

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-006501**Date Inspected:** 29-Apr-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Lin and Chen Ying Xin**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 MT of approximately 15% and VT 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 Lift 2 South Tower corner seam C/D and C/B. The weld designations reviewed are as follows:

Bay 10

1. SSD1-TL5B/L-3A and 4A

This QA Inspector observed the following work in progress:

SMAW welding of weld joint 9 located on PCMK SSD1-FESA3-1C/D.

Welder is identified as Mr. Xue Songyu (205524). ZPMC QC is identified as Mr. Chen Ying Xin.

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

SMAW welding of weld joint 9 located on PCMK SSD1-FESA3-1C/D.

Welder is identified as Mr. Wang Yungquan (057259). ZPMC QC is identified as Mr. Chen Ying Xin.

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

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

SMAW welding of weld joint 11 located on PCMK ED1-A27A/E.

Welder is identified as Mr. Guo Liang (057247). ZPMC QC is identified as Mr. Wang Chuanding.

The welding variables recorded by QC appeared to comply with WPS-B-T-2312-Tc-P5-F.

SMAW welding of weld joint 12 located on PCMK ED1-A27A/E.

Welder is identified as Mr. Zang Weili (040570). ZPMC QC is identified as Mr. Wang Chuanding.

The welding variables recorded by QC appeared to comply with WPS-B-T-2312-Tc-P5-F.

FCAW welding of weld joint 21 located on PCMK WD1-A28A/B.

Welder is identified as Mr. Zhang Jihua (066482). ZPMC QC is identified as Chen Ying Xin.

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

Bay 11

SMAW welding of weld joint 5A/B located on PCMK ESD1-T17H/L.

Welder is identified as Mr. Yang Zhaoyin (047470). ZPMC QC is identified as Mr. Li Le.

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

SMAW welding of weld joint 25B located on PCMK ESD1-FESA3-2B/D.

Welder is identified as Mr. Xie Zhong Cheng (047470). ZPMC QC is identified as Mr. Li Le.

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

SMAW welding of weld joint 29A located on PCMK ESD1-FESA3-2B/D.

Welder is identified as Mr. Zhu Zeyuan (053916). ZPMC QC is identified as Mr. Li Le.

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

Assembly area behind Tower Bay

This QA Inspector observed ZPMC welders Yan Shitian (062708) and Mr. Guo Xingyui (048619) welding on OBG Segment 5AW. ZPMC QC Inspector was not present at the time of work. QA Inspector issued an incident report on this date for the welding observed.

Bay 12

This QA Inspector observed ZPMC welder Mr. Hu Yongcang (203805) welding on Deck Panel DP471-001 (8BE) in OBG Assembly Shop (Bay 12). ZPMC QC Inspector was not present at the time of work. QA Inspector issued an incident report on this date for the welding observed.

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 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
