

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-006776**Date Inspected:** 18-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:** Wan Wenzhong**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 limited VT of OBG Segment 2AW to 2BW weld splice prep. Several areas at Side panel to Edge plate on counter weight side had 7.5mm to 10mm root opening. Also opposite side on the Interior Cross beam, weld seam had 7mm to 8mm root openings. QA Inspector Umesh Gaikwad had issued an incident report for the above noted issues for today's work shift.

Due to welding in progress of the weld joint, limited recording of root opening was performed.

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 Tower Lift 4 Skin C&B and North Tower base shear plate. The weld designations reviewed are as follows:

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1. SSD1-FCSA4-1A/C-58, 61A/B
2. SSD1-FBSA4-1A/C-15A/B
3. SSD1-FBSA4-1A/C-7A/B

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4. NSD1-A112B/H-49, 50, 68A/B

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FCAW welding of weld joint 3A located on NSD1-A112B/H.

Welder is identified as Mr. Zhang Yigui (048627). ZPMC QC is identified as Mr. Wan Wenzhong.

The welding variables recorded by QC appeared to comply with WPS-B-T-2232-Tc-U4b-F.

FCAW welding of weld joint 2B located on NSD1-A112B/H.

Welder is identified as Mr. Jiang Zhou (040261). ZPMC QC is identified as Mr. Wan Wenzhong.

The welding variables recorded by QC appeared to comply with WPS-B-T-2232-Tc-U4b-F.

SMAW welding of weld joint 74 located on NSD1-FASA4-1A/E.

Welder is identified as Mr. Shi Xingyu (052930). ZPMC QC is identified as Mr. Wan Wenzhong.

The welding variables recorded by QC appeared to comply with WPS-B-P-4211-B-U2b-2.

OBG Assembly Yard

ZPMC's welding personnel Mr. Bai Jinhu (067756) was observed welding Internal Cross Beam to OBG Segment 3AW. QA Inspector observed that ZPMC CWI Quality Control (QC) Inspector was not present during the welding operations at noted location during the time of QA observations from 0115 to 0210.

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.

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
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Reviewed By:	Carreon, Albert	QA Reviewer
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