

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-007353**Date Inspected:** 20-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:	Shen Fu You and Lu Li Qing	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

SAW welding of weld joint 001 on SEG047*.

Welder is identified as Mrs. Lu Shiqin (044755). 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.

SMAW welding of weld joint 004 on SEG048*.

Welder is identified as Mr. Li Jiao (049861). 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.

FCAW welding of weld joint 134 on SSD13A-PP60.

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-2231-U2-F.

FCAW welding of weld joint 138 on SSD13A-PP60.

Welder is identified as Mr. Ge Hao (201583). ZPMC QC is identified as Mr. Shen Fu You.

The welding variables recorded by QC appeared to comply with WPS-B-T-2231-U2-F.

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FCAW welding of weld joint 018 on SEG055A.

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-2231-U2-F.

Bay 13

SMAW welding of weld joint 005 on SEG043.

Welder is identified as Mr. Ren Jinzhu (044837). ZPMC QC is identified as Mr. Lu Li Qing.

The welding variables recorded by QC appeared to comply with WPS-B-T-2214-Tc-U4b-FCM-1.

SMAW welding of weld joint 020 on SEG043.

Welder is identified as Mr. Bai Jinhui (067756). ZPMC QC is identified as Mr. Lu Li Qing.

The welding variables recorded by QC appeared to comply with WPS-B-T-2214-Tc-U4b-FCM-1.

SMAW welding of weld joint 019 on SEG046*.

Welder is identified as Mr. Liang Yan Hai (066457). ZPMC QC is identified as Mr. Lu Li Qing.

The welding variables recorded by QC appeared to comply with WPS-B-T-2213-B-U2.

SMAW welding of weld joint 025 on SEG046*.

Welder is identified as Mr. Lu Xiao Jie (067904). ZPMC QC is identified as Mr. Lu Li Qing.

The welding variables recorded by QC appeared to comply with WPS-B-T-2213-B-U2.

FCAW welding of weld joint 007 on SSD11A-PP63.

Welder is identified as Mr. Jia Guangfu (066673). ZPMC QC is identified as Mr. Lu Li Qing.

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

Bay 19

FCAW welding of weld joints 021, 022, 027 and 028 on SB014-050.

Welder is identified as Mr. Xie Biwu (062787). 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 021, 022, 027 and 028 on SB014-050.

Welder is identified as Mr. Sun Ruidong (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 021, 022, 027 and 028 on SB015-062.

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 021, 022, 027 and 028 on SB015-062.

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.

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Bay 13

QA Inspector discovered the root opening of a web to flange fillet weld (SSD12A-PP64-009) at FB003-094 to be approximately 10 mm, exceeding the allowable tolerance per approved WPS-B-T-2233-Tc-U4b-F. 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.

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
