

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-008286**Date Inspected:** 12-Aug-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 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

4AE

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 4AE Diverter Plate. The weld designations reviewed are as follows:

1. Edge Plate Diverter Plate at PP26 Bike Path side.

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 4AE Diverter Plate. The weld designations reviewed are as follows:

1. Edge Plate Diverter Plate at PP26 Bike Path side.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

1AAE & 1AE

FCAW welding of weld joint 260 located on SEG2E.

Welder is identified as Mr. Jiang Yafei (045276). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-B-T-2213-B-U2-FCM-1.

SMAW welding of weld joint 004 located on OBE1.

Welder is identified as Mr. Zang Yanbo (045196). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-B-T-2214-B-U2-FCM-1

SMAW welding of weld joint 003 located on OBE1A.

Welder is identified as Mr. Tian Zhaoquan (045246). ZPMC QC is identified as Xu Yumin.

The welding variables recorded by QC appeared to comply with WPS-B-T-2214-B-U2-FCM-1.

SMAW welding of weld joint 002 located on OBE1A.

Welder is identified as Mr. Yang Changming (058242). ZPMC QC is identified as Xu Yumin.

The welding variables recorded by QC appeared to comply with WPS-B-P-2214-B-U2-FCM.

SMAW welding of weld joint 001 located on OBE1A.

Welder is identified as Mr. Zang Wei (066413). ZPMC QC is identified as Xu Yumin.

The welding variables recorded by QC appeared to comply with WPS-B-P-2214-B-U2-FCM.

2AE

SMAW welding of side plate bevel on edge located at panel point 13.

Welder is identified as Mr. Shen Zhihua (062772). ZPMC QC is identified as Mr. Li Jia.

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

2BE

SMAW welding of drip plate located at panel point 13 on bike path side.

Welder is identified as Mr. Qie Jian (067571). ZPMC QC is identified as Mr. Xu Yumin.

The welding variables recorded by QC appeared to comply with WPS-B-P-2214 and WPS-B-P-2213.

Incidents in Trail Assembly Yard

1. QA Inspector observed 2 welders welding at various locations on deck panel stiffeners on CB1 segment. QA Inspector observed that ZPMC CWI Quality Control (QC) Inspector or an approved WPS was not present during the welding operations at noted location during the time of QA observation.

2. QA Inspector observed 1 welder welding at various locations on OBG 2BW side plate edge (panel point 18 at counter weight side). QA Inspector observed that ZPMC CWI Quality Control (QC) Inspector or an approved WPS was not present during the welding operations at noted location during the time of QA observation.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

3. QA Inspector observed 1 welder welding at various locations on OBG 2AE side plate edge (panel point 13 at bike path side). QA Inspector observed that ZPMC CWI Quality Control (QC) Inspector or an approved WPS was not present during the welding operations at noted location during the time of QA observation.

QA Inspector issued an incident report on this date for the noted issues 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
