

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-006777**Date Inspected:** 19-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: | Wan Wenzhong and Yun Xiao | 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:

Bay 10

FCAW welding of weld joint 29 located on NSD1-FDSA3-1B/C.

Welder is identified as Mr. Dong Changxi (070046). ZPMC QC is identified as Mr. Li Ming.

The welding variables recorded by QC appeared to comply with WPS-B-T-2232-Tc-P5-F.

FCAW welding of weld joint 43 located on NSD1-FDSA3-1B/C.

Welder is identified as Mr. Zhang Hua (068206). ZPMC QC is identified as Mr. Li Ming.

The welding variables recorded by QC appeared to comply with WPS-B-T-2232-Tc-P5-F.

FCAW welding of weld joint 30 located on NSD1-FDSA3-1B/C.

Welder is identified as Mr. Zhang Xinmin (066484). ZPMC QC is identified as Mr. Li Ming.

The welding variables recorded by QC appeared to comply with WPS-B-T-2232-Tc-P5-F.

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Bay 11

FCAW welding of weld joint 1~91 located on SSD1-SA79-A/B.

Welder is identified as Mr. Liao Yanfei (066398). ZPMC QC is identified as Mr. Yun Xiao.

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

FCAW welding of weld joint 1~91 located on SSD1-SA79-A/B.

Welder is identified as Mr. Wang Rucheng (066881). ZPMC QC is identified as Mr. Yun Xiao.

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

SAW welding of weld joint 29B located on WSD1-FBSA4-2A/C.

Welder is identified as Mrs. (047304). ZPMC QC is identified as Mr. Xiao Yun.

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

SAW welding of weld joint 8A located on ESD1-FCSA4-2A/C.

Welder is identified as Mrs. Xia Wenying (044558). ZPMC QC is identified as Mr. Xiao Yun.

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

SMAW welding of weld joint 4A (B) located on WDS1-FASA4-2A/E.

Welder is identified as Mr. Chen Kang (206195). ZPMC QC is identified as Mr. You Qi Guo.

The welding variables recorded by QC appeared to comply with WPS-B-T-4211-U3b.

OBG Assembly Yard

SMAW welding of weld joint 020, 022 and 024 located on SP226.

Welder is identified as Mr. Dong Haitao (067183). ZPMC QC is identified as Mr. Li Jia.

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

FCAW welding of weld joint 077, 079, 081 and 083 located on SP222A.

Welder is identified as Mr. Li Shoufu (066674). ZPMC QC is identified as Mr. Li Jia.

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

QA Inspector noted ZPMC approved welder Mr. Bai Jinhu (067756) performing the welding (4F) at weld joint SP222-064, 066 and 068 per WPS-B-P-2214-Tc-U4b-FCM with welding consumable THJ506Fe-1 classification. Heating container for electro rods was not plugged into a power supply and therefore not providing the required continuous heating.

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.

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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 |
