

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-011410**Date Inspected:** 15-Jan-2010**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

This QA inspector performed MT of the repaired area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) is/are identified as Punch List Item 212. The weld designations reviewed are as follows:

5CE

1. 7Th stiffener on the bottom plate off the E4 line at panel point 37.

6BE+6AE

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 001 located at OBW6A deck plate weld joint. Welder is identified as Mr. Zhang Hanming (220066). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS345-SMAW-2G (2F)-FCM-1 and CWR #958 repair procedure.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

5CE

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 004 located at CA024 on bike path side of segment. Welder is identified as Mr. Sun Lingling (048047). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS345-SMAW-2G (2F)-FCM-1 and CWR #1075 repair procedure.

Y Location of repairs areas by above noted welder (048047) is located between 1520mm~1970mm.

5AE

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 004 located at CA016 cross beam side of segment. Welder is identified as Mr. Yun Chuansheng (045221). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS345-SMAW-4G (2F)-Repair-1.

Bay 14

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 003 located at CA092. Welder is identified as Mr. Wang Fupeng (205718). ZPMC QC is identified as Liu Hua Jie. The welding variables monitored and recorded by the QC appeared to comply with WPS345-SMAW-4G (2F)-Repair-1.

9BE

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 010 located at SSD17-PP075. Welder is identified as Mr. Hu Yauhong (049339). ZPMC QC is identified as Li Yang Hua. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-2G (2F)-Repair-1.

NDT Observation

This QA Inspector observed ZPMC Magnetic Particle (MT) Technician performing MT on various locations in the trial assembly yard. Locations are as followed:

Bay 19

1. Stiffeners on BP025-010-53 bottom plate member.

5BE

1. Excavation areas on edge to deck plate weld on counter beam side of segment. Y locations of excavations and numbers of MT Indications observed are as followed:

Y locations are 13030mm, 13200 (1 MT indications on base metal observed), 13500mm, 14600mm~14470mm and 14800mm~14795mm.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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
