

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-012020**Date Inspected:** 10-Feb-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:** Wu Zhi Cheng**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 approximately 15% of the 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 OBG 6AE pad eyes and Punch List Item 388. The weld designations reviewed are as follows:

OBG 6AE pad eyes

1. SSD16-PP38-260, 261
2. SSD16-PP40-260

Punch List Item 388 (5BW+5AW)

1. EP043-001-013/014
2. EP044-001-03/04

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6CW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 011 located at OBW6F on counter weight side of segment. Welder is identified as Mr. Jiang Jinyong (066361). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2214-Tc-U4b.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 011 located at OBW6F on counter weight side of segment. Welder is identified as Mr. Li Zhengxu (066179). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2214-Tc-U4b.

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 004 located at CA030 on bike path side of segment. Welder is identified as Mr. Yang Yunfeng (215553). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-2G (2F)-FCM-Repair-1 and CWR1139 R3 repair procedure.

7AW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 001 located at OBW7M on counter weight side of segment. Welder is identified as Mr. Zhao Aifei (067942). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2214-Tc-U4b.

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:

6BE

1. Excavations (UT reject areas) were performed on the edge plate to deck plate weld joint CA028-006 located on the bike path side of segment. Y locations are as followed: 10685mm and 10715mm.
2. Excavations (UT reject areas) were performed on the edge plate to deck plate weld joint CA030-004 located on the bike path side of segment. Y locations are as followed: 1760mm and 1795mm.

7AW

1. Heat straightening was performed on Longitudinal Diaphragm located on the counter weight side of segment per HSR (B)-8122.

Note:

Due to Chinese holiday, work was limited in the OBG Trail Assembly Yard on today's work shift.

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Welding was performed on weld joint OBW7M -001 by ZPMC approved welder 067942.



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 (150-0042-2372), who represents the Office of Structural Materials for your project.

Inspected By:	Alaniz,Joe	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer
