

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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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-006211**Date Inspected:** 14-Apr-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1830**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Le Feng & Ma Yun**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**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 10

This QA inspector performed UT of approximately 10% 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 Lift 1 south tower diagonal stiffener with skin plate on corner seam B/C and stiffener splice on corner seam B/C. The weld designations reviewed are as follows:

1. SSD1-A111H/H-2, 4
2. SSD1-A164J/J-9~14, 45, 47~52

Please be advised UT was performed only on one side of butt joint face A side of weld, due to location of weld on stiffener.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Bay 10

This QA Inspector observed the following work in progress:

FCAW welding of weld joint 11 located on PCMK SSD1-FESA3-1B/D.

Welder is identified as Mr. Dai Xicheng (066012). ZPMC QC is identified as Mr. Chen Ying Xia.

The welding variables recorded by QC appeared to comply with WPS-B-T-2332-Tc-P5-F.

FCAW welding of weld joint 10 located on PCMK SSD1-FESA3-1B/D.

Welder is identified as Mr. Sun Jianguo (069075). ZPMC QC is identified as Mr. Chen Ying Xia.

The welding variables recorded by QC appeared to comply with WPS-B-T-2332-Tc-P5-F.

SAW welding of weld joint 18A located on PCMK NSD1-FBSA3-3A/C.

Welder is identified as Mr. Hua Guimei (050295). ZPMC QC is identified as Mr. Ma Yun.

The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-U3c-S-F.

Bay 11

SAW welding of weld joint 20 located on PCMK WSD1-FESA3-2A/B.

Welder is identified as Mrs. Shen Mei (041716). ZPMC QC is identified as Mr. Xu Le Feng.

The welding variables recorded by QC appeared to comply with WPS-B-T-2321-B-P3-S-2.

FCAW welding of weld joint 52 located on PCMK ESD1-FESA3-2B/C.

Welder is identified as Mr. Nie Baofeng (068864). ZPMC QC is identified as Mr. Li Ming.

The welding variables recorded by QC appeared to comply with WPS-B-T-2321-Tc-P5-F.

FCAW welding of weld joint 51 located on PCMK ESD1-FESA3-2B/C.

Welder is identified as Mr. Ye Bing (066733). ZPMC QC is identified as Mr. Li Ming.

The welding variables recorded by QC appeared to comply with WPS-B-T-2321-Tc-P5-F.

SMAW welding of weld joint 57A/B located on PCMK ESD1-FASA3-2E/G.

Welder is identified as Mr. Tang Yongqing (066028). ZPMC QC is identified as Mr. Xu Le Feng.

The welding variables recorded by QC appeared to comply with WPS-345-2G (2F)-Repair.

SMAW welding of weld joint 44B located on PCMK ESD1-FASA3-2E/E.

Welder is identified as Mr. Wang Yinsheng (040775). ZPMC QC is identified as Mr. Xu Le Feng.

The welding variables recorded by QC appeared to comply with WPS-345-2G (2F)-Repair.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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 Serge Sinevod 13482570045, 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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