

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-007833**Date Inspected:** 21-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:** 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 3B & 3A X37 corner assembly. The weld designations reviewed are as follows:

1. CA005-022 and 033
2. CA003-022 and 033
3. CA001-038 and 062

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 diverter plates. The weld designations reviewed are as follows:

1. OBW1B-022, 025, 026, 029, 006, 010
2. OBE1B-028, 031, 032, 001, 004, 027
3. OBW2C-029, 034, 039

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

- 4. OBW2B-032, 001, 006, 014, 015
- 5. OBE2B-027, 034, 035, 038, 039, 043, 026
- 6. OBW1C-011

2AE and 1BE Segment

SMAW repair welding at both sides of weld joint splice where dogs (jig attachment) were tacked onto the side plate at bike path side of OBG segment. Welder is identified as Mr. Feng Changdou (067572). ZPMC QC is identified as Mr. Cheng Xi. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair-1.

SMAW repair welding at both sides of weld joint splice where dogs (jig attachment) were tacked onto the side plate at crossbeam side of OBG segment. Welder is identified as Mr. Li Wenguo (066261). ZPMC QC is identified as Mr. Cheng Xi. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair-1.

3AW Segment

SMAW repair welding of bottom plate stiffeners between panel points 24 and 25. Welder is identified as Mr. Chen Zhen (220067). ZPMC QC is identified as Mr. Xu Yumin. The welding variables recorded by QC appeared to comply with WPS-345-FCAW-3G (3F)-Repair-1.

NDT Observation

QA Inspector observed ZPMC Magnetic Particle (MT) Technician performing MT on various locations in the trail assembly yard. Locations are as followed:

1. Side Plate stiffeners at panel point 18 on Segment 2BW (crossbeam side).

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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
---------------------	----------------	-------------