

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-008506**Date Inspected:** 15-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			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**1AE & 1BE**

SMAW welding of weld joint 007 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-345-SMAW-4G (4F)-Repair.

2AE

SMAW welding (repair) on horizontal stiffeners on panel point 16 cross beam connection.

Welder is identified as Mr. Wei Jun (067707). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G (2F)-Repair-FCM-1.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

SMAW welding (buttering ends) on bottom plate stiffeners on panel point 14.

Welder is identified as Mr. Wei Jun (067707). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-3G (3F)-Repair and repair procedure B-WR6858.

This QA Inspector observed heat straightening of LD panel member located in between panel point 15&16 on both side of side of segment. Work was performed per heat straightening procedure HSR (B)-312 and 316.

4AW

SMAW welding of weld joint 020 located on SEG017B.

Welder is identified as Mr. Zhang Xiaochong (220068). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G (2F)-Repair-1.

1AE

SMAW welding of weld joint 015 located on SEG2.

Welder is identified as Mr. Tian Zhaoquan (045246). ZPMC QC is identified as Li Jia.

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

SMAW welding of weld joint 004 located on SEG004A.

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-2214-B-U2-FCM-1.

NDT Observation

QA Inspector observed ZPMC Ultra Sonic (UT) Technician performing the testing on weld OBE1-003. QA Inspector noted weldment was rejected due to 5 discontinuities (Class A) present.

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