

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-013187**Date Inspected:** 24-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) welding was performed on weld joint 020 located at DP662-001 bike path 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-485-SMAW-3G (3F)-FCM-Repair-1 and WR11321 repair procedure.

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7BE

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Shield Metal Arc Welding (SMAW) VT repair welding was performed on various t stiffeners located on the side plate at bike path side of segment. Welder is identified as Mr. Hu Yanming (062092). 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)-Repair-1.

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 ad coating touch up, being performed throughout segments.

QA Inspector observed ZPMC's personnel performing various job functions in the trial assembly yard. Locations and description of work are as followed:

7CW+7BW

1. Removal of temporary attachment remaining portions at deck plate splices (internal) being removed by ZPMC workers.

NDT Observation

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

7BE+7CE

1. Performed on the edge plate horizontal stiffeners splice weld joints at cross beam side of segment. This QA Inspector noted ZPMC rejected the area inspector due to Class A indication present at this time.

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. 7CE+7BE

1. Performed on X37 members between panel points 52 and 53 bike path side of segment per WR11081.

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NOTE:

Due to inclement weather 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 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
