

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-006972**Date Inspected:** 19-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:	Hu Wei Qing	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 Components	

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the time noted above for observations relative to the work being performed.

BAY#2

During Visual inspection of 1AAE following issues observed. CT VT is still pending

SEG2C-045 - PJP Weld Root Opening is approximately 8 mm.

SEG2E-227 - PJP Weld Root Opening is approximately 7 mm.

SEG2E-137 - PJP Weld Root Opening is more than required. WPS-B-T-2333-Tc-U4b-F.

SEG2D-060 - Uneven Cut surface Plate stiffener.

SEG2D-458- Crack in Tack weld.

SEG2D-187- Drawings require tight fit. Area has been fillet welded and then had the weld removed by air arc gouging. Base metal damage exists fit-up no longer tight fit.

SEG2D- Fit -up of End Plate in between the Side Plate and stiffener there is a gap approximately 7 mm.

X193A-Cut Plate Radius of curvature is not match with Horizontal plate

BAY#2

During Visual inspection of 1AAW following issues observed. CT VT still pending.

SEG1E-227 - PJP Weld Root Opening is approximately 12 mm.

SEG1E-187 - PJP Weld Root Opening is approximately 10 mm.

SEG1E-443 - PJP Weld Root Opening is approximately 10 mm. WPS-B-T-2333-Tc-U4b-F.

SEG1E-666 - Crack in Tack weld.

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SEG1E-668- Tack weld missing.

SEG1C-152 to 172 – Drawings require tight fit. Area has been fillet welded and then had the weld removed by air arc gouging. Base metal damage exists fit-up no longer tight fit.

SEG1D-152 to 170- Drawings require tight fit. Area has been fillet welded and then had the weld removed by air arc gouging. Base metal damage exists fit-up no longer tight fit.

SEG1E- 587 CJP- weld some places steel backing bar used and not yet removed, spatter, undercut, etc.

WPS-B-T-2233-Tc-U4b-F.

SEG1D-002- Base metal Damage at loose end .

SEG1D-092 Base metal damage at loose end.

SEG1A-23, 24, 25, 27 Bottom Cable tray Plate Hole Free hand cutting length around 500mm and Improper finishing,Notches,etc.

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 is indentified as Segment 1AAE and 1AAW. The weld designations reviewed as follows:

1AAE

SEG2-26- one linear indication found, repair and retested, accepted.

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

Summary of Conversations:

No Relevant Conversation.

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:	Kumar,Chadra	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
