

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-006383**Date Inspected:** 20-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:	Li Hong Fei and You Qi Guo	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:

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 East Tower Lift 1. The weld designations reviewed are as follows:

Bay 11

1. C-D corner weld

Bay 10

This QA Inspector observed the following work in progress:

SAW welding of weld joint 19A located on PCMK NSD1-FESA3-1A/O.

Welder is identified as Mr. Wang Shougin (201750). ZPMC QC is identified as Mr. Zhang Huang.

The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-U3c-S-2.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

FCAW welding of weld joint 25A located on PCMK SSD1-FESA3-1B/D.

Welder is identified as Mr. Zhang Yigui (068627). ZPMC QC is identified as Mr. Ma Yun.

The welding variables recorded by QC appeared to comply with WPS-B-T-2231-Tc-U5-F.

FCAW welding of weld joint 29A located on PCMK SSD1-FESA3-1B/D.

Welder is identified as Mr. Yu Yonglai (048378). ZPMC QC is identified as Mr. Ma Yun.

The welding variables recorded by QC appeared to comply with WPS-B-T-2231-Tc-U5-F.

FCAW welding of weld joint 4A located on PCMK SSD1-FESA3-1B/D.

Welder is identified as Mr. Jiang Zhou (040261). ZPMC QC is identified as Mr. Ma Yun.

The welding variables recorded by QC appeared to comply with WPS-B-T-2231-Tc-U5-F.

FCAW welding of weld joint 17A located on PCMK SSD1-FESA3-1B/D.

Welder is identified as Mr. Xu Bo (040427). ZPMC QC is identified as Mr. Ma Yun.

The welding variables recorded by QC appeared to comply with WPS-B-T-2231-Tc-U5-F.

SMAW welding of weld joint 18 located on PCMK SSD1-A164H/J.

Welder is identified as Mr. Chen Qiqiong (056364). ZPMC QC is identified as Mr. Wen Zhong Wan.

The welding variables recorded by QC appeared to comply with WPS-B-T-3212-B-U2a-2.

SMAW welding of weld joint 134 located on PCMK SSD1-A164G/J.

Welder is identified as Mr. Chen Lian (053671). ZPMC QC is identified as Mr. Wen Zhong Wan.

The welding variables recorded by QC appeared to comply with WPS-B-T-3212-B-U2a-2.

SMAW welding of weld joint 16 located on PCMK SSD1-A164G/J.

Welder is identified as Mr. Chen Jizhong (052771). ZPMC QC is identified as Mr. Wen Zhong Wan.

The welding variables recorded by QC appeared to comply with WPS-B-T-3212-B-U2a-2.

FCAW welding of weld joint 17 located on PCMK SSD1-A164F/J.

Welder is identified as Mr. Huang Hongpei (037705). ZPMC QC is identified as Mr. Wen Zhong Wan.

The welding variables recorded by QC appeared to comply with WPS-B-T-4333-Tc-P4-F.

FCAW welding of weld joint 138 located on PCMK SSD1-A164D/J.

Welder is identified as Mr. Zhong Chongli (068554). ZPMC QC is identified as Mr. Wen Zhong Wan.

The welding variables recorded by QC appeared to comply with WPS-B-T-4333-Tc-P4-F.

Bay 11

FCAW welding of weld joint 110 located on PCMK WSD1-A115F/J.

Welder is identified as Mr. Liu Guoxuan (066279). ZPMC QC is identified as Mr. You Qi Guo.

The welding variables recorded by QC appeared to comply with WPS-B-T-4133.

FCAW welding of weld joint 96 located on PCMK WSD1-A115D/J.

Welder is identified as Mr. Zhu Lisheng (068765). ZPMC QC is identified as Mr. You Qi Guo.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

The welding variables recorded by QC appeared to comply with WPS-B-T-4133.

FCAW welding of weld joint 17 located on PCMK ESD1-FASA3-2C/E.

Welder is identified as Mr. Zhang Binghua (053316). ZPMC QC is identified as Mr. Li Hong Fei.

The welding variables recorded by QC appeared to comply with WPS-B-T-4332-Tc-P4-F.

During the observation of shop work in progress, this QA Inspector noted Shear Plate SD1-20 has been sandblasted for coating and return to shop. QA Inspector observed ABF QC had rejected the noted member due to defects (gouges, pin holes on weld face and rough edges) at various areas.

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
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Reviewed By:	Carreon,Albert	QA Reviewer
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