

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-007610**Date Inspected:** 23-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Xi**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:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Larry Viars was present during the times noted above for observations relative to the work being performed.

Bay 2:

1AAW

This Caltrans QA inspector monitored activities related to internal stiffener replacement for Partial Joint Penetration (PJP) welds exceeding Welding Procedure Specification maximum root gap dimension on OBG segment 1AAW.

The following Fill plate welds were tested and accepted by ZPMC MT technicians were verified and accepted by QA.

A41- (Side Plate Side)

A39- (Side and Deck Plate)

A13- (Side and Deck Plate)

Caltrans QA performed MT verification of the following shim plates. A18 shim was rejected by Caltrans QA for a 35 mm linear indication. An incident report was issued for ZPMC QC accepting this area. This area was excavated and Magnetic Particle testing was performed. ZPMC repaired the area and MT was performed after the weld cooled to ambient temperature. See the attached digital photographs of the above mentioned indication prior to

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

repair.

A16- (Deck Plate Side)

A17- (Deck Plate Side)

A18- (Deck Plate Side) excavation and repair

Bay 3-

FCAW welding of weld joints 102 and 103 located on CSD5-PP81. ZPMC welder was identified as 204338 . ZPMC QC is identified as Chen Xi. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2132-3.

Bay 7-

SAW welding of weld joint 056, located on BP3028-001. ZPMC welder was identified as 046830. ZPMC QC is identified as Xu Xian Ping. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2221-B-L2C-S-2.

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



Summary of Conversations:

As identified within the contents of this report.

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: Viars,Larry

Quality Assurance Inspector

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Reviewed By: Carreon,Albert

QA Reviewer