

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-007648**Date Inspected:** 14-Jun-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 Zhi jiang**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, Hiranch Patel, was present during the times noted above for observations relative to the work being performed.

Bay#2- Segment 1AAE

This QA inspector witnessed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel of Segment 1AAE, seg2E stiffeners weld removal areas. ZPMC QC-CWI Li Zhi Jiang and ABFJV Wang Wen Bin were present during observation. The member is identified as Segment 1AAE. The weld designations reviewed are as follows:

-(Seg2E-137, 227, Seg2D-044) Location-A-13

-(Seg2E-429, 387, 347, 305, Seg2D-129, 130) Location-A-13

-(Seg2E-150, 109, 240, 190, Seg2C-046, 045) Location-A-26

Bay#2- Segment 1AAE

This QA inspector witnessed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel of Segment 1AAE, seg2E stiffeners weld after repair of excavation areas. ZPMC QC-CWI Li Zhi Jiang and ABFJV Wang Wen Bin were present during observation. The member is identified as Segment 1AAW. The weld designations reviewed are as follows:

-(Seg2E-083, 124, 334, 416) Location-A-00

-(Seg2F-022, 023, 024, 025, 026, 027) Location-A-00

-(Seg2D-002, 004, 088, 090) Location-A-00

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During random verification Magnetic Particle Testing of the internal components of OBG Segment 1AAW, Caltrans Quality Assurance (QA) Inspector discovered a total of (2) Two, linear indications from 05mm to 30mm in length in the base metal (weld removal area) at location A040, plate detail is X193B. These areas have been previously tested and accepted by ZPMC Quality Control MT Technicians. This QA Inspector submits a TL015 Incident report.

During random verification Magnetic Particle Testing of the internal components of OBG Segment 1AAE, Caltrans Quality Assurance (QA) Inspector discovered a linear indication from 50mm in length in the base metal (weld removal area) at location A026, plate detail is X302B. This area have been previously tested and accepted by ZPMC Quality Control MT Technicians. This QA Inspector submits a TL015 Incident report.

During in process inspection of welding of internal stiffeners components of OBG Segment 1AAW, Caltrans Quality Assurance (QA) Inspector discovered welding without qualified position according to approved WPS# WPS-B-T-2333-TC-P4-F. Caltrans Quality Assurance (QA) Inspector found welder welding by FCAW welding process and FCAW welding gun attached with long pipe, weld# Seg1E-582, Plate detail X308K. The distance is approximately 2 (Two) feet between welder and FCAW welding gun. This QA Inspector submits a TL015 Incident report.

Unless otherwise noted, all 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 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Patel,Hiranch	Quality Assurance Inspector
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Reviewed By:	Prue,Erik	QA Reviewer
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