

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-007739**Date Inspected:** 12-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:** 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

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member(s) is/are identified as OBG X37A to I-Rib. The weld designations reviewed are as follows:

1. CA012-056/062
2. CA008-046/058
3. CA010-046/058
4. SEG020D-007

CB4 Segment

FCAW welding of weld joints 029, 031, 033 and 035 located on SP209-001.

Welder is identified as Mr. Cao Caijun (220064). ZPMC QC is identified as Mr. Wu Zhi Cheng.

The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

FCAW welding of weld joints 026, 028, 030 and 034 located on SP201-001.

Welder is identified as Mr. Li Shuqing (053609). ZPMC QC is identified as Mr. Wu Zhi Cheng.

The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

FCAW welding of weld joints 025, 027 and 029 located on SP202-001.

Welder is identified as Mr. Li Shuqing (053609). ZPMC QC is identified as Mr. Wu Zhi Cheng.

The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

5BE Segment

FCAW welding of weld joints 126 and 128 located on SP207-001.

Welder is identified as Mr. Cao Caijun (220064). ZPMC QC is identified as Mr. Wu Zhi Cheng.

The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

SMAW welding of weld joints 017, 019, 021 and 023 located on FB203-001.

Welder is identified as Mr. Lv Peng (048617). ZPMC QC is identified as Mr. Wu Zhi Cheng.

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

5BW Segment

SMAW welding of weld joint 042 located on SP203-001.

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-FCM-1.

SMAW welding of weld joints 042, 044, 04 and 048 located on SP203-001.

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-FCM-1.

1AE Segment

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.

1AE Segment

SMAW welding of weld joints 013~024 located on SP395A-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.

3BE Segment

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

QA Inspector observed ZPMC welder Dai Lu (048659) buttering end of Deck Plate stiffener (2nd from end on cross beam side) on Segment 3BE. A Weld Repair Report was not present at the time of work. Inspector issued an incident report on this date for the welding 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
