

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-007420**Date Inspected:** 24-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:** Wu Zhi Cheng**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:

OBG Assembly Yard

1AW to 1BW Segments

FCAW welding of weld joint 007 located on OBW1A.

Welder is identified as Mr. Li Shuliang (048801). ZPMC QC is identified as Mr. Wu Zhi Cheng.

The welding variables recorded by QC appeared to comply with WPS-345-FCAW-3G (3F)-FCM-Repair-1.

SMAW welding of weld joint 008 located on OBW1A.

Welder is identified as Mr. Jiang Zhen (068917). ZPMC QC is identified as Mr. Wu Zhi Cheng.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-1G (1F)-FCM-Repair-1.

1AW Segment

FCAW welding of weld joints 030, 031, 056 and 057 located on LD023.

Welder is identified as Mr. Zai Dawei (068091). ZPMC QC is identified as Mr. Wu Zhi Cheng.

The welding variables recorded by QC appeared to comply with WPS-B-T-2114-FCM-1 and

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WPS-B-P-2112-FCM-1.

1BW to 2BW Segment

SMAW welding of weld joints 025~036 located on BP303A-001.

Welder is identified as Mr. Lv Peng (048612). ZPMC QC is identified as Mr. Wu Zhi Cheng.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G (2F)-Repair-1.

Panel Point (PP) cope holes verification

QA Inspector performed random verification and documentation of cope holes on panel point members at various location on Segment 1AE (PP8 & PP9), 1BE (PP11), 2AE (PP15 & PP16) and 1AW (PP8, PP9.5 & PP11.5).

CALTRANS OSM Quality Assurance Inspector (QA) Mark Miller generated a photo file for further information.

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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