

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-009227**Date Inspected:** 26-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

2AW

SMAW plug welding of bottom plate stiffeners located between panel point 13 & 14.

Welder is identified as Mr. Li Guimin (220066). ZPMC QC is identified as Xu Yumin.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-1G (1F)-Repair- missdrilled holes and repair procedure CWR755.

2AE

This QA Inspector received a Radiographic Testing (RT) notification from ZPMC QC Department to select areas for RT to be performed. Three areas, per welds, were selected on weld joint SEG008*-069, 070, 071, 072, 073, 074 and 075.

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NDT Observation

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 5AE and 5BE repaired areas by ZPMC with a 70° transducer. Measurements were pulled from bike path edge of segment. Y locations and welds are as followed:

OBE1-004- 1950mm (rejected)

Measurements were pulled from OBE1-004 weld edge. Y locations and welds are as followed:

OBW1-003- 210mm (rejected)

OBW1-003- 11,060mm (rejected)

OBW1-003- 12,730mm (rejected)

OBW1-003- 17,130mm (rejected)

OBW1-003- 18,410mm (rejected)

Measurements were pulled from OBE1-003 weld edge. Y locations and welds are as followed:

OBW1-002- 900mm (rejected)

2. UT was performed on 5AW and 5BW repaired areas by ZPMC with a 70° transducer. Measurements were pulled from crossbeam edge of segment. Y locations and welds are as followed:

OBW1-004- 580mm (rejected)

OBW1-003- 3630mm (rejected)

Measurements were pulled from counter weight edge of segment. Y locations and welds are as followed:

OBW1-002- 1335mm (rejected)

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. Removal of backing bar on 5BW5-007, 008 and 009 deck plate weld seam at segment 5CW & 5BW.

2. Grinding weld profile on bike path cantilever BK1A welds 056, 053, 005 and 007.

2AW

This Quality Assurance (QA) Inspector observed repair work in progress of corner assembly (counter weight side) diaphragm stiffener in 2AW PP15 to adjust offset. During the course of welding, a CWR or WPS not present at the time of observation. 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.

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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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