

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-009130**Date Inspected:** 08-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Li Jia			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 & Tower		

Summary of Items Observed:

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

TRIAL ASSEMBLY YARD

OBG SEGMENT 2AW-2BW

Magnetic Particle Inspection

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 an MT report for this date. The members are identified as OBG Segment 2AW-2BW center and counter weight Deck Panel Diaphragm to Floor beam and upper diaphragm web to flange weld. Numerous areas of welds inspected were partially painted. The weld identification numbers are as follows:

SSD14-PP17-004, 005
SSD12-PP16-004, 005
SSD11-PP15-003, 004
FB007-008-004, 003
FB003-114-005, 004

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BAY #10

This QA Inspector randomly observed the following work in progress

SMAW welding process of weld joint 026 located on PCMK SSTL4-1K/L. Welder is identified as 057239ZPMC QC is identified as Wan Wen Zhong. The welding variables recorded by QC appeared to comply with the WPS-B-P-4112-4.

INCIDENT

OBG SEGMENT-2AW

During the random verification Magnetic Particle Testing (MT) on the weld between deck panel diaphragms to upper floor beam flange at PP15 east side of floor beam in OBG segment 2AW. This QA Inspector discovered two transverse linear indications. The MT indications are approximately 5 to 10 mm in length and are located 1010 cm from the end of the weld (counter weight side). MT inspections of this weld have been previously performed and accepted by ZPMC MT personnel. For additional information see attached photos.

Unless otherwise noted, all work observed on this dated 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: Utekar, Shrikant

Quality Assurance Inspector

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Reviewed By: Clifford, William

QA Reviewer