

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-006288**Date Inspected:** 01-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:	Li Hong Fei & Wan Wen Zhong			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 Cross Beam and OBG Counterweight 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 5

CB202F-006-001,002

Bay 1

CW001B-PP018-001-003 CW001B-PP024-001-003 CW001B-PP026-001-003

CW001BPP028-001-003 CW001B-PP034-001-003

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This QA Inspector observed the following work in progress:

Bay 10

ZPMC's welding personnel is identified as Mrs. Liu Xianoyan (207745), Mrs. Zhang Lingling (207746) and Mrs. Hua Guimei (050295) performing groove welding of weld joint SSD1-FDSA3-1B/C-44B, SSD1-FDSA3-1B/C-64B and SSD1-FCSA3-1a/c-1A, 2A and 3A. The personnel were observed welding in the 1G (flat) position utilizing a Submerged Arc Welding (SAW) process. ZPMC QC identified Mr. Wan Wenzhong 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. Xu Xiuping (057244), Mr. Wang Kui (203977), Mr. Li Haishan (048784), Mrs. Dong Yuqin (053869) and Wang Qingbo (068501) perform FCAW welding on weld joints identified SSD1-SA164A/J-1 and 2. ZPMC QC identified Mr. Wan Wen Zhong 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-2332-TC-P4-T-2 and WPS-B-T-2331-TC-P4-T-2.

Bay 11

ZPMC's qualified welding personnel's are identified as Mr. Wang Yinsheng (040775) and Li Zhaoqian (048810) perform FCAW welding on weld joints identified ESD1-A164L/J-1 and 2. ZPMC QC identified Mr. Li Hong 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-2232-Tc-U5-F.

ZPMC's qualified welding personnel's are identified as Mr. Yang Zaihua (040669), Mr. Yang Zhaoyin (047470) and Mr. Xie Zhong Cheng (041271) perform SMAW welding on weld joint identified as WD1-A476-18M-1-2B, 3A, 5A and NDI-A476-77M-1-3A. ZPMC's QC identified Mr. Li Hong 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-3212-TC-U5b-1.

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

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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:	Clifford,William	QA Reviewer
