

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-013625**Date Inspected:** 20-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

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 X371 to X74 fillet welds. The weld designations reviewed are as follows:

1. CA036-001-019, 020, 025~028
2. CA033-001-039, 040, 047, 048, 057~060
3. CA033-001-045~048
4. CA039-001-061~064
5. CA040-001-061~064

BP Member 25A

Shield Metal Arc Welding (SMAW) base metal repair welding was performed on bottom plate temporary attachment areas. Welder is identified as Mr. Li Yi (045268). 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)-Repair-1 and

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WR12119 repair procedure.

BK001-028

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 009 located at BK001-028 bike path cantilever member. Welder is identified as Mr. Qie Jianzhou (067571). 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.

BK001-030

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 009 located at BK001-030 bike path cantilever member. Welder is identified as Mr. Chen Hongjun (067609). 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.

BK001-029

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 009 located at BK001-029 bike path cantilever member. Welder is identified as Mr. Huang Jian (0695841). 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.

Miscellaneous Work In Progress

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

7BW+7CW

1. Side plate stiffener welds being removed for misalignment purpose per WR12027 repair procedure.

7CE+7DE

1. UT reject excavation performed on the side plate weld splice OBE7C-002 crossbeam side of segment at Y location 562mm.

NDT Observation

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

7DE+7EE

1. Bottom plate weld splice on the exterior side.

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:	Carreon,Albert	QA Reviewer
