

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-007205**Date Inspected:** 14-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Zhong Hai and Liu Fa Wen	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:	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 14

FCAW welding of weld joints 042, 046, 052 and 054 on DP310-001.

Welder is identified as Mr. Wen Chao (069860). ZPMC QC is identified as Mr. Zhu Zhong Hai.

The welding variables recorded by QC appeared to comply with WPS-B-T-2133.

FCAW welding of weld joints 068, 073, 078 and 081 on DP310-001.

Welder is identified as Mr. Gao Mi (050988). ZPMC QC is identified as Mr. Zhu Zhong Hai.

The welding variables recorded by QC appeared to comply with WPS-B-T-2133.

SMAW welding of weld joints 130 and 137 located on SSD12-PP58.

Welder is identified as Mr. Wang Fupeng (205718). ZPMC QC is identified as Mr. Shen Fu You.

The welding variables recorded by QC appeared to comply with WPS-B-P-2214-Tc-U2.

SMAW welding of weld joint 047 located on SP761.

Welder is identified as Mr. Liu Qingyong (066479). ZPMC QC is identified as Mr. Shen Fu You.

The welding variables recorded by QC appeared to comply with WPS-B-P-2214-Tc-U2.

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SMAW welding of weld joint 046 located on SEG035.

Welder is identified as Mr. Li Jun (051348). ZPMC QC is identified as Mr. Shen Fu You.

The welding variables recorded by QC appeared to comply with WPS-B-P-2214-Tc-U5b.

SMAW welding of weld joints 107 and 106 located on SEG031H.

Welder is identified as Mr. Hao Jianxiang (067665). ZPMC QC is identified as Mr. Shen Fu You.

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

Bay 13

FCAW welding of weld joint 003 on CA047.

Welder is identified as Mr. Wu Wanyong (050242). ZPMC QC is identified as Mr. Zhu Zhong Hai.

The welding variables recorded by QC appeared to comply with WPS-B-T-2231-Tc-U4b-F.

FCAW welding of weld joint 003 on CA047.

Welder is identified as Mr. Pan Meng (066673). ZPMC QC is identified as Mr. Zhu Zhong Hai.

The welding variables recorded by QC appeared to comply with WPS-B-T-2233-Tc-U4b-F.

FCAW welding of weld joint 002 on SEG046C.

Welder is identified as Mr. Hong Yongli (044801). ZPMC QC is identified as Mr. Zhu Zhong Hai.

The welding variables recorded by QC appeared to comply with WPS-B-T-2231-Tc-U4b-F.

Bay 19

FCAW welding of weld joints 004 located on SB001-010.

Welder is identified as Mr. Feng Hulong (062778). ZPMC QC is identified as Mr. Liu Fa Wen.

The welding variables recorded by QC appeared to comply with WPS-B-T-2232-Tc-U5-F.

FCAW welding of weld joints 004 located on SB004-010.

Welder is identified as Mr. Chang Shan hao (062763). ZPMC QC is identified as Mr. Liu Fa Wen.

The welding variables recorded by QC appeared to comply with WPS-B-T-2232-Tc-U5-F.

Outside Bay 13 Segment 6CE

QA Inspector observed during random in-process inspection of SMAW repair welding of SPCM weld joint #SEG023B-026 performed by ZPMC welder Zhao Guanglin (044779) that preheating of joint (30mm material) was not performed or verified by a ZPMC QC Inspector prior to the welding.

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.

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