

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-008975**Date Inspected:** 21-Sep-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 and 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

5AE

FCAW welding of weld joint BKX1C located on 5AE at panel point 29.

Welder is identified as Mr. Zhang Hanming (220066). ZPMC QC is identified as Xu Yumin.

The welding variables recorded by QC appeared to comply with WPS-345-FCAW-3G (3F)-Repair and repair procedure B-WR7677.

1AAW & 1AW

SMAW welding of weld joint 002 located on OBW1.

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

The welding variables recorded by QC appeared to comply with WPS-345-FCAW-3G (3F)-FCM-Repair and repair procedure B-WR7662.

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1AAE & 1AE

FCAW welding of weld joints 175~188 located on OBE1.

Welder is identified as Mr. Yan Chuanshan (050316). ZPMC QC is identified as Xu Yumin.

The welding variables recorded by QC appeared to comply with WPS-B-T2132.

FCAW welding of weld joints 189~198 located on OBE1.

Welder is identified as Mr. Yan Ailong (067103). ZPMC QC is identified as Xu Yumin.

The welding variables recorded by QC appeared to comply with WPS-B-T2132.

SMAW welding of weld joints 071~074 located on OBE1.

Welder is identified as Mr. Yun Chengxian (045138). ZPMC QC is identified as Xu Yumin.

The welding variables recorded by QC appeared to comply with WPS-B-P-2113-FCM-1.

NDT Observation

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

1. Hold back welds on the side plate stiffeners (bike path) at various repair areas.

Miscellaneous Work In Progress

QA Inspector observed ZPMC's personnel performing various job functions in the trial assembly yard. Locations and description of work are as followed:

1. Welding of diverter plates on bike path side of segment at panel point 8.5.
2. Grit blasting of 2E (internal locations).
3. Setting up to perform a test fit up of cable tray on bottom plate (outside underneath on 1AE&1AAE).

1AAW & 1AW

This QA Inspector performed random MT inspection at repair work at weld OBE1-001 (UT reject excavations).

During the course of MT inspection, this QA Inspector observed various transverse linear indications in excavation areas. Transverse indications measurements were taken from cross beam side edge of segment and are as followed:

1. OBW1-001: Approximately 600mm
2. OBW1-001: Approximately 4140mm
3. OBW1-001: Approximately 10510mm
4. OBW1-001: Approximately 20350mm
5. OBW1-001: Approximately 20930mm
6. OBW1-001: Approximately 22650mm
7. OBW1-009: Approximately 24400mm

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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
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Reviewed By:	Carreon,Albert	QA Reviewer
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