

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-008274**Date Inspected:** 22-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:**

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 1BW, OBG 2AW, OBG 2BW and OBG 3AW counter weight splice plate. The weld designations reviewed are as follows:

1. OBW1A-011, 013
2. OBW2A-011, 013
3. OBW2A-017
4. OBW3B-001

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 1BW, OBG 2AW, OBG 2BW and OBG 3AW counter weight splice plate. The weld designations reviewed are as follows:

1. OBW1A-011, 013
2. OBW2A-011, 013
3. OBW2A-017
4. OBW3B-001

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1AAW Segment

FCAW welding of spacer blocks at various locations on bottom plate.

Welder is identified as Mr. Ren Linsheng (066261). 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 spacer blocks at various locations on bottom plate.

Welder is identified as Mr. Wang Yueming (045284). ZPMC QC is identified as Mr. Wu Zhi Cheng.

The welding variables recorded by QC appeared to comply with WPS-B-P-2112-FCM-1.

SMAW welding of spacer blocks at various locations on side plate (crossbeam side of segment).

Welder is identified as Mr. Tian Zhaoquan (045246). ZPMC QC is identified as Mr. Wu Zhi Cheng.

The welding variables recorded by QC appeared to comply with WPS-B-P-2112-FCM-1.

2BE Segment

SMAW repair welding of bottom plate stiffeners located at panel point 18 (crossbeam side).

Welder is identified as Mr. Han Xiaofeng (054467). ZPMC QC is identified as Mr. Xu Yumin.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-3G (3F)-Repair-1.

SMAW repair welding of side plate stiffeners located at panel point 18 (crossbeam side).

Welder is identified as Mr. Li Wenguo (066261). ZPMC QC is identified as Mr. Xu Yumin.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-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. LD011 at panel point 23 on Segment 3BW (counter weight side).
2. LD012 at panel point 22 on Segment 3AW (counter weight side)

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

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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
