

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-013189**Date Inspected:** 22-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1800**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

7BW+7CW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 007 and 008 located at OBW7B bottom and side plate (counter weight) of segment. Welder is identified as Mr. Qie Jianzhou (067570). 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-FCM-1.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 19~21 located at DP648-001 cross beam side of segment. Welder is identified as Mr. Duan Yanyang (066422). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-3213-B-U3b.

7AW+7BW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 19~21 located at DP647-001 cross beam side of segment. Welder is identified as Mr. Yun Chuansheng (045221). ZPMC QC is identified as Li Yang.

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The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-3213-B-U3b.

7CW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 044 located at SEG055 cross beam side of segment. Welder is identified as Mr. Li Zajun (045196). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

7BW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 006 located at CA035 counter weight side of segment. Welder is identified as Mr. Jiang Jinyong (066361). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

7BE

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 004 located at CA036 bike path side of segment. Welder is identified as Mr. Shi Li (068746). 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 CWR1224 repair procedure.

Y Location of repairs areas by above noted welder (068746) is located at 6790mm.

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:

6 East

1. Segment was placed onto ship for shipment.

Ship

1. ZPMC welder performing the welding of the sea fasteners to ship deck on the starboard and port side of ZPMC ship.

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:

Ship

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1. Performed on sea fasteners weld joint to ship deck at various locations.

7BE+7CE

1. Performed on the deck plate weld joint OBE7-007, 008 and 009.

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:

2. Performed on the side plate weld joint OBE7B-006 and 007 cross beam side of segment.

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
