

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-014803**Date Inspected:** 01-Jun-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 8AE punch list item #556 and 9AE+9BE hold back welds. The weld designations reviewed are as follows:

8AE

1. X82T horizontal stiffener

9AE+9BE

1. SP687-23, 24
2. SP688-23, 24
3. SP542-29, 30
4. SP543-15, 16

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5. SP561-43, 44
6. SP563-11, 12
7. SP622-25, 26
8. SP623-05, 06
8. BP178-27, 28
9. BP179-33, 34
10. BP70-25, 26
11. BP71-31, 32
12. BP124-25, 35
13. DP696-13, 14
14. DP697-06, 07
15. EP143-09, 010
16. EP143-09, 010

7DW

Shield Metal Arc Welding (SMAW) repair was performed on weld joint 100 located at SEG039C cross beam side of segment. Welder is identified as Mr. Zai Dawei (068097). 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 WR13212 procedure.

8AW+8BW

Shield Metal Arc Welding (SMAW) repair was performed on weld joint 022 located at OBW8A counter weight side of segment. Welder is identified as Mr. Zai Dawei (068097). 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 WR13212 procedure.

Shield Metal Arc Welding (SMAW) repair was performed on weld joint 016 located at EP062-001 counter weight side of segment. Welder is identified as Mr. Lu Xiaojie (067904). 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 WR13288 procedure.

9AW+9BW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 003 located at OBW9B bottom plate splice weld of segment. Welder is identified as Mr. Jiang Jinyong (066361). 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 003 located at OBW9B bottom plate splice weld of segment. Welder is identified as Mr. Jiang Jinyong (069841). 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 003 located at OBW9B bottom plate

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splice weld 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-P-2214-B-U2-FCM-1.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 002 located at OBW9B 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-2214-B-U2-FCM-1.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 002 located at OBW9B counter weight 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-B-U2-FCM-1.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 001 located at OBW9B counter weight side of segment. Welder is identified as Mr. Zhang Quanfa (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-B-U2-FCM-1.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 001 located at OBW9 counter weight side of segment. Welder is identified as Mr. Li Zaijun (037996). 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.

Flux Core Arc Welding (FCAW) welding was performed on weld joint 044 located at SEG051A cross beam 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-B-T-2231-Tc-U4b-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.

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Inspected By:	Alaniz,Joe	Quality Assurance Inspector
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Reviewed By:	Carreon,Albert	QA Reviewer
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