

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-014361**Date Inspected:** 13-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

8BE+8CE

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 004 located at OBE8C bike path side of segment. Welder is identified as Mr. Wang Zhonghua (053753). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-3G (3F)-Repair-1 and CWR1525 procedure.

Y Location of repairs areas by above noted welder (053753) is located at 1000~1170mm. (Internal)

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 004 located at OBE8C bike path side of segment. Welder is identified as Mr. Han Xiaofeng (054467). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-4G (4F)-Repair-1 and CWR1525 procedure.

Y Location of repairs areas by above noted welder (054467) is located at 110mm. (External)

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Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 005 located at OBE8C bike path side of segment. Welder is identified as Mr. Han Xiaofeng (054467). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-4G (4F)-Repair-1 and CWR1525 procedure.

Y Location of repairs areas by above noted welder (054467) is located at 1040mm. (External)

8AW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 043 located at SEG043* cross beam side of segment. Welder is identified as Mr. Gang Huaigang (037840). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2212-Tc-U4b-FCM-1.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 006 located at CA047 counter weight side of segment. Welder is identified as Mr. Li Zhengqiang (037840). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2212-Tc-U4b-FCM-1.

Flux Core Arc Welding (FCAW) welding was performed on weld joint 013 located at SEG043B counter weight side of segment. Welder is identified as Mr. Liu Xiaolin (067079). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2233-Tc-U4b-FCM-1.

7EW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 044 located at CA044 cross beam side of segment. Welder is identified as Mr. Gang Huaigang (066038). 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.

7CW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 009 located at SEG037B counter weight side of segment. Welder is identified as Mr. Zang Wei (066413). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2211-Tc-U4b-FCM-1.

8BW+8CW

Submerged Arc Welding (SAW) welding was performed on weld joint 003 located at OBW8A 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 OBW8A 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.

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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:

8AW+8BW

1. Deck plate weld splice OBW8-002, 003 and 004 temporary attachment areas.

8BW+8CW

1. Deck plate weld splice (root pass) OBW8A-003 located on the deck plate of segment.

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
