

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-014962**Date Inspected:** 02-Jun-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.

Magnetic Particle Testing (MPT)

This Quality Assurance (QA) Inspector performed Visual inspection and verification of Magnetic Particle Testing (MT) 15% for Segment 10CW. This QA inspector generated a (MT) report for this date. This weld was previously tested and accepted by ZPMC QC MT technicians.

The weld designations reviewed are as follows:

SEG063D-001,002,004,005,019,020,027,028

SEG063E-056,058,062,063,161,162,151,52,153

SEG063G-005,006,007,008

SSD11A-PP93-130,132,138,142

SSD22-PP93.5-125,126,,127,128,147,148,149,150,157,158,161,162

SSD12A-PP94-132,140,136,144

During the Quality Assurance Magnetic Particle Testing (MT) review of welds located on Segment 10CW, this Quality Assurance (QA) Inspector discovered Two (2) Longitudinal Linear indications on the following welds that Weld # SSD22-PP093.5-140: One (1) Longitudinal linear indication measuring approximately 12 mm in length. This weld is a Fillet Weld joining the Corner Assembly Diaphragm identified as X36B (Non SPCM) to Edge Plate

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Stiffener identified as RS89F (Non SPCM). The weld is designated as Non Seismic Performance Critical Material (Non SPCM). Weld # SSD22-PP093.5-144: One (1) Longitudinal linear indication measuring approximately 09 mm in length. This weld is a Fillet Weld joining the Corner Assembly Diaphragm identified as X36B (Non SPCM) to Edge Plate Stiffener identified as RS89F (Non SPCM)). The weld is designated as Non Seismic Performance Critical Material (Non SPCM). All indications are clearly marked on the material near the weld. OBG segment 10CW is located outside west of Bay#16. The Notice of Witness Inspection Number (NWIT) is 005839. The indications are located inside an area that has been previously tested by ZPMC Quality Control (QC) personnel.

The QA inspector informed to other QA Inspector Mr. Singh to generate 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
