

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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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-010734**Date Inspected:** 15-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 / Tower**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:

Tower Bay

This QA inspector performed MT of approximately 15% and VT of the area previously tested and accepted by ZPMC Quality Control personnel. The member(s) is/are identified as Lift 2 East Tower Miscellaneous plate on skin d, e, Lift 4 East Tower skin a~e to 116m diaphragm and fit lugs to diaphragm 116m. The QA Inspector generated a TL-6028 MT report on this date. The weld designations reviewed are as follows:

Lift 2

1. Campsa-2A/B-6 and 7

Lift 4

1. ESTL4-2B/L-29, 33, 35 23, 26, 151, 13, 9, 53, 49, 47, 41, 46, 36, 27, 10, 52, 43

OBG Assembly Yard

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6CE

SMAW repair welding on weld joints 030, 027 and 028 located at SP529-001 side plate stiffeners located on cross beam side of segment between panel point 46&45. Welder is identified as Mr. Kua Wenshan (054013). ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-3G (3F)-Repair-2, WPS-SMAW-2G (2F)-Repair-2 and WR8988.

2AE

During a random visual inspection, this QA inspector observed ZPMC Ultrasonic Testing (UT) technician performed and rejected excavation area on deck panel E5, identified as DP729A. This QA inspector noted ZPMC personnel preceded with drilling new hole at excavation area. This QA inspector issued an incident report for this issue.

Due to inclement weather work was limited in the trail assembly yard.

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
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Reviewed By:	Miller,Mark	QA Reviewer
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