

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-009201**Date Inspected:** 24-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

1AAE & 1AE

SMAW welding of weld joint 001 located on OBE1.

Welder is identified as Mr. Zang Yanbo (045196). ZPMC QC is identified as Xu Yumin.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-1G (1F)-Repair and repair procedure CWR761.

SMAW welding of weld joints 049, 050, 057 and 058 located on OBE1A.

Welder is identified as Mr. Li Bo (050433). ZPMC QC is identified as Li Jia.

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

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5AE

SMAW welding of weld joint 001 located on OBE1.

Welder is identified as Mr. Zang Yanbo (220069). ZPMC QC is identified as Xu Yumin.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-1G (1F)-Repair and repair procedure CWR761.

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. ZPMC MT technician performed MT at excavation on OBW1-004 UT reject (discontinuity). Y location is approximately 3023mm from cross beam side of segment 1W.
2. ZPMC MT technician performing MT on 5AE floor beam to diaphragm at panel point 29.

This QA Inspector observed ZPMC Ultra Sonic (UT) Technician performing UT on various locations in the trial assembly yard. Locations are as followed:

1. UT was performed on weld OBW1-001 (various locations) with a 45° wedge. Scanning “D” pattern was observed at time of UT inspection.

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. ZPMC workers removing grit from internal of segment 2E for coating process.
2. ZPMC worker performing the excavation on OBW1-004 UT reject (discontinuity). Y location is approximately 3023mm from cross beam side of segment 1W.
3. Grit blasting of various internal areas in segment 4W.
4. Grit blasting of various internal areas in segment 2W.

1AE & 1AAE

This QA Inspector observed areas UT on work shift 7-21-09 by ZPMC QC Dept had been excavated at noon. Caltrans was not notified to witness the excavation. Be advised a WRR was not present nor the engineer notified for the noted work. This QA Inspector issued an incident report on the work.

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

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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.

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| Inspected By: | Alaniz,Joe | Quality Assurance Inspector |
| Reviewed By: | Carreon,Albert | QA Reviewer |
