

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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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-006822**Date Inspected:** 09-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yan Hua**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 Assembly**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector was present during the times noted above for observations relative to the work being performed.

Segment Repair Yard (North of the blast shop)

Segment 5BE

This QA Inspector performed Magnetic Particle testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (MT) report for this date. The members are identified as the longitudinal diaphragm component welds. The Weld Designations are as follows: SEG024B-009, 010, 017, 018, 023 and 024.

SEG024C-009, 010, 017, 018, 023 and 024.

This QA Inspector performed Magnetic Particle testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (MT) report for this date. The members are identified as the deck panel diaphragm to U-Rib welds. The Weld Designations are as follows:

DP325-001-053~059.

DP325-002-053~059.

DP487-041~048.

DP460-063~070.

DP433-063~070.

DP406-063~070.

DP379-063~070.

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DP352-063~070.

DP298-041~048.

This QA Inspector performed Magnetic Particle testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (MT) report for this date. The members are identified as the corner assembly component welds. The Weld Designations are as follows:

CA020-037~042, 061~066 and 085~090.

CSD4-PP32-068~074 and 130~134.

CSD2-PP32.5-049~056.

CSD5-PP33-063~074.

CSD2-PP33.5-049~056.

CSD4-PP34-068~074, 130~134.

CSD2-PP34.5-049~056.

SEG024D-011~014, 057~060 and 034~037.

SEG024E-005~008.

SEG024F-001 and 004.

SEG024G-001 and 004.

During random verification Magnetic Particle Testing of the corner assembly weld numbers SSD16-PP32-146, 142, SSD24-PP32.5-129, CSD5-PP33-065, CSD4-PP34-072 and CSD4-PP32-071,132. Caltrans Quality Assurance (QA) Inspector discovered a total of nine (9), 5mm to 35mm long longitudinal linear indication previously overlooked by ZPMC Quality Control MT Technicians.

This QA Inspector performed Magnetic Particle testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (MT) report for this date. The members are identified as the floor beam welds. The Weld Designations are as follows:

SSD18-PP34-029~032, 087~090 and 140~151.

SSD18A-PP34-004, 049~051, 103~106 and 127.

SSD17A-PP33-003, 047~050, and 106~109.

SSD17-PP33-028~031, 084~087 and 136~147.

SSD16A-PP32-003, 047~050, 106~109.

SSD16-PP32-028~031, 086~089 and 140~151.

SSD24-PP32.5-049~052 and 129~136.

SSD24-PP33.5-049~052 and 129~136.

SSD23-PP34.5-049~052 and 129~136.

This QA Inspector performed Ultrasonic testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as the deck panel diaphragm splice welds. The Weld Designations are as follows:
SEG024*-009~014, 029 and 030.

This QA Inspector performed Ultrasonic testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as the FL3 floor beam to the side and edge plates welds. The Weld Designations are as

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follows:

SEG024A-009, 010, 015, 016, 025, 035 and 037.

This QA Inspector performed Ultrasonic testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as the longitudinal diaphragm welds. The Weld Designations are as follows:

SEG024B-003, 004, 019 and 020.

SEG024C-003, 004, 019 and 020.

This QA Inspector performed Ultrasonic testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as the edge plate to the deck and side plate weld splices. The Weld Designations are as follows:

CA020-003 and 004.

This QA Inspector performed Ultrasonic testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as the floor beam component weld splices. The Weld Designations are as follows:

SSD18A-PP34-002, 003, 009, 129, 130 and 136.

SSD18-PP34-005, 010, 011, and 184.

This QA Inspector performed Ultrasonic testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as the transverse deck stiffeners in way of the crossbeam. The Weld Designations are as follows:

SEG024D-015, 018, 038, 041, 061 and 064.

This QA Inspector performed a preliminary random visual inspection of the internal structure of this segment. Areas that were marked to be ground and welded were repaired at the time of inspection.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No Relevant conversations

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, (15000422372), who represents the Office of Structural Materials for your project.

Inspected By: Patterson,Rodney

Quality Assurance Inspector

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Reviewed By: Carreon,Albert

QA Reviewer