

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-007596**Date Inspected:** 27-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

4BW Segment

FCAW repair welding on edges of LD5E.

Welder is identified as Mr. Lu Yongyuan (202841). ZPMC QC is identified as Mr. Wu Zhi Cheng. The welding variables recorded by QC appeared to comply with WPS-345-FCAW-1G (1F)-Repair.

FCAW welding of weld joint 007 located on SEG017A.

Welder is identified as Mr. Li Shuqiang (053609). ZPMC QC is identified as Mr. Wu Zhi Cheng. The welding variables recorded by QC appeared to comply with WPS-345-FCAW-1G (1F)-Repair.

SMAW welding of weld joint 007 located on SEG017A.

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-1G (1F)-Repair.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

1AE Segment

SMAW welding of weld joint 018 located on DP736-001.

Welder is identified as Mr. Li Bio (050433). ZPMC QC is identified as Mr. Wu Zhi Cheng.

The welding variables recorded by QC appeared to comply with WPS-B-T-3213-B-U3b.

NDT Observation

QA Inspector observed ZPMC Ultra Sonic (UT) Technician perform the required UT testing and accepted of repaired work of LD10C in 5AW at panel point 28 & 29. (Time of inspection was approximately at 0800) Upon completion of the UT testing, ZPMC Magnetic Particle (MT) Technician began to perform the required MT inspection of the repair work of same above noted areas. (Time of inspection was approximately at 1025). Due to MT indications observed by ZPMC MT Technician, noted member was not ready for the required QA verification.

1AE Segment

During in process visual inspection of the fabrication of corner assemblies for OBG 1AE, Caltrans Quality Assurance (QA) Inspector discovered weld joint DP736-001-018, exceed the maximum weld size during the intermitted passes and final reinforcement weld. These areas have not been inspected or accepted by ZPMC Quality Control (QC) Inspectors. QA Inspector issued an incident report on this date for the welding observed.

Due to heavy rain on today's work shift, welding was limited in the OBG Trail Assembly Yard.

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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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
