

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-009936**Date Inspected:** 23-Oct-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 yang**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, D.Sukanthan was present during the time noted above for observations relative to the work being performed.

OBG # CROSS BEAM 7 (OPEN YARD)

This QA inspector received ZPMC Non Destructive Testing (NDT) notification 004458 to perform Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector performed the required Visual Testing (VT) prior to MT and observed numerous weld profiles that did not appear to comply with the contract documents. This QA observed one weld that appeared to exhibit a crack like linear indication in the crater area of the weld. This indication was verified using the MT method and appeared to be noncompliant to the contract documents. ZPMC QA identified as Mr. Zhang Wei canceled the above mentioned NDT notification after these findings and informed this QA that ZPMC would perform VT and MT again and resubmit the notification at a later date. This QA notified ZPMC QC identified as Mr. Tian Lei and ABF QA identified as Mr. Shen Rushan of this issue and that an incident report would be generated. This QA generated a Magnetic Particle Test report for this weld and date. The member is identified as a side panel. The weld tested is identified as follows:

(CB201G-013-185) Noncompliant indication found by MT method.

This QA Inspector randomly observed the following work in progress:

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

OBG # BAY 5

Flux Cored Arc Welding Process:

Welding of weld joint –010 located on PCMK 10TR1-025. Welder is identified as 217805. ZPMC QC is identified as Wang liyang . The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-TC-U5-F.

Welding of weld joint –012 located on PCMK 10TR1-025. Welder is identified as 215689. ZPMC QC is identified as Wang liyang . The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

Welding of weld joint –005,007 located on PCMK 10TR3-013. Welder is identified as 215009. ZPMC QC is identified as Wang liyang . The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-TC-U5-F.

TOWER # BAY 6(Welding being performed on tower struts)

Shield Metal Arc Welding Process:

Welding of weld joint –008A/B located on PCMK WD1-A305-65M-1. Welder is identified as 048617. ZPMC QC is identified as Sun zi wang. The welding variables recorded by QC appeared to comply with the WPS-485-SMAW-2G (2F)-FCM-Repair-1.

Welding of weld joint –001A/B located on PCMK WD1-A305-65M-1. Welder is identified as 053753. ZPMC QC is identified as Sun zi wang. The welding variables recorded by QC appeared to comply with the WPS-485-SMAW-2G (2F)-FCM-Repair-1.

OBG # BAY 8 (Cross beam # 13)

The Quality Assurance (QA) Inspector observed ZPMC personnel performing weld repair buttering (weld build up) on one (1) cope hole without an approved Critical Weld Repair (CWR) procedure. The contractor was utilizing an approved CWR for a CB12 repair that was not specific to CB13 or this weld joint. The member is identified as Intermediate Crossbeam Diaphragm 205A, CB202G-040-030. This QA notified ZPMC QC identified as Mr. Zhao cheng jian of this issue and that an incident report would be generated.

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

Summary of Conversations:

As mention above

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 150-00422372, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By:	Sukanthan,Dhanasingh	Quality Assurance Inspector
----------------------	----------------------	-----------------------------

Reviewed By:	Hall,Steven	QA Reviewer
---------------------	-------------	-------------
