

**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-006746**Date Inspected:** 11-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Tu Jun and Zhang Yaxu**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 10% of OBG 3AW+3BW welds previously accepted by ZPMC ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3. The QA Inspector observed a rejectable indication at the time of testing. The QA Inspector generated a TL-6027 UT report on this date. Welds UT verified was identified as listed below:

**OBG Assembly Yard**

## 1. OB3A-003

This QA Inspector observed a Class A discontinuity present in the weldment accepted by ZPMC QC UT personal. This QA Inspector issued an incident report on the above noted UT rejection.

**Bay 10**

SMAW welding of weld joint 82B located on SSTL3-1B/K.

Welder is identified as Mr. Li Pan Pan (057239). ZPMC QC is identified as Mr. Tu Jun.

The welding variables recorded by QC appeared to comply with WPS-B-T-2214-Tc-U4b.

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SMAW welding of weld joint 82B located on SSTL3-1B/K.

Welder is identified as Mr. Zhang Songtin (057186). ZPMC QC is identified as Mr. Tu Jun.

The welding variables recorded by QC appeared to comply with WPS-B-T-2214-Tc-U4b.

SAW welding of weld joint 58 located on SSD1-FASA4-1A/E.

Welder is identified as Mr. Zhang Lingling (207740). ZPMC QC is identified as Mr. Su Zhengrou.

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

Bay 3

SMAW welding of weld joint 021 located on FB012-024.

Welder is identified as Mr. Yang Xuhe (057795). ZPMC QC is identified as Mr. Zhang Yaxu.

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

SMAW welding of weld joint 013 and 014 located on FB003-018.

Welder is identified as Mr. Wu Wanyong (050242). ZPMC QC is identified as Mr. Zhang Yaxu.

The welding variables recorded by QC appeared to comply with WPS-B-T-2132-3.

Bay 3

SMAW welding of weld joint 003~006 located on SP202-012-001.

Welder is identified as Mr. Sun Daolan (250833). ZPMC QC is identified as Mr. Wu Zhifeng.

The welding variables recorded by QC appeared to comply with WPS-B-P-2112.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents. QA Inspector issued an incident report on this date for the welding observed.

### 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.

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<b>Inspected By:</b>	Alaniz, Joe	Quality Assurance Inspector
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<b>Reviewed By:</b>	Carreon, Albert	QA Reviewer
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