

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-006773**Date Inspected:** 14-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

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|------------------------------------|----------------------------|-----------|------------|----------------------------------|---------------|-----------|------------|
| CWI Name: | You Qi Guo and Su Zhenrong | | | 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 UT of approximately 10% 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 South and North Tower 116M Diaphragm. The weld designations reviewed are as follows:

Bay 6

1. SSD1-DPSA-16-4A (B) and 7A (B)
2. SSD1-DPSA-16-4A (B) and 6A (B)

Bay 10

SMAW welding of weld joint 41 and 42 located on ND1-A468-43M.

Welder is identified as Mr. Li Jixiang (053829). ZPMC QC is identified as Mr. Su Zhenrong.

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

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SMAW welding of weld joint 35 located on ND1-A468-43M.

Welder is identified as Mr. Sun Guanping (050289). ZPMC QC is identified as Mr. Su Zhenrong.

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

SAW welding of weld joint 50C located on SSD1-FCSA4-1A/C.

Welder is identified as Mr. Zhang Lingling (207746). ZPMC QC is identified as Mr. Tu Jun.

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

Bay 11

FCAW welding of weld joint 5A located on WSD1-TL6B/C.

Welder is identified as Mr. Li Shoufu (066674). ZPMC QC is identified as Mr. You Qi Guo.

The welding variables recorded by QC appeared to comply with WPS-B-T-2231-B-U2-F.

FCAW welding of weld joint 5A located on WSD1-TL6B/C.

Welder is identified as Mr. Zhang Liang (067036). ZPMC QC is identified as Mr. You Qi Guo.

The welding variables recorded by QC appeared to comply with WPS-B-T-2231-B-U2-F.

SAW welding of weld joint 4A located on WSD1-TL6B/L.

Welder is identified as Mrs. Cao Xiaohua (056975). ZPMC QC is identified as Mr. Tu Jun.

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

SAW welding of weld joint 4A located on WSD1-TL6B/L.

Welder is identified as Mrs. Cao Guimei (047304). ZPMC QC is identified as Mr. You Qi Guo.

The welding variables recorded by QC appeared to comply with WPS-B-T-2221-C-U2b-S-2.

FCAW welding of weld joint 90B located on WSD1-A115E/J.

Welder is identified as Mr. Li Zhaoqian (043810). ZPMC QC is identified as Mr. You Qi Guo.

The welding variables recorded by QC appeared to comply with WPS-B-T-2332-Tc-U4b-F.

FCAW welding of weld joint 4 located on ESD1-SA45-2A/B.

Welder is identified as Mr. Nie Baofeng (068864). ZPMC QC is identified as Mr. You Qi Guo.

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

FCAW welding of weld joint 3 located on ESD1-SA45-2A/B.

Welder is identified as Mr. Zhang Xinmin (066484). ZPMC QC is identified as Mr. You Qi Guo.

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

SMAW welding of weld joint 17 and 18 located on ND1-A468-38M-1.

Welder is identified as Mr. Zhu Zeyuan (053916). ZPMC QC is identified as Mr. You Qi Guo.

The welding variables recorded by QC appeared to comply with WPS-B-T-2113.

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OBG Assembly Yard

ZPMC's welding personnel Mr. Zhang Cheng (209664) was observed tack welding plates in the 3G position on OBG 2AE Diaphragm PP13.50 (OBG Assembly Yard). QA Inspector asked for welder's qualification card to verify position qualified. QA Inspector noted welder was qualified in the 2F position and not the 3G position. QA Inspector observed that ZPMC CWI Quality Control (QC) Inspector was not present during the welding operations in area during the time of QA observations from 0350 to 0430.

This QA Inspector issued an incident report on the above noted noncompliance issue.

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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| Inspected By: | Alaniz,Joe | Quality Assurance Inspector |
| Reviewed By: | Carreon,Albert | QA Reviewer |
