

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-007349**Date Inspected:** 17-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:	Zhu Zhong Hai and Li Yan Hua			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

SMAW welding of weld joint 031 on SEG040A*.

Welder is identified as Mr. Li Aijun (037996). ZPMC QC is identified as Mr. Li Yan Hua.

The welding variables recorded by QC appeared to comply with WPS-B-T-2114-FCM.

SMAW welding of weld joint 031 on SEG040A*.

Welder is identified as Mr. Zhang Shan Hao (067609). ZPMC QC is identified as Mr. Li Yan Hua.

The welding variables recorded by QC appeared to comply with WPS-B-T-2114-FCM.

SMAW welding of weld joints 041, 050, 073 and 096 on SEG031J.

Welder is identified as Mr. He Junrong (201215). ZPMC QC is identified as Mr. Shen Fu You.

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

SMAW welding of weld joint 006 on SEG061A.

Welder is identified as Mr. He Junrong (201215). ZPMC QC is identified as Mr. Shen Fu You.

The welding variables recorded by QC appeared to comply with WPS-B-T-2211-B-U2-FCM-1.

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SAW welding of weld joint 004 on SEG051A*.

Welder is identified as Mrs. Xu Peipei (050323). ZPMC QC is identified as Mr. Shen Fu You.

The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-L2c-S-2.

FCAW welding of weld joints 017~186 located on DP173-001.

Welder is identified as Mr. Wen Chao (069866). ZPMC QC is identified as Mr. Zhu Zhong Hai.

The welding variables recorded by QC appeared to comply with WPS-B-T2133.

FCAW welding of weld joints 017~186 located on DP173-001.

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

The welding variables recorded by QC appeared to comply with WPS-B-T2133.

Bay 13

SMAW welding of weld joints 131 on SSD13-PP66.

Welder is identified as Mr. Bai Jinhua (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-PP65.

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 133 on SSD12-PP64.

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-2233-B-U2-F.

FCAW welding of weld joint 014 on SSD12A-PP64.

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-2233-Tc-U4b-F.

FCAW welding of weld joint 016 on SEG047B.

Welder is identified as Mr. Yuan Wen Song (055491). ZPMC QC is identified as Mr. C.M. Chen.

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

FCAW welding of weld joint 016 on SEG047B.

Welder is identified as Mr. Hong Yongli (044801). ZPMC QC is identified as Mr. C.M. Chen.

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

FCAW welding of weld joint 016 on SEG047B.

Welder is identified as Mr. Hong Yongli (044801). ZPMC QC is identified as Mr. C.M. Chen.

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

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FCAW welding of weld joint 105 on SSD16A-PP68.

Welder is identified as Mr. Cao Xiang Long (069683). ZPMC QC is identified as Mr. C.M. Chen.

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

Bay 19

FCAW welding of weld joint 105 on SB001-010.

Welder is identified as Mr. Zhang 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-2132.

FCAW welding of weld joints 26 and 32 on SB004-010.

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-2132.

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.

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