494). ZPMC QC is identified as Guo Peng.
The welding variables recorded by QC appeared to comply with WPS-B-Tc-P4-F.

FCAW welding of weld joint 4 and 3 located on PCMK ESD1-A167B/H.
Welder is identified as Mr. Wei Xingli (067499). ZPMC QC is identified as Guo Peng.
The welding variables recorded by QC appeared to comply with WPS-B-Tc-P4-F.

Bay 10

This QA Inspector observed the following work in progress:

FCAW welding of weld joint 20A located on PCMK SSD1-FASA3-1E/E.
Welder is identified as Mr. Chang Chuancang (053870). ZPMC QC is identified as Liu Liang.
The welding variables recorded by QC appeared to comply with WPS-345-FCAW-1G (1F).

FCAW welding of weld joint 7 located on PCMK SSD1-SA164B/F.
Welder is identified as Mr. Jinnng Zhou (040261). ZPMC QC is identified as Jin Dong Liang.
The welding variables recorded by QC appeared to comply with WPS-B-T-2332-Tc-P5-F.

SAW welding of weld joint 3A located on PCMK NSD1-FASA3-1A/E.
Welder is identified as Mr. Xu Xiushui (053869). ZPMC QC is identified as Jin Dong Liang.
The welding variables recorded by QC appeared to comply with WPS-B-T-2221- B-U3c-S-2.

SAW welding of weld joint 4A located on PCMK NSD1-FASA3-1A/E.
Welder is identified as Mr. Zhang Suqin (209051). ZPMC QC is identified as Jin Dong Liang.
The welding variables recorded by QC appeared to comply with WPS-B-T-2221- B-U3c-S-2
WPS-B-T-2311-B-P3.

Bay 10

SAW welding of weld joint 004 located on PCMK SEG028*.

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Welder is identified as Mrs. Wang Min (044771). ZPMC QC is identified as Liu Fawen.
The welding variables recorded by QC appeared to comply with WPS-B-T-2221- B-L2c-S-2

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

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