

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-014369**Date Inspected:** 22-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

7BE

Shield Metal Arc Welding (SMAW) repair welding (buttering) was performed on side plate 611B located at 7BE cross beam side 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)-FCM-Repair-1 and WR12962 repair procedure.

9AE

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 025~036 located at SP622-001 cross beam side of segment. Welder is identified as Mr. Xin Meng (053742). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2132.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 025~036 located at SP622-001 cross beam side of segment. Welder is identified as Mr. Li Shuqiang (053609). ZPMC QC is identified as Li Yang. The

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welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2214-B-U4b-FCM-1.

9BE

Flux Core Arc Welding (FCAW) welding was performed on weld joint 037~042 located at SP622-001 cross beam side of segment. Welder is identified as Mr. Xin Meng (053742). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2233-B-U2-F.

Flux Core Arc Welding (FCAW) welding was performed on weld joint 037~042 located at SP582-001 cross beam side of segment. Welder is identified as Mr. Li Shuqiang (053609). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2233-B-U2-F.

8BW+8CW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 031 located at SP435-001 cross beam side of segment. Welder is identified as Mr. Dong Haitao (067183). 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-U2-FCM-1.

NDT Observation

This QA Inspector observed ZPMC Ultra Sonic Testing (UT) Technician performed UT on various locations in the trial assembly yard. Locations are as followed:

8AW

1. Longitudinal diaphragm to floor beam web at PP 61 at counter weight side of segment.

Miscellaneous Work In Progress

QA Inspector observed ZPMC's personnel performing various job functions at Tail Assembly Yard. Locations and description of work are as followed:

7EW

1. Heat straightening was performed on the FB flange to DP diaphragm at panel point 59 counter weight side of segment per HSR (B)-365.

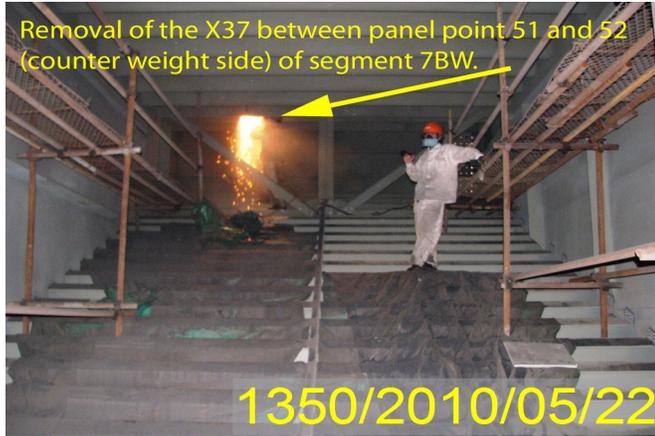
7BW

1. Removal of the X37 between panel point 51 and 52 (counter weight side) being removed due to excessive gap being present. Work is being performed per WR12960.

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
