

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-013860**Date Inspected:** 07-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 8AE+8BE segment tag 3. The weld designations reviewed are as follows:

1. SEG044B-11, 12, 23, 31
2. SEG044C-23, 32, 40
3. SEG046C-24, 17
3. SEG046B-11, 17

8AW+8BW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 004 located at OBW8B cross beam side of segment. Welder is identified as Mr. Fang Xianyou (037748). 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.

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Shield Metal Arc Welding (SMAW) welding was performed on weld joint 003 located at OBW8B bottom plate 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-B-U2-FCM-1.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 004 located at OBW8B 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-2214-B-U2-FCM-1.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 002 located at OBW8B counter weight 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-U2-FCM-1.

Submerged Arc Welding (SAW) welding was performed on weld joint 003 located at OBW8 deck plate of segment. Welder is identified as Mr. 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-PT-223(2)1T-2.

Submerged Arc Welding (SAW) welding was performed on weld joint 003 located at OBW8 deck plate of segment. Welder is identified as Mr. 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-PT-223(2)1T-2.

8AW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 055~066 located at BP094-001 bottom plate of segment. Welder is identified as Mr. Wei Hengbin (068924). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2112-FCM-1.

8BW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 031~042 located at BP095-001 bottom plate of segment. Welder is identified as Mr. Wei Hengbin (068924). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2112-FCM-1.

7DW+7EW

Repair welding was being performed at the internal of deck plate (DP) on weld splice OBW7A-008. During the repair work was being commenced, this QA Inspector noted rain water present on the opposite side of surface of area being repaired causing the material to be quenched. This QA Inspector issued an incident report for noted issue on today's work shift.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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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
