

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014001**Date Inspected:** 17-May-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) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. Geng Wei**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 Segment 11CW**Summary of Items Observed:**

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

Magnetic Particle Testing (MT)

This QA inspector performed Visual Testing (VT) on OBG Segment 11CW and VT indications are confirmed by Magnetic Particle Testing (MT) on area previously tested and accepted by ZPMC Quality Control personnel.

This QA Inspector generated an MT report for this date. The indications are clearly marked on the material near the weld for future repair. The members are identified as OBG Segment 11CW. The weld designations reviewed are as follows:

OBG Segment 11CW-PP103 West side

1. FB003-186-005
2. FB009-039-003

OBG Segment 11CW-PP103 East side

3. FB015-040-002
4. FB003-186-004

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OBG Segment 11CW-PP102 East side

5. FB015-043-002

6. FB003-180-004

Description of Incident: During random Quality Assurance Visual review of welds located on segment 11CW, this Quality Assurance Inspector (QA) discovered one (1) Transverse linear indications measuring approximately 12mm in length. The indication were discovered visually and confirmed by Magnetic particle Testing (MT) by Caltrans QA. ZPMC Quality Control MT Technicians claimed that magnetic particle testing have been performed on these welds that require 25% MT. The indication is clearly marked on the material near the weld. The weld number is identified as FB003-186-004. The panel point is identified as a PP103. This weld is a Fillet weld joining the Floor beam Web to Flange. The Floor Beam Flange weld is identified as Non SPCM. For further information, please see the attached pictures

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This QA inspector observed ZPMC qualified welding personnel identified as 055564 perform Flux Cored Arc Welding (FCAW) welding on Segment 12AE, weld joint identified as SP3001B-001-031~035. ZPMC QC is identified as Mr. Wang Xu. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2133.

This QA inspector observed ZPMC qualified welding personnel identified as 044790 perform FCAW welding on Segment 12AE, weld joint identified as SEG3001F-005 and 097. ZPMC QC is identified as Mr. Wang Xu. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2233-B-U2-F.

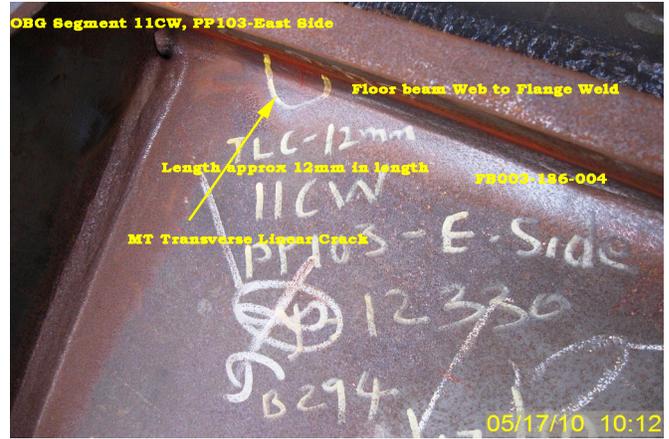
This QA inspector observed ZPMC qualified welding personnel identified as 069841 perform Shielded Metal Arc Welding (SMAW) welding on Segment 12AE, weld joint identified as EP3001A-001-034, 035. ZPMC QC is identified as Mr. Wang Xu. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2214-Tc-U4b-FCM-1.

This QA inspector observed ZPMC qualified welding personnel identified as 067752 and 037996 perform SMAW welding on Segment 12AE, weld joint identified as SEG3001AA-003 and 005. ZPMC QC is identified as Mr. Wang Xu. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2214-Tc-U4b-FCM-1.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

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

Inspected By: Kumar,Vibin

Quality Assurance Inspector

Reviewed By: McClendon,Timothy

QA Reviewer