

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-014606**Date Inspected:** 28-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

9AE+9BE

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 014 located at EP162-001 bike path side of segment. Welder is identified as Mr. Jiang Zhen (068917). 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.

9AW+9BW

Flux Core Arc Welding (FCAW) welding was performed on weld joint 004 located at OBW9B cross beam side of segment. Welder is identified as Mr. Fei Cheng Xiang (066239). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2233T-1.

Flux Core Arc Welding (FCAW) welding was performed on weld joint 004 located at OBW9B cross beam side of segment. Welder is identified as Mr. Cao Hengfeng (066421). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2233T-1.

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

Flux Core Arc Welding (FCAW) welding was performed on weld joint 003 located at OBW9B bottom plate of segment. Welder is identified as Mr. Wang Quanlin (066746). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2231T-1.

Flux Core Arc Welding (FCAW) welding was performed on weld joint 003 located at OBW9B bottom plate of segment. Welder is identified as Mr. Wang Zhaocong (068445). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2231T-1.

Flux Core Arc Welding (FCAW) welding was performed on weld joint 003 located at OBW9B bottom plate of segment. Welder is identified as Mr. Jiang Yongsheng (045240). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2231T-1.

7DW

Flux Core Arc Welding (FCAW) welding was performed on weld joint 100 located at SEG039C-001 cross beam side of segment. Welder is identified as Mr. Yu Huiye (045143). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2232-Tc-U4b-F.

8BW+8CW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 001 located at OBW8A counter weight side of segment. Welder is identified as Mr. Zhao Shanlun (066038). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-3G (3F)-FCM-Repair-1 and WR13197 procedure.

Y Location of repairs areas by above noted welder (066038) is located at 230, 550, 870 and 1340mm.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 002 located at OBW8C counter weight side of segment. Welder is identified as Mr. Du Henghua (037779). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-3G (3F)-FCM-Repair-1 and WR13194 procedure.

Y Location of repairs areas by above noted welder (037779) is located at 13194mm.

8CW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 017~024 located at BP151-001 bottom plate of segment. Welder is identified as Mr. Li Yongshui (067183). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2112-FCM-1.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 013~016 located at BP151-001 bottom plate of segment. Welder is identified as Mr. Mao Liwei (0453213). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2112-FCM-1.

WELDING INSPECTION REPORT

(Continued Page 3 of 4)

9AW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 044 located at SEG043* 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-T-2114-B-U2-FCM-1.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 013~024 located at BP097-001 bottom plate of segment. Welder is identified as Mr. Du Henghua (037743). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2112-FCM-1.

Flux Core Arc Welding (FCAW) welding was performed on weld joint 006 located at CA047 counter weight side of segment. Welder is identified as Mr. Li Zhengqiang (066038). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-FCAW-1G (1F)-Repair-1 and WR13175 procedure.

8AW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 044 located at SEG043* cross beam side of segment. Welder is identified as (044268). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair-1 and WR13177 procedure.

Y Location of repairs areas by above noted welder (044268) is located at 380 and 560mm.

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

WELDING INSPECTION REPORT

(Continued Page 4 of 4)

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
