

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-010177**Date Inspected:** 28-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:** Shen Fu You**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.

During a random 10% verification Ultrasonic Testing (UT) on weld joint identified as SSD34-PP8.5-004/003 on segment 1AAW, the Caltrans Quality Assurance inspector discovered a class "A" non conforming indication measuring approximately 20 mm in length. This weld was previously tested and accepted by ZPMC QC UT technicians. For further information, please see the attached pictures below. Please see incident report on this date.

Segment 1AAW-Super Structure

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member is identified as OBG Components. The weld designations reviewed are as follows:

-(SSD34-PP8.5-004/003)- found rejectable class "A" indication

Bay#14

FCAW welding of weld joint SSD10-PP74-003, 004 located on 9BW. Welder is identified as 201215 (2F). ZPMC QC is identified as Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132.

FCAW welding of weld joint SSD11-PP75-003, 004 located on 9BW. Welder is identified as 47866 (2F). ZPMC

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QC is identified as Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132.

FCAW welding of weld joint SSD12-PP76-004, 005 located on 9BW. Welder is identified as 066401 and 202122 (2F). ZPMC QC is identified as Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132.

SMAW welding of weld joint Seg063A-009 located on 10CW. Welder is identified as 045246 (4G). ZPMC QC is identified as Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-Tc-U4b-FCM-1.

SMAW welding of weld joint Seg063A-010 located on 10CW. Welder is identified as 058242 (4G). ZPMC QC is identified as Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-Tc-U4b-FCM-1.

SMAW welding of weld joint Seg063A-015 located on 10CW. Welder is identified as 047864 (4G). ZPMC QC is identified as Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-Tc-U4b-FCM-1.

SMAW welding of weld joint Seg063A-016 located on 10CW. Welder is identified as 051348 (4G). ZPMC QC is identified as Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-Tc-U4b-FCM-1.

FCAW welding of weld joint Seg059*-011, 012 located on 10AW. Welder is identified as 201215 (3G). ZPMC QC is identified as Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-B-U2-F.

FCAW welding of weld joint Seg059*-019, 020 located on 10AW. Welder is identified as 047866 (3G). ZPMC QC is identified as Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-B-U2-F.

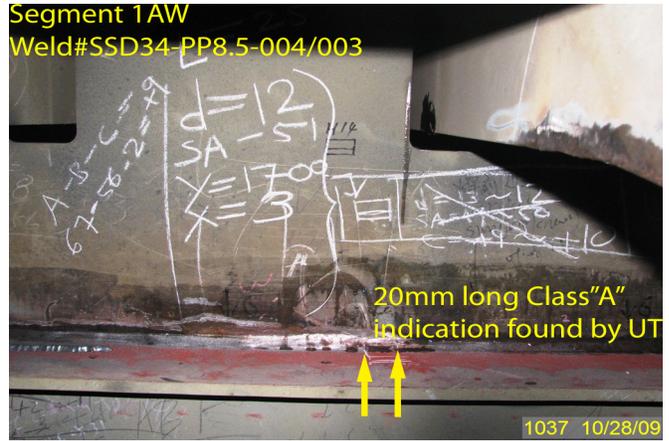
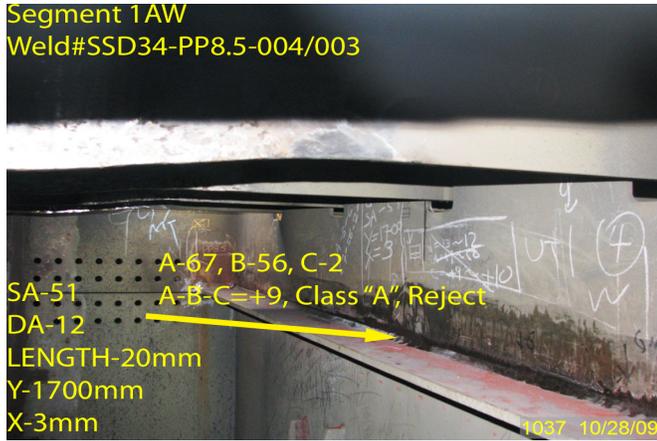
FCAW welding of weld joint Seg059*-027, 028 located on 10AW. Welder is identified as 066401 (3G). ZPMC QC is identified as Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-B-U2-F.

FCAW welding of weld joint Seg059*-031, 032 located on 10AW. Welder is identified as 202122 (3G). ZPMC QC is identified as Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-B-U2-F.

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

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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
Reviewed By:	Patterson, Rodney	QA Reviewer
