DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-014368
Date Inspected: 21-May-2010

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 700
OSM Departure Time: 1900
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 8AW, 8BW and 8CW X37L, 8BE+8CE hold back welds and 7 East drip plates. The weld designations reviewed are as follows:

7 East Drip Plates

1. OBE7B-001~005

8CE (X37L)

1. CA054-51~54, 63~66
2. SEG048H-11~14
3. SEG048S-57~60
4. SSD24-PP68.5-002

5. SSD24-PP69.5-002

8AE

1. CA048-75~78, 87~90
2. SEG044D-11~14
3. SEG044E-57~60
4. SSD23-PP61.5-001
5. SSD24-PP62.5-002

8BE

1. CA051-27~30, 39~42
2. CA051-75~78, 87~90
3. SSD29-PP66.5-001

8BE+8CE

1. SP458-021, 022, 029, 030
2. SP459-021, 022, 029, 030
3. SP579-025, 026
4. SP580-18, 19
5. SP619-025, 026
6. SP620-31, 32
7. SP467-21, 22, 29, 30
8. SP468-11, 12, 19, 20
8. SP317-01, 02
9. SP370-35, 36
10. SP371-11, 12
11. EP086-11, 12
12. EP087-11, 12
13. DP668-15, 16
14. DP669-09, 10
15. DP660-15, 16
16. DP661-09, 10
13. BP176-43, 44
14. BP177-25, 26
15. BP068-43, 44
16. BP069-25, 26
17. BP123-25, 26, 35, 36

7DW+7EW

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 008 located at OBW7A deck

plate weld splice of segment. Welder is identified as Mr. Zang Yanbo (045196). 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 CWR1514 repair procedure.

Y Location of repairs areas by above noted welder (045196) is located at 430, 1200 and 1200mm. (Internal)

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 006 located at OBW7C counter weight side of segment. Welder is identified as Mr. Zhao Aifei (067942). 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 CWR1542 repair procedure.

Y Location of repairs areas by above noted welder (067942) is located at 150 and 1160mm. (External)

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 006 located at OBW7C counter weight side of segment. Welder is identified as Mr. Xu Changxue (066002). 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 CWR1542 repair procedure.

Y Location of repairs areas by above noted welder (066002) is located at 630, 1200 and 1590mm. (External)

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 008 located at OBW7C cross beam side of segment. Welder is identified as Mr. Zang Yanbo (069683). 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 CWR1514 repair procedure.

Y Location of repairs areas by above noted welder (069683) is located at 7870mm.

8AW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 043 located at SEG043A cross beam side of segment. Welder is identified as Mr. Li Zhengqiang (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.

8BW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 030 located at SEG047B cross beam side of segment. Welder is identified as Mr. Gong Huaigang (037840). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2214-B-U4b-FCM-1.

8CW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 001 located at CA050 cross beam side of segment. Welder is identified as Mr. Gong Huaigang (037840). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2214-B-U4b-FCM-1.

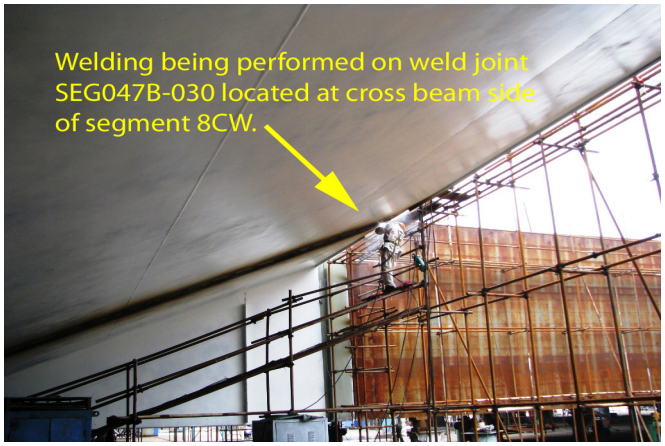
7DW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 006 and 043 located at SEG039C cross beam side of segment Welder is identified as Mr. Tian Zhaoquan (045246). 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, WR12975 and 12975 procedure.

9AE

Flux Core Arc Welding (FCAW) welding was performed on weld joint 011 located at SEG050A cross beam side of segment. Welder is identified as Mr. Zhang Hanming (220066). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2231-B-U2-F.

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