

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-014808**Date Inspected:** 08-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 7DE and 7BE FL3/ DP hold back welds. The weld designations reviewed are as follows:

7BE

1. FB028-01~04, 13~18, 128
2. FB024-01, 02, 15~20
3. FB040-13~18, 07, 08
4. SEG036D-34, 35, 52, 53
5. SEG036E-158, 159, 167, 168
6. SSD16-PP50-170
7. SSD18-PP52-169
8. BP026-007-26, 27, 30, 31

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7DE

1. FB028-01~04, 15~20
2. FB020-01~04, 15~20
3. FB024-01~04, 15~20
4. SEG040D-34, 35, 43, 44
5. SEG040E-68, 69, 86, 87, 131, 132, 140, 141
6. SSD16-PP56-170
7. SSD18-PP57-166
8. BP026-008-24, 25, 28, 29, 040, 41

8CE

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 006 and 007 located at FB020-010 cross beam side segment. Welder is identified as Mr. Li Bin (069896). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2114-FCM-1.

8CW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 008, 009 located at FB019-010 cross beam side segment. Welder is identified as Mr. Li Jian (067829). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2114-FCM-1.

Flux Core Arc Welding (FCAW) repair welding (buttering) was performed on LD end which connects to the bottom plate cross beam side segment. Welder is identified as Mr. Li Jian (067829). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-FCAW-1G (1F)-FCM-Repair-1 and WR13500 procedure.

9AE+9BE

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 005 located at OBE9 deck plate splice of segment. Welder is identified as Mr. Li Jian (054467). 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 CWR 1594 procedure.

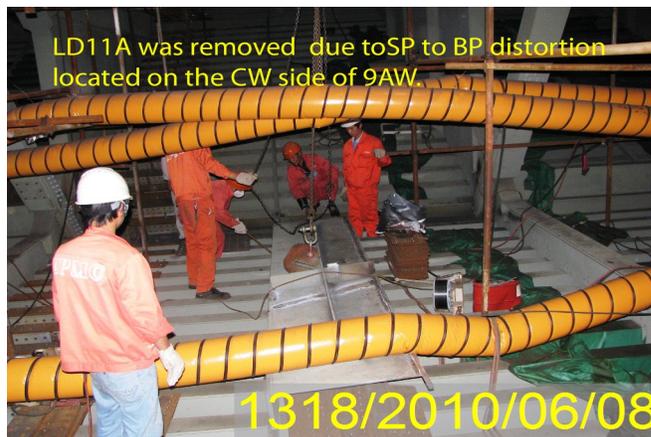
Travel Rail Brackets

Flux Core Arc Welding (FCAW) welding was performed on weld joint 002 located at TR2A-PP066 for counter weight side of segment 8BW. Welder is identified as Mr. Wang Bing (048696). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2132-Tc-U4b-F.

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
