

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-010861**Date Inspected:** 28-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

6BW

Flux Core Arc Welding (FCAW) welding was performed on weld joint 002 located at CA027 on counter weight of segment. Welder is identified as Mr. Li Guimin (220069). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2234-C-U2-F.

6BW

Flux Core Arc Welding (FCAW) welding was performed on weld joint 006 located at CA025 on counter weight of segment. Welder is identified as Mr. Li Guimin (220069). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2234-C-U2-F.

5CE+5BE

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Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 009 located at OBE5A on cross beam side of segment. Welder is identified as Mr. Han Xiaofeng (054467). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by QC appeared to comply with WPS-345-SMAW-4G (4F)-Repair-1 and WR 9323 repair procedure.

5AE+5BE

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 004 located at OBE5 on bike path side of segment. Welder is identified as Mr. Han Xiaofeng (054467). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-4G (4F)-Repair-1 and CWR996 repair procedure.

Y Location of repairs area by above noted welder (054467) is located at 710mm and 820mm.

6AW

Shield Metal Arc Welding (SMAW) visual repair welding was performed on panel point 38 horizontal stiffeners located on cross beam side of segment. Welder is identified as Mr. Zhang Feng (049769). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-2G (2F)-Repair-1.

NDT Observation

QA Inspector observed ABF's personnel performing Magnetic Particle Testing (MT) inspection on repair areas. Locations and description of work are as followed:

5AW+5BW

1. Bottom plate weld splice t stiffeners hold back welds.

NDT Observation

QA Inspector observed ZPMC's personnel performing Ultra Sonic (UT) inspection on repair areas. Locations and description of work are as followed:

5CE+5BE

1. Side (bike path side) and deck plate repair areas on weld located on segment weld splice.

5CE+5BE

1. Bottom and deck plate repair areas on weld located on segment weld splice.

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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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