

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-012453**Date Inspected:** 28-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhou zhong hai**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, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

OUTSIDE SHOP

Ongoing SMAW welding of repair weld joint 2G-004 located on PCMK CA056 of Segment 9AW welder is identified as 06558. ZPMC QC is identified as Mr. Wang wei ming. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G(2F)-FCM-Repair-1 and B-CWR-1199.

ZPMC QC MT personnel doing MT of Scan-D UT repair location gouged area of Corner assembly of Segment 9AW the weld is identified as CA055-004. As per approved B-CWR-1199.

During random in-process visual inspection of OBG segment 9BW, Caltrans Quality Assurance (QA) Inspector discovered the following issue; ZPMC performed base metal repairs (BMR) without a critical weld report (CWR). These repairs were performed due to Ultrasonic Indications discovered by ZPMC personnel.

For further more information please see the incident report

04-0120F4_TL-15_B247_02-28-10_9BW_BMR_without_Engineer_Approval.

TRAIL ASSEMBLY YARD

This QA inspector performed MT 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 Segment 6AE+6BE and 6BW. NWIT for this inspection is 005244. The weld designations reviewed are as follows:

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Punch list item 475 @ 6BW, MT after repair.

Punch list item 474 @ 6AE+ 6BE , MT after repair

Punch list item 480 @ 6BE+6CE , Splice weld MT after repair .

This QA inspector performed MT 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 Segment 6CW. NWIT for this inspection is 005244. The weld designations reviewed are as follows:

SEG031H-069,087.

SEG031H-078, 10mm linear transverse indication found, incident report written for this weld.

SEG031J-073,005,014,123.

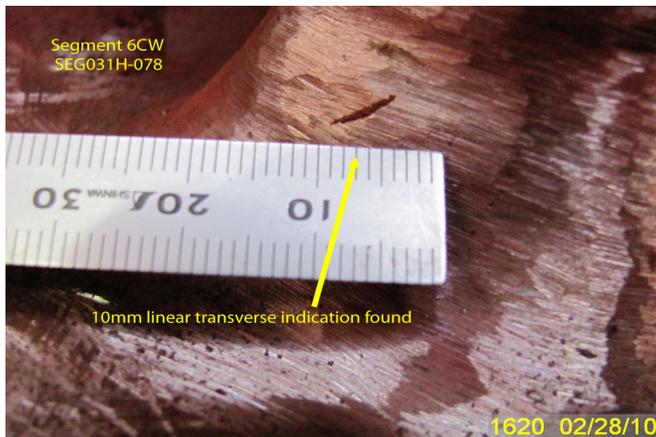
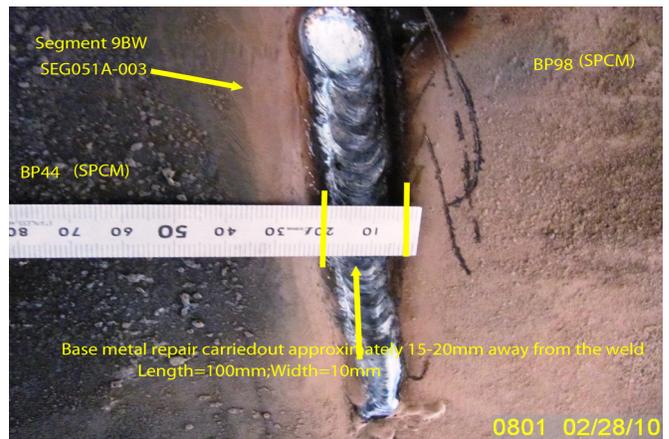
During the Quality Assurance Magnetic particle Testing (MT) review of welds located on OBG Segment 6CW, this Quality Assurance Inspector (QA) discovered the following issue:

One (1) linear Transverse indication that measured approximately 10mm in length.

For further more information please see the incident report

04-0120F4_TL-15_B247_02-28-10_Seg6CW__MT_Linear_Indication[1]

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 Conversation.

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-15--0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Chadra	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
