

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-012092**Date Inspected:** 18-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:** 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 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 5CE Holdback welds at panel point 37 counter weight side green tag #4. The weld designations reviewed are as follows:

OBG 5CE

1. SP422-001-021,022,029,030
2. SP564-001-029,030,039,040
3. SP604-001-029,030,039,040
4. SP425-001-021,022,029,030
5. SP333-001-025,026,035,036
6. SP360-001-025,026,035,036
7. SP306-001-029,030,041,042
8. BP166-001-025,026,035,036

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9. BP58-001-025,026,035,036

10. BP112-001-025,026,035,036

7AW+7BW

Shield Metal Arc Welding (SMAW) welding was performed on weld joints 037 and 038 located at SP124-001 on counter weight side of segment. Welder is identified as Mr. Jiang Zhen (068917). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2214-B-U2.

Shield Metal Arc Welding (SMAW) welding was performed on weld joints 037 and 038 located at SP518-001 on cross beam side of segment. Welder is identified as Mr. Cao Xinglong (069683). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2213-B-U2.

6CW

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 008 located at SEG03F on cross beam side of segment. Welder is identified as Mr. Du Hengyou (037743). 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)-FCM-Repair-1 and WR10630 repair procedure.

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:

7AW+6CW

1. LD16A and LD12B web to flange weld joint at bolt connection was cut due to misalignment per WR10693 located on the counter weight side of segment.

NDT Observation

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

6AW+6BW

1. Temporary attachment locations at side plate weld splice OBW6B-004. Y locations are as followed:

6AW side plate; 6800mm, 5725mm, 4880mm, 3445mm and 3215mm

6BW side plate; 3215mm

This QA Inspector observed ZPMC Ultra Sonic Testing (UT) Technician performed UT on various locations in the trial assembly yard. Locations are as followed:

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6CW

1. Counter weight connection plate weld joint OBW6F-011.

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 (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
