

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-015177**Date Inspected:** 19-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:** Xu Tao**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.

In process Inspection

Out Side

This QA Inspector observed the following work in progress:

SMAW in the 3G position for the OBG Segment 11BE, weld No. SEG068D-106. The welder is identified as #066258. ZPMC QC is identified as Mr. Wang Wai Ming. The welding variables recorded by QC appear to comply with WPS-B-P-4213-Tc-U4b-2.

SMAW in the 2F position for the OBG Segment 11EW, weld No. SSD13-PP107-063. The welder is identified as #051348. ZPMC QC is identified as Mr. Li Ping. The welding variables recorded by QC appear to comply with WPS-B-T-2112-FCM-1.

SMAW in the 4F position for the OBG Segment 11BE, weld No. SEG068D-109. The welder is identified as #066258. ZPMC QC is identified as Mr. Wang Wai Ming. The welding variables recorded by QC appear to comply with WPS-B-T-2214-FCM.

During random visual inspection at segment 12AW at Panel Point 111.5 and PP112.5, this QA Inspector found transverse cracks at several locations at the floor beam web to flange connection in way of previously removed

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tack welds. This QA informed the ZPMC QC Mr. Li Ping and ABF QA Mr. Wen Jian Bao and they stated that further Magnetic Particle would be performed at all locations of tack welds. For more information see the attached photo.

Bay #14

This QA Inspector observed the following work in progress:

FCAW in the 2F position for the OBG Segment 13CE side Plate to stiffener , weld No. SP3066A-001-043~052. The welders are identified as #044830/044795. ZPMC QC is identified as Mr. Wang Xu. The welding variables recorded by QC appear to comply with WPS-B-T-2132.

Bay #19

This QA Inspector observed the following work in progress:

FCAW in the 4F position for the OBG Bike Path BK004A weld No. BK004A8-003-035/036. The welder is identified as #062904. ZPMC QC is identified as Mr. Zhoe Chang. The welding variables recorded by QC appear to comply with WPS-B-T-2134.

Magnetic Particle Testing (MPT) on OBG Segment 8BW,8CW and 9AW

This Quality Assurance (QA) Inspector performed Visual inspection and verification of Magnetic Particle Testing (MT) 15% for OBG segment. This QA inspector generated a (MT) report for this date .This area was previously tested and accepted by ZPMC QC MT technicians. The members are identified as OBG Segments 8BW, 8CW and 9AW.

The weld designations reviewed are as follows:

SEG049B-001,005,006,007,008,009,011,023,024,031

SEG045C-001,005,007,009,011,012,031,032

SEG047F-001, 009,010,011,012,013,037,047

During the Quality Assurance Magnetic particle Testing (MT) review of welds located on Orthotropic Box Girder (OBG) Segment 8BW this Quality Assurance Inspector (QA) discovered the following issue that One (3) Transverse linear indications measuring approximately 7~15mm in length. The weld is identified as SEG045C-043. The weld is designated as Non Seismic Performance Critical Member (Non SPCM). The weld is located at East side of Panel Point PP67 (Crossbeam Side). The indications are clearly marked on the material near the weld. The weld is a Complete Joint Penetration (CJP) Weld joint joining the Longitudinal Diaphragm identified as LD16B (X68D) to Bottom Plate identified as BP149A (PL793A). OBG segment 8BW is located at Trial Assembly area. The Notice of Witness Inspection Number (NWIT) is 006010. The indication is located within area previously tested and accepted by ZPMC Quality Control (QC) personnel.

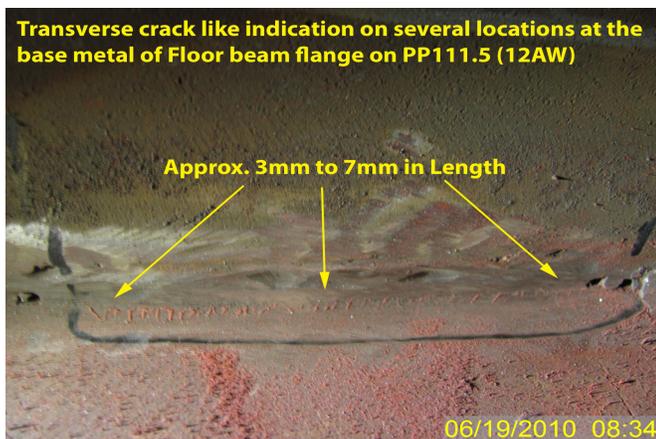
The QA inspector generated an incident report for this date.

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

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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