

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-010229**Date Inspected:** 13-Nov-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 Yang**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

1AW

SMAW repair welding on weld joint 004 located at CA095 edge to deck plate (exterior on cross beam).

Welder is identified as Mr. Wu Haijun (201087). ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G (2F)-FCM-Repair-1 and CWR repair procedure #896.

Y Locations of excavations by above noted welder (201087) are located at approximately 16310 and 12515mm.

SMAW repair welding on weld joint 004 located at CA106 edge to deck plate (exterior on cross beam).

Welder is identified as Mr. Zang Yanbo (054013). ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G (2F)-FCM-Repair-1 and CWR repair procedure #896.

Y Locations of excavations by above noted welder (054013) are located at approximately 6980~7385mm and

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14810~21350mm.

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. Weld build up on deck and side plate stiffeners located on counter weight side of segment 1AAW+1AW per repair procedure CWR778 (Rev 1) and RFI 1904.

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:

UT reject excavation was performed at bottom plate weld joint on segment 1W cross beam side of segment. Y locations are as followed:

1. Y location 225mm, 400mm, 1180mm, 1340mm, 1425mm, 2186mm, 4580mm, 4590mm, 5850mm and 6830mm.

UT reject excavation was performed (11-12-09) at side plate weld joint on segment 1AW+ 1BW cross beam side of segment. Y locations are as followed:

1. Y location 2640mm, 3010mm and 3730mm.

MT Inspection was also performed and accepted by ZPMC on 11-12-09.

1AE

This QA Inspector observed transverse indications reported on 11-09-09 were repaired without an engineer approval or an approved CWR. Engineer was not notified of the removal of indications at weld OBE1-165 located on the Lateral Bracing fillet welds between I-Ribs (bottom plate) between panel points 8 and 8.5. This QA Inspector issued an incident report on the above noted issue.

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.

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Inspected By:	Alaniz,Joe	Quality Assurance Inspector
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Reviewed By:	Miller,Mark	QA Reviewer
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