

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-014372**Date Inspected:** 25-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 7AE Drip Plate, 8E X74 to T-Rib flange, 7BE LD003 and 7DE/8AE/8CE stiffener on T-Rib web. The weld designations reviewed are as follows:

7AE

1. OBE7E-001-002

8E X74

1. SSD23-PP70.5-117~120, 13~16

7AE

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1. LD003-001-013, 014

7DE/8AE/8CE stiffener on T-Rib web

1. Panel Points 57, 63 and 69 cross beam side.

9AE+9BE

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 005 located at OBE9B cross beam side of segment. Welder is identified as Mr. Zhang Shenhong (068764). ZPMC QC is identified as Li Yang. 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 OBE9B bike path side of segment. Welder is identified as Mr. Wang Honglei (066687). ZPMC QC is identified as Liu Huajie. 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 OBE9B bottom plate splice of segment. Welder is identified as Mr. Huang Jing (069841). ZPMC QC is identified as Liu Huajie. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2214-B-U2-FCM-1.

8AW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 051 located at FB015-001 cross beam side of segment at panel point 64. Welder is identified as Mr. Li Shoufu (066674). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2211-B-U2-FCM-1 and RFI-GGL-MQ-1573.

8BW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 002 located at CA047 cross beam side of segment. Welder is identified as Mr. Li Wenguo (066261). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-\$G(4F)-FCM-Repair-1 and CWR1540.

8AW+8BW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 004 located at OBW8 deck plate splice of segment. Welder is identified as Mr. Hao Jianxiang (067665). 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 WR13064.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 003 located at OBW8 deck plate splice of segment. Welder is identified as Mr. Hao Jianxiang (067665). 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

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WR13063.

8CE

Flux Core Arc Welding (FCAW) welding was performed on weld joint 004 located at SEG040F bike path side of segment. Welder is identified as Mr. Chen Zhenghua (220067). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS- B-T-2132.

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:

8CE

1. Heat straightening was performed on the deck plate to CB deck plate between panel point 68 and 70 per HSR (B)-367.

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.

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Inspected By: Alaniz,Joe Quality Assurance Inspector

Reviewed By: Carreon,Albert QA Reviewer