

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-010760**Date Inspected:** 18-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

6CE+6BE

SMAW repair welding on X37 members (2ea) located between panel point 46&45 on the cross beam side of segment. 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+485-SMAW-3G (3F)-Repair.

6BW

SMAW welding on weld joints 45~55 located at BP032-001. Welder is identified as Mr. Li Shoufu (066674). ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

6AW

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SMAW welding on weld joints 45~55 located at BP086-001. Welder is identified as Mr. Li Shoufu (066674). ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

5AW+5BW

SMAW repair welding on bottom plate and side plate (cross beam side) t stiffeners at various locations. Welder is identified as Mr. Hu Yanming (062092). ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G (2F)-Repair-1.

SMAW repair welding on weld joint 002 located at OBW5A side plate on counter weight side of segment. Welder is identified as Mr. Dai Lu (048659). ZPMC QC is identified as Wu Zhi Cheng. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair-1 and CWR995.

6CE+6BE

SMAW welding on weld joint 005 located at OBE6C on bike path side of segment. Welder is identified as Mr. Qie Jianzhou (067571). ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-B-P-2114-B-U2-FCM-1.

SMAW welding on weld joint 005 located at OBE6C on bike path side of segment. Welder is identified as Mr. Li Wenguo (066261). ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-B-P-2114-B-U2-FCM-1.

SMAW welding on weld joint 005 located at OBE6C on bike path side of segment. Welder is identified as Mr. Zhao Aifei (067942). ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-B-P-2114-B-U2-FCM-1.

FCAW welding on weld joint 005 located at OBE6A on bike path side of segment. 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-2233-B-U2-F.

NDT Observation

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

5AW+5BW

1. Excavation on weld splice OBW5A-003 on the bottom plate of segment. Y location are approximately 640mm, 3670mm, 4730mm, 5740mm~ 7875mm (3 transverse indications) and 7890mm~8005mm.

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2. Excavation on weld splice OBW5A-002 on side plate counter weight of segment. Y location are approximately 1240mm~1240mm (1 transverse indication).

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:

6CE+6BE

1. Heat straightening in progress of side plate stiffeners on SP526B, SP566B and SP606B between panel points 40 and 41 per HSR1 (B)-8018.

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
