

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-015215**Date Inspected:** 25-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:** Le Zhi Jiang**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 # CROSSBEAM CB13

This QA inspector received ZPMC Non Destructive Testing (NDT) notification 006043 to perform Magnetic particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated a Magnetic particle Test report for this date. The member is identified as Crossbeam CB13. The weld tested is identified as follows:

(CB202G-040-082) Non complaint Indication

(CB202A-013-020,017)

(CB202G-037-140,158,081,082,087,088,045,046,147,165,153,154,155,156,144,162,099,100)

(CB202G-038-081,082,087,088,140,158,180,181,153,154,155,156,099,100,144,162)

(CB202G-039-081,082,087,088,180,181,140,158,153,154,155,156,099,100,144,162)

(CB202G-040-081,087,088,180,181,140,158,153,154,155,156,099,100,144,162)

(FB205-038-033,034,017,018)

(FB205-039-033,034,017,018)

(FB205-039-033,034,017,018)

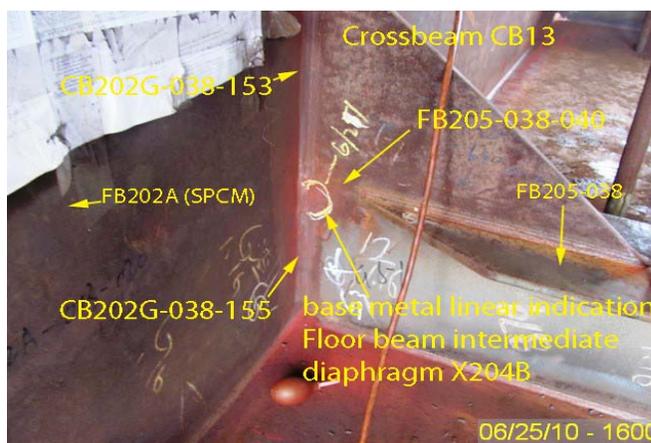
During the Quality Assurance Magnetic Particle Testing (MT) review of welds located on Orthotropic Box Girder

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(OBG) Cross Beam CB13, this Quality Assurance Inspector (QA) discovered the following issues. Two base metal linear indications measuring approximately 18mm and 15mm in length. One longitudinal crack indication measuring approximately 10mm in length. The base metal indications are located on floor beam diaphragm identified as FB205-038 adjacent to welds CB202G-038-153 & 155 (18 mm & 15mm). Welds CB202G-038-153 & 155 are Seismic Performance Critical Material (SPCM) fillet welds joining floor beam FB205-038 to intermediate web plate FB202A (SPCM). Y locations of these indications are approximately 350mm from the bottom panel. The crack indication is located in weld identified as CB202G-040-082. The weld is a fillet weld joining the side panel (SP204A) stiffener to the floor beam identified as FB205-040. Y location of this indication is 0mm. All indications are clearly marked on the material. This QA notified ZPMC QA identified as Mr. Zhang wei of this issue and that an incident report would be generated. For more information refer Magnetic particle Test report for this date. See attached picture.

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

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your project.

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