

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-013031**Date Inspected:** 08-Apr-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:** 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:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this date Caltrans Office of Structural Material (OSM) Quality Assurance (QA) Inspector, D.Sukanthan was present during the time noted above for observations relative to the work being performed.

OBG # BAY 3

This QA inspector received ZPMC Non Destructive Testing (NDT) notification 0005487 to perform Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated a Ultrasonic Test report for this date. The member is identified as Corner Assembly. The weld tested is identified as follows:

(CA3002-023,038)

(CA3003-051)

(CA3004-010)

(CA3005-038)

(CA6501-010,023)

(SEG067D-082)

(SEG068D-006,029,047)

(SEG072E-073)

(SEG072D-006,029)

This QA Inspector randomly observed the following work in progress:

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OBG # BAY 1

This QA observed ZPMC qualified welding personnel identified as 215397 perform Flux Cored Arc Weld (FCAW) Process on weld joint 20TR2-017-011. ZPMC Quality Control Personnel (QC) identified as Mr. Xiang Feng Feng was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2231-TC-U5-F.

This QA observed ZPMC qualified welding personnel identified as 059450 perform Flux Cored Arc Weld (FCAW) Process on weld joint 20TR2-046-011. ZPMC Quality Control Personnel (QC) identified as Mr. Xiang Feng Feng was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2231-TC-U5-F.

OBG # CROSS BEAM CB 9

During random in-process visual inspection of Crossbeam CB9, this QA inspector observed ZPMC personnel base metal repairs being performed in way of temporary attachment removal areas on the Side Panel and Intermediate Web Panel without the prior approval of the engineer. The panel identifications under repair are identified as Side Panel (SP205A SPCM), Intermediate Web Panel (FB202A SPCM & FB201A Non SPCM). The material is A709 Grade 345 Seismic Performance Critical Member (SPCM) and Non Seismic Performance Critical Member (Non SPCM). This QA informed ZPMC QA identified as Zhang wei of this issue and that an incident report would be generated. See attached pictures.

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.

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Inspected By:	Sukanthan,Dhanasingh	Quality Assurance Inspector
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Reviewed By:	Hall,Steven	QA Reviewer
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