

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-007602**Date Inspected:** 04-Jul-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:	Li Jia			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

4BE Segment

SMAW welding of weld joint 031 located on SEG020A.

Welder is identified as Mr. Li Wenguo (066261). ZPMC QC is identified as Mr. Wu Zhi Cheng.

The welding variables recorded by QC appeared to comply with WPS-B-P-2114-Tc-U4b-FCM-1.

SMAW welding of weld joint 031 located on SEG020A.

Welder is identified as Mr. Han Xiaofeng (054467). ZPMC QC is identified as Mr. Wu Zhi Cheng.

The welding variables recorded by QC appeared to comply with WPS-B-P-2114-Tc-U4b-FCM-1.

FCAW repair welding on edges of LD4BE.

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-3G (3F)-Repair and WRR-B-WR5962.

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FCAW repair welding on edges of LD4BE.

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-3G (3F)-Repair and WRR-B-WR5962.

1BE Segment

SMAW welding of weld joints 013~024 located on SP395-001.

Welder is identified as Mr. Yun Chengxian (045138). ZPMC QC is identified as Mr. Li Jia.

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

SMAW welding of weld joints 011~020 located on SP648-001.

Welder is identified as Mr. Liu Houkuan (045133). ZPMC QC is identified as Mr. Li Jia.

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

1AE

SMAW welding of weld joints 019~028 located on SP789-001.

Welder is identified as Mr. Liu Houkuan (045133). ZPMC QC is identified as Mr. Li Jia.

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

SMAW welding of weld joints 016~025 located on SP407A-001.

Welder is identified as Mr. Yun Chengxian (045138). ZPMC QC is identified as Mr. Li Jia.

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

4AE&4BE Segment

QA Inspector observed (approximately at 0745) welding of the Longitudinal Diaphragm (LD), in between panel point 25 & 26 was in progress. Completion of the welding (build up edges) on noted LD was completed at approximately at 1015. QA Inspector observed worker welding braces (technology struts) at weld SEG015A-007 to control distortion. Approximately at 1515 braces were removed from noted area.

4AW&4BW Segment

QA Inspector observed worker welding braces (technology struts) at weld SEG017A-007 to control distortion at approximately 1530.

NDT

This QA inspector performed Magnetic Particle (MT) testing of the LD in between panel point 22 and at 4BW & 4AW. QA Inspector observed a 13.5mm (approximately) indication on the surface of panel point 23 where the LD flange is butted and welded. QA Inspector informed ZPMC QA Mr. Wang Lu of the indication. QA Inspector generated an MT report for this date.

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QA Inspector observed ZPMC Magnetic Particle (MT) Technician perform the MT inspection and concord with the QA Inspector findings. Approximately at 1630 ZPMC approved welder ground out the indication. Area was then retested and accepted by ZPMC MT Technician. Upon accepting of the MT by ZPMC, welding personnel proceeded to reweld area.

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
