

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-010335**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:** Chen Xi**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 COMPONENT**Summary of Items Observed:**

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

Bay #2

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) in the 2G position of the OBG floor Beam assembly weld No. FB-3006-001-146. The welder is identified as #045209. ZPMC QC is identified as Mr. Chen Xi. The welding variables recorded by QC appear to comply with WPS- B – T-2232-Tc-U4b-F.

Flux Core Arc Welding (FCAW) in the 2F position of the OBG Floor Beam assembly weld No. FB-3006-001-104, 105. The welder is identified as #0045203. ZPMC QC is identified as Mr. Zhan Hai Feng. The welding variables recorded by QC appear to comply with WPS- B – T-2132-3.

Flux Core Arc Welding (FCAW) in the 2F position of the OBG Floor Beam assembly weld No. FB-3031-001-038. The welder is identified as #062438. ZPMC QC is identified as Mr. Zhan Hai Feng. The welding variables recorded by QC appear to comply with WPS- B – T-2132-3.

Out Side Segment Yard Area

This QA inspector was instructed by task leaders to carry out Ultrasonic testing (UT) utilizing scanning pattern

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'D' for detecting transverse Indications at corner joint between Edge Panel to Deck Panel for OBG Segment 6CW at work point W5. The indications found on this date were recorded onto a data sheet that Caltrans QA Inspector have filled out.

The Weld Designation is as follows

SEG-031-045
SEG-031-048
SEG-031B-038
CA-029-003

The Quality Assurance Inspector (QA) performed Ultrasonic Testing (UT) verification utilizing scanning pattern 'D' on weld joint identified as SEG-031-045 for OBG segment 6CW. The weld joint UT scanned connects the Edge Plate to Deck Plate corner joint at work point W5. One class "A" rejectable Transverse Crack was discovered measuring 10mm in length.

This weld was previously tested and accepted by ZPMC QC UT technicians although scanning pattern 'D' was not utilized.

The Y location of this class "A" Transverse Crack is as follow; Ind. =700 mm.

The Y locations was taken from panel point 47 side to panel point 44 longitudinal weld seam.

This QA Inspector generated an incident report for this date.

Visual Inspection

During random in-process visual inspection the QA inspector observed lots of porosity and wormhole at the weld area on Floor Beam .

The Weld number is noted as FB-3099-001-001,009 and 010.

For details see attached picture.

Unless otherwise noted, all work 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:	Bera,Subhasis	Quality Assurance Inspector
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Reviewed By:	Patterson,Rodney	QA Reviewer
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