

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-010915**Date Inspected:** 31-Dec-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1600**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

BK001-024

Flux Core Arc Welding (FCAW) welding was performed on weld joints 005 and 007 located at BK001-023 on Cantilever member. Welder is identified as Mr. Zhou Pan (220063). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2233-Tc-U4b-F.

6AW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 043 located at SEG027* at cross beam side of segment. Welder is identified as Mr. Li Wenguo (066261). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2214-Tc-U4b-FCM-1.

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6BW

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 005 located on CA013 at cross beam side of segment. Welder is identified as Mr. Li Wenguo (066261). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-2214-Tc-U4b-FCM-1.

6BW+6CW

During random visual inspection of 6CW+6BW deck plate, Mechanical Straightening was being performed on misaligned areas on weld joint OBE6A-003 closest to cross beam side of segment with a HSR procedure present. Mechanical Straightening portable jacks fixtures are placed at Y locations 2800mm (DP113A), 5480mm (DP248A) and 7290mm (DP221A). Pressure was applied By ZPMC at noted Y locations above without heating areas. This QA Inspector issued an incident report for the noted issued.

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:

6BW+6CW

1. Observed tack welding being performed at bottom plate t stiffeners.

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. Deck plate weld joints OBW5-009 (cross beam side), OBW5-008 (center) and OBW5-007(counter weight side).

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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