

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-010231**Date Inspected:** 17-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

This QA inspector performed MT of approximately 15% of the repaired area previously tested and accepted by ZPMC Quality Control personnel. Punch List Item 1508 (Inspection request # 4658), deck and side plate stiffeners located on counter weight side of segment 1AAW+1AW per repair procedure CWR778 (Rev 1) and RFI 1904.

1AE+1BE

SMAW repair welding on weld joint 008 located at OBE1A bottom plate of segment.

Welder is identified as Mr. Zang Yanbo (045196). ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair-1 and CWR repair procedure #874.

Y Locations of excavations by above noted welder (045196) are located at approximately 5370, 6610 and 7265mm.

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2AE

SMAW repair welding on weld joint 004 located at CA100 edge to deck plate bike path side of segment. Welder is identified as Mr. Wu Haijun (201087). ZPMC QC is identified as Xu Yumin. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G (2F)-FCM-Repair-1 and CWR repair procedure #899.

Y Locations of excavations by above noted welder (045196) are located at approximately 2370, 8670~ 8750 and 8990~9170mm.

SMAW repair welding on weld joint 004 located at CA100 edge to deck plate bike path side of segment. Welder is identified as Mr. Zhao Guanglin (044779). ZPMC QC is identified as Xu Yumin. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G (2F)-FCM-Repair-1 and CWR repair procedure #899.

Y Locations of excavations by above noted welder (044779) are located at approximately 5335, 5100~ 5235 and 10650~10730mm.

6BE

SMAW welding on weld joint 001 located at CA014 cross beam side of segment. Welder is identified as Bi Shijian (068764). ZPMC QC is identified as Xu Yumin. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

6AE

SMAW welding on weld joint 043 located at SEG028 cross beam side of segment. Welder is identified as Bi Shijian (068764). ZPMC QC is identified as Xu Yumin. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

6BE+6AE

FCAW welding on weld joints 030, 032 and 034 located at SP307-001 side plate stiffeners on bike path side of segment. Welder is identified as Chen Zhenghua (220067). ZPMC QC is identified as Xu Yumin. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-B-U2-F.

SMAW welding on weld joint 023 located at DP635-001 side plate stiffeners on bike path side of segment. Welder is identified as Feng Huajun (066258). ZPMC QC is identified as Xu Yumin. The welding variables recorded by QC appeared to comply with WPS-B-T-3213-B-U3b.

Miscellaneous Work In Progress

NDT Observation

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QA Inspector observed ABF's personnel performing Magnetic Particle Testing (MT) inspection on repair areas per Request No 11162009-3. Locations and description of work are as followed:

1AW+1AAW

1. Deck plate weld joint OBW1-001 repair located at y locations 240, 670, 2630, 6120, 6140, 6750, 7160, 8110, 13340, 13470, 13550, 13780, 17040, 17750~19050 and 27540mm. This QA Inspector noted all noted areas were accepted by ABF.

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

2AE

1. Edge to deck plate excavation located on bike path side of segment. Y location 10720mm (4 transverse indications), 13160mm (1 transverse indications), 14620mm (1 transverse and linear indication), 15370mm, 15655mm, 15575mm, and 16060mm.

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
Reviewed By:	Miller,Mark	QA Reviewer
