

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-006502**Date Inspected:** 30-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% 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 1AAW and 1AAE segment welds. The weld designations reviewed are as follows:

Bay 2

1AAW

1. SEG1F-002,005 2. SEG1E-124, 334 3. SEG1D-004,086

1AAE

1. SEG2F-002,005 2. SEG2E-124, 334 3. SEG2C-004,086

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Bay 10

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 North Tower Lift 3 Skin D stiffeners D1~D4. The weld designations reviewed are as follows:

1. NSD1-FESA3-1B/C-50/21/24/25/26 A/B
2. NSD1-FESA3-1B/C-56/42/45/46/47 A/B
3. NSD1-FESA3-1B/C-53/35/38/39/40 A/B
4. NSD1-FESA3-1B/C-52/28/31/32/33 A/B

Bay 2

This QA Inspector observed the following work in progress:

SMAW welding of weld joint 077 located on PCMK SEG1D-001.

Welder is identified as Mr. Wang Fupeng (205718). ZPMC QC is identified as Mr. Wuz Zhi Cheng.
The welding variables recorded by QC appeared to comply with WPS-B-P-2214-Tc-U4b.

Bay 10

SMAW welding of weld joint 29B located on PCMK NSD1-FESA3-1E/E.

Welder is identified as Mr. Zhang Ronghong (205908). ZPMC QC is identified as Mr. Chen Ying Xin.
The welding variables recorded by QC appeared to comply with WPS-B-T-2212-Tc-P4-F.

SMAW welding of weld joint 29B located on PCMK NSD1-FESA3-1E/E.

Welder is identified as Mr. Zhao Bin (206568). ZPMC QC is identified as Mr. Chen Ying Xin.
The welding variables recorded by QC appeared to comply with WPS-B-T-2212-Tc-P4-F.

SMAW welding of weld joint 18 located on SSD1-FESA3-1D/D.

Welder is identified as Mr. Dong Jianuan (040345). 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 18 located on SSD1-FESA3-1D/D.

Welder is identified as Mr. Li Haishan (048784). 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.

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SAW welding of weld joint 1B located on ESD1-FASA3-2A/E.

Welder is identified as Mrs. Yang Meizhen (042195). ZPMC QC is identified as Mr. Li Le.

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

SAW welding of weld joint 7A located on ESD1-FASA3-2A/E.

Welder is identified as Mr. Shen Mei (041716). ZPMC QC is identified as Mr. Li Le.

The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-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
