

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-013185**Date Inspected:** 05-Apr-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

7AW

Shield Metal Arc Welding (SMAW) repair welding was performed on deck plate weld joint 004 located at CA032 cross beam side of segment. Welder is identified as Mr. Zhang Quanfa (066326). 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 CWR1223 repair procedure.

Y Location of repairs areas by above noted welder (066326) is located at 1990~1995 and 3060mm.

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 004 located at CA032 cross beam side of segment. Welder is identified as Mr. Gong Huaigang (037840). 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 CWR1223 repair procedure.

Y Location of repairs areas by above noted welder (037840) is located at 4300 and 4570mm.

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Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 047 located at SEG036 cross beam side of segment. Welder is identified as Mr. Han Xiaofeng (048659). 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 CWR1325 repair procedure.

Y Location of repairs areas by above noted welder (048659) is located at 90mm.

7CE

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 002 located at CA040 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-1G (1F)-FCM-Repair-1 and CWR1227 repair procedure.

Y Location of repairs areas by above noted welder (054467) is located at 555 and 397mm.

7CW

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 004 located at CA038 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 WPS-345-SMAW-2G (2F)-FCM-Repair-1 and CWR1228 repair procedure.

Y Location of repairs areas by above noted welder (045221) is located at 8020mm.

7AE

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 002 located at CA033 cross beam side of segment. Welder is identified as Mr. Dai Lu (048659). 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 CWR1210 repair procedure.

Y Location of repairs areas by above noted welder (048659) is located at 290~640mm.

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 006 located at CA034 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-2G (2F)-FCM-Repair-1 and CWR1210 repair procedure.

Y Location of repairs areas by above noted welder (054467) is located at 9260mm.

Miscellaneous Work In Progress

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QA Inspector observed ZPMC's personnel performing various job functions at Trail Assembly yard. Locations and description of work are as followed:

8AW and 8AE

1. Observed segment being moved in the trail assembly yard for field splice fit up work.

7BW+7CW

1. Observed heat straightening in progress at various side plate t stiffeners per HSR1 (B)-8235 procedure.

7DE

1. Observed beveling of the deck plate, side plate (crossbeam & bike path side) and bottom plate for welding.

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
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Reviewed By:	Miller,Mark	QA Reviewer
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