

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-014299**Date Inspected:** 19-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), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	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.

Ultrasonic Testing (UT)

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as segment 10AW.

The weld designations reviewed are as follows:

SEG059A-012,013,014,016,026,034,035

SSD11A-PP87-004

SEG059D-142,145,151,154

EP131B-001-028,030

SEG059*-026,038

During Caltrans (CT) Quality Assurance random Visual Testing (VT) for segment tagging on Orthotropic Box Girder (OBG) segment 10AW, this Quality Assurance Inspector (QA) discovered the following issues that ZPMC appears to have failed to perform the required VT and Magnetic particle Testing (MT) of hold back area of the fillet weld joints joining two of the stiffeners to the edge plate near Panel Point (PP) 086 on the east side of this

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

panel point between W5 and W6 line. The weld joints are identified as EP131-001-013 and EP131-001-015. The joints have not yet been welded. According to the approved shop drawings 6mm fillet weld required. ZPMC has released OBG segment 10AW to CT to perform segment tag NDT. According to the contract documents ZPMC is required to perform 100% VT and MT of these joints. The Edge panel is designated on the approved shop drawings as Seismic Performance Critical Member (SPCM). The Edge plate is identified as PL1269B (SPCM) and both stiffeners are identified as RS89F. The missing welds are approximately 250 mm in length from panel point PP86. OBG Segment 10AW is located back side of Bay#16.

The QA inspector generated an incident report for this date.

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



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
Reviewed By:	Patterson,Rodney	QA Reviewer
