

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-013183**Date Inspected:** 27-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**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

7AE+7BE

Shield Metal Arc Welding (SMAW) repair welding was performed on deck plate weld joint 003 located at OBE7 bike path of segment. Welder is identified as Mr. Li Zhengxu (066361). 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)-FCM-Repair-1 and WR1345 repair procedure.

Y Location of repairs areas by above noted welder (066361) is located at 520mm.

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 001 located at OBE7 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 the QC appeared to comply with WPS-345-SMAW-3G (3F)-FCM-Repair-1 and WR1345 repair procedure.

Y Location of repairs areas by above noted welder (054467) is located at 55, 65, 75, 100 and 785mm.

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Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 003 located at OBE7B 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-1G (1F)-FCM-Repair-1 and WR1345 repair procedure.

Y Location of repairs areas by above noted welder (054467) is located at 1820mm.

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 003 located at OBE7B bike path side of segment. Welder is identified as Mr. Li Zhengxu (066179). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-1G (1F)-FCM-Repair-1 and WR1345 repair procedure.

Y Location of repairs areas by above noted welder (066179) is located at 270mm.

Miscellaneous Work In Progress

ZPMC Ship

QA Inspector observed ZPMC's personnel performing various job functions on ZPMC Ship. Locations and description of work are as followed:

6 West, 6 East

1. Various activity such as; bolt installation, scaffolding removal, suspender bracket and coating touch up, being performed throughout segments.

NDT Observation

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

1. Performed on the side plate weld joint OBE7B-002 excavations areas located cross beam side of segment at Y locations 15, 810, 3550, 5800, 6380, 6780, 6820 and 7225mm.

2. Performed on the side plate weld joint OBE7B-004 excavations areas located cross beam side of segment at Y locations 660, 3300, 6025, and 8170mm.

NOTE:

Due to ZPMC work personnel being utilized on the ZPMC ship for the shipment of OBG 5 and 6 (east/west) segments and CB 4, 5, 6 members, work was limited in the trail assembly yard on today's work shift.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract

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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
