

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-009535**Date Inspected:** 06-Oct-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:** Wang Chuan 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 and Tower**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.

OBG Trial Assembly:

During random visual observations QA observed ZPMC personnel performing air carbon arc gouging of OBG segment 1AW to 1BW side panel transverse splice weld OBW1A-007. Caltrans QA reviewed ZPMC Weld Repair Report, # 8086 and observed that the repair was for "Transverse Linear Indications found Ultrasonically with Scanning Pattern D" by ZPMC Ultrasonic Testing Technicians. The weld repair report did not require Magnetic Particle Testing (MT) of excavation areas prior to welding. Caltrans QA Inspector performed MT after Air Carbon Arc Gouging and observed numerous transverse linear indications present ranging from 2 mm to 30 mm. Caltrans QA issued an incident report this date the transverse linear indications mentioned above. The Y locations and the number of number of transverse linear indications are as follows:

Weld OBW1A-007

50~2475 mm, (14) Transverse linear indications

2720~5030 mm, (29) Transverse linear indications

See attached photos for additional information

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Bay 10:

This QA Inspector observed the following work in progress: Flux Cored Arc Welding (FCAW) of North Tower Lift 3 weld joint, NSTL3-3 I/K-96. ZPMC welder was identified as 052075. ZPMC QC is identified as Wang Chuan Qing. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-4333-TC-P4-F.

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



Summary of Conversations:

Only general conversation occurred between QC and QA this date.

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
Reviewed By:	Dawson,Paul	QA Reviewer
