

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-013634**Date Inspected:** 30-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

8BE

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 006 located at CA051 cross beam side of segment. Welder is identified as Mr. Zhao Aifei (067942). 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-Tc-U4b-FCM-1.

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 004 located at CA051 cross beam 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-2G (2F)-FCM-Repair-1 and CWR1411 repair procedure.

8CE

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 043 located at SEG048* cross beam

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side of segment. Welder is identified as Mr. Zhao Aifei (067942). 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-Tc-U4b-FCM-1.

7CW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 013~018 located at DP640-001 counter weight side of segment. Welder is identified as Mr. Luo Xuanping (067610). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-4114-1.

7DW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 007~012 located at DP641-001 counter weight side of segment. Welder is identified as Mr. Luo Xuanping (067610). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-4114-1.

7DW+7EW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 020~030 located at BP146-001 bottom plate of segment. Welder is identified as Mr. Xu Changxue (066002). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2213-B-U2a-1.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 020~030 located at BP038-001 bottom plate of segment. Welder is identified as Mr. Dong Youcun (067588). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2213-B-U2a-1.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 006 located at OBW7C counter weight side of segment. Welder is identified as Mr. Cao Xinglong (069683). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2114-B-U2a-FCM-1.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 007 located at OBW7C counter weight side of segment. Welder is identified as Mr. Li Zaijun (037996). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2114-B-U2a-FCM-1.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 007 located at OBW7C counter weight side of segment. Welder is identified as Mr. Zang Wei (066413). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2114-B-U2a-FCM-1.

Submerge Arc Welding (SAW) welding was performed on weld joint 008 located at OBW7A deck plate of segment. Welder is identified as Mrs. Wang Lanying (045265). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-223(2)1T-2.

Submerge Arc Welding (SAW) welding was performed on weld joint 008 located at OBW7A deck plate of

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segment. Welder is identified as Mrs. Ma Ying (045270). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-223(2)1T-2.

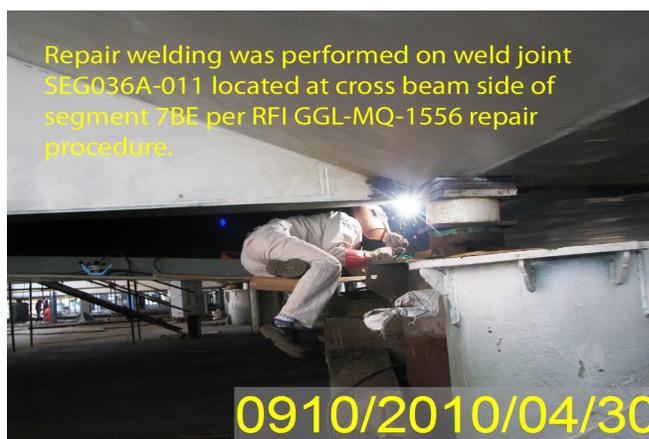
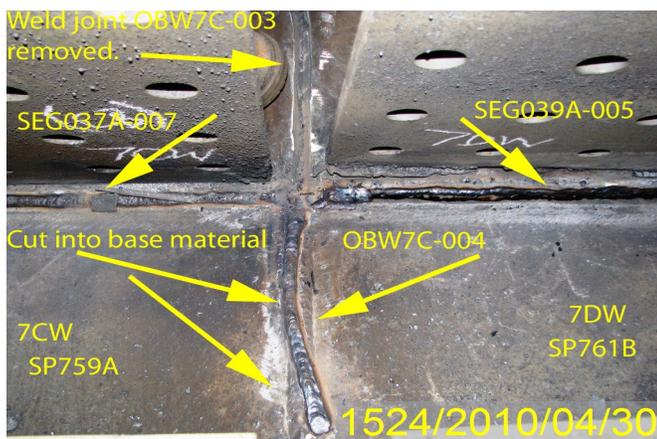
7BE

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 011 located at SEG036A 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-B-P-2214-B-U2-FCM-1 and RFI GGL-MQ-1556 repair procedure.

7CW+7DW

This QA Inspector observed ZPMC welding personnel had commenced a Critical Weld Repair (CWR) on Seismic Performance Critical Material (SPCM) without an approved Critical Weld Repair procedure and prior to properly preparing the joint. This location is at panel point 55 cross beam side of segment. This QA Inspector issued an incident for 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: Carreon, Albert

QA Reviewer