

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-013632**Date Inspected:** 28-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 UT of approximately 10% of the repaired area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member(s) is/are identified as Punch List Item 472 (Inspection request # 005620) longitudinal diaphragm to floor beam web. The weld designations reviewed are as follows:

1. SEG035C-022

8AE

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 002 located at SEG044A cross beam side of segment. Welder is identified as Mr. Wang Quanlin (066746). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2231T.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 002 located at SEG044* cross beam side of segment. Welder is identified as Mr. Chen Hongjun (066746). ZPMC QC is identified as Wu Zhi Cheng.

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The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2214-Tc-U4b-FCM-1.

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 004 located at CA048 bike path side of segment. Welder is identified as Mr. Bian Henggui (051359). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair-1 and CWR1426 repair procedure.

Y Location of repairs areas by above noted welder (051359) is located at 1290 and 1295mm.

8BE

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 002 located at CA051 cross beam side of segment. Welder is identified as Mr. Chen Hongjun (066746). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2214-Tc-U4b-FCM-1.

7CW+7DW

Flux Core Arc Welding (FCAW) welding was performed on weld joint 008 located at OBW7A deck plate of segment. Welder is identified as Mrs. Cheng Hai Xia (045209). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2233(2)1T-2.

Flux Core Arc Welding (FCAW) welding was performed on weld joint 009 located at OBW7C bottom plate of segment. Welder is identified as Mr. Shi Yan (068920). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2233(2)1T-2.

Flux Core Arc Welding (FCAW) welding was performed on weld joint 009 located at OBW7C deck plate of segment. Welder is identified as Mrs. Cheng Hai Xia (045209). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2233(2)1T-2.

Flux Core Arc Welding (FCAW) welding was performed on weld joint 009 located at OBW7C cross beam side of segment. Welder is identified as Mr. Yu Huiye (045143). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2233(2)1T-2.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 010 located at OBW7A cross beam side of segment. Welder is identified as Mr. Zang Yanbo (045196). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2214-B-U2a-1.

7CE+7DE

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 002 located at OBE7C cross beam side of segment. Welder is identified as Mr. Han Xiaofeng (054467). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair-1 and CWR1448 repair procedure.

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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:

8AE

1. Heat straightening was performed on DP647A located between PP50&PP51 counter weight side of segment per HSR1 (B)-8369.

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:	Carreon,Albert	QA Reviewer
