

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-013843**Date Inspected:** 03-May-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 7CW+7DW segment splice temporary attachment areas and 7DE&7EE X74 to X37L. The weld designations reviewed are as follows:

1. CA045-001-061~064, 047~051
2. CA046-001-085~088
3. CA042-001-023~028, 059~065

7DE+7EE

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 007 located at OBE7C cross beam side of segment. Welder is identified as Mr. Dai Lu (048659). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-3G (3F)-FCM-Repair-1 and CWR1448 repair procedure.

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Y Location of repairs areas by above noted welder (048659) is located at 20mm.

7DE

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 001 located at CB202A-008 cross beam side of segment. Welder is identified as Mr. Lu Xianojie (067904). 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.

7DW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 001 located at CB202A-008 cross beam side of segment. Welder is identified as Mr. Zhou Bing (067764). 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) welding was performed on weld joint 001 located at CB202A-003 cross beam side of segment. Welder is identified as Mr. Qie Jianzhou (067571). 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 005 located at SEG039A cross beam side of segment. Welder is identified as Mr. Tian Zhaoquan (045246). 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 WR12294 repair procedure.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 006 located at CA041 cross beam 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-2214-Tc-U4b-FCM-1.

7BW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 013 located at CA201A-007 cross beam side of segment. Welder is identified as Mr. Li Jian (067829). 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) repair welding was performed on weld joint 007 located at SEG037A cross beam side of segment. Welder is identified as Mr. Tian Zhaoquan (045246). 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 WR12294 repair procedure.

7DW+7EW

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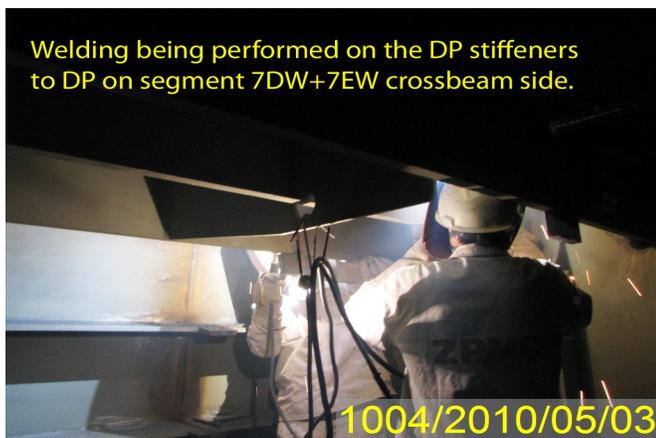
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Shield Metal Arc Welding (SMAW) welding was performed on weld joint 019 located at DP642-001 counter weight side of segment. Welder is identified as Mr. Yu Chuansheng (045221). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-3213-B-U3b.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 019 located at DP642-001 counter weight side of segment. Welder is identified as Mr. Yu Chuansheng (045221). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-3213-B-U3b.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 018 located at DP649-001 cross beam side of segment. Welder is identified as Mr. Zai Dawei (068097). 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.

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
