

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-007743**Date Inspected:** 16-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 and Xu Yumin	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 MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) is/are identified as OBG 3AE and 3BE. The weld designations reviewed are as follows:

1. CA006-046
2. CA004-034
3. CA002-038

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 3BE. The weld designations reviewed are as follows:

1. CA009-046, 058
2. CA007-034
3. CA011-086

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CB4 Segment

SMAW welding of weld joints 010 and 001 located on SEG023-PP33.

Welder is identified as Mr. Feng Changdou (067572). 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-F-1.

5AE Segment

FCAW welding of weld joint 128 located on FB022-001.

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-B-T-2232-C-U2-F.

SMAW welding of weld joints 018, 016 and 014 located on FB018-001.

Welder is identified as Mr. Gong Huaigang (037840). ZPMC QC is identified as Mr. Xu Yumin.

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

5BW Segment

SMAW welding of weld joints 001, 003, 005 and 007 located on FB025-001.

Welder is identified as Mr. Qie Jianzhou (067571). 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 & 5BE Segment

FCAW welding of weld joint 128 located on FB021-001.

Welder is identified as Mr. Lu Yongyuan (202841). ZPMC QC is identified as Mr. Li Jia.

The welding variables recorded by QC appeared to comply with WPS-B-P-2232-Tc-U4b-F-1.

3BE Segment

SMAW welding of weld joints 001 and 002 located on FB026-001.

Welder is identified as Mr. Hu Yanming (062092). ZPMC QC is identified as Mr. Wu Zhi Cheng.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair.

4BW Segment

SMAW welding of weld joint 004 located on SSD11-PP27.

Welder is identified as Mr. Lu Xianjie (067904). ZPMC QC is identified as Mr. Xu Yumin.

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

4BW Segment

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SMAW welding of stiffener ends located on DP35A- RS4A and 4C.

Welder is identified as Mr. Dai Lu (048659). ZPMC QC is identified as Mr. Xu Yumin.

The welding variables recorded by QC appeared to comply with WPS-485-SMAW-3G (3F)-Repair.

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
