

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-007207**Date Inspected:** 16-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:** C.M. Chen and Shen Fu You**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 joint 019 on SEG041*.

Welder is identified as Mr. Wang Chaili (045203). ZPMC QC is identified as Mr. Shen Fu You.

The welding variables recorded by QC appeared to comply with WPS-B-T-2233-B-U2.

FCAW welding of weld joints 072 and 071 on DP119-002.

Welder is identified as Mr. Jia Guang Fu (069089). ZPMC QC is identified as Mr. Shen Fu You.

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

FCAW welding of weld joint 013 on SEG039*.

Welder is identified as Mr. (202122). ZPMC QC is identified as Mr. Shen Fu You.

The welding variables recorded by QC appeared to comply with WPS-B-T-2233-B-U2.

SMAW welding of weld joint 198 located on SSD14A-PP53.

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

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

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Bay 13

SMAW welding of weld joints 061, 062, 066, 067, 082 and 083 on DP255.

Welder is identified as Mr. Kua Wenshen (054013). ZPMC QC is identified as Mr. C.M. Chen.

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

SMAW welding of weld joints 131 on SSD13-PP67.

Welder is identified as Mr. Bai Jinhu (067756). ZPMC QC is identified as Mr. C.M. Chen.

The welding variables recorded by QC appeared to comply with WPS-B-P-2114-Tc-U4b.

SMAW welding of weld joint 127 on SSD19A-PP66.

Welder is identified as Mr. Zhao Aifei (067942). ZPMC QC is identified as Mr. C.M. Chen.

The welding variables recorded by QC appeared to comply with WPS-B-P-2114-Tc-U4b.

FCAW welding of weld joint 005 on SEG043A.

Welder is identified as Mr. Zhao Shanlun (066683). ZPMC QC is identified as Mr. C.M. Chen.

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

FCAW welding of weld joint 020 on SEG043A.

Welder is identified as Mr. Pan Meng (066673). ZPMC QC is identified as Mr. C.M. Chen.

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

Bay 13

QA Inspector observed run off tabs at both ends of butt joint was not removed prior to the UT inspection performed and accepted by ZPMC UT Inspector Su Wei on 06-07-2009. QA Inspector issued an incident report on this date for the issue 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.

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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
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Reviewed By:	Carreon,Albert	QA Reviewer
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