

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-010639**Date Inspected:** 11-Dec-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

5CW+5BW

SMAW repair welding on weld joint 008 located at OB5W on deck plate.

Welder is identified as Mr. Feng Changdou (067572). ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G (4F) and WR # 8818.

6BW+6AW

FCAW welding on weld joint 001 located at OBW6 counter weight side of segment.

Welder is identified as Mr. Chen Zhenghua (220067). ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-B-T-B-U2-F.

FCAW welding on weld joint 005 located at OBW6 counter weight side of segment.

Welder is identified as Mr. Zhou Pan (220063). ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-B-T-B-U2-F.

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4AW

SMAW repair welding on weld joint 007 located at SEG017A counter weight side of segment. Welder is identified as Mr. Han Xiaofeng (054467). ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-B-T-2233T.

6BE+6CE

FCAW repair welding on weld joints 033, 034 and 032 located at SP427-001 side plate stiffeners on cross beam side. Welder is identified as Mr. Chang Hanming (220066). ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-B-U2-F.

6AW+6BW

SAW welding on weld joint 003 located at OBW6 deck plate weld seam. Welder is identified as Mr. Li Guimin (220069). ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-B-T-2234-B-U2-F.

4BE

SMAW repair welding on weld joint 007 located at SEG017A on bike path side of segment. Welder is identified as Mr. Feng Huajun (066258). ZPMC QC is identified as Wu Zhi Cheng. The welding variables recorded by QC appeared to comply with WPS-345-4G (4F)-FCM-Repair-1 and CWR repair procedure 904.

Y Location of excavation by above noted welder (066258) is located at 880mm, 940mm, 1080mm~1260mm.

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:

Excavation was performed on 2AE deck plate A10 at panel point 14.5 per WR8994 on cross beam side of segment

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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