

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-015857**Date Inspected:** 25-Jul-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:	Geng wei / Li yan hua / 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 Components	

Summary of Items Observed:

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

BAY#14

FCAW welding of weld joint 2F-030 located on PCMK SEG3007B for Segment 13BE the welder is identified as 044795. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2132.

FCAW welding of weld joint 2F-0090 located on PCMK SEG3073-001 for Segment 13BE the welder is identified as 044795. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2132.

SMAW welding of weld joint 3G-010 located on PCMK DP3065-001 for Segment 12CW the welder is identified as 045268. ZPMC QC is identified as Mr. Wang wei ming. The welding variables recorded by QC appeared to Comply with the WPS-345-SMAW-3G (3F)-Repair.

BAY#19

This QA inspector performed 15% MT of weld areas previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an MT report for this date. The Members are identified as OBG Suspender bracket. The weld designations reviewed as follows.

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SB17-086-041 Linear indication found, after grind it was deep slag up to root of the fillet weld.

SB19-078-035, 002,042,053, in VT found incomplete welding, Arc strike, Porosity, Slag etc.

During Visual (VT) and Magnetic Particle Testing (MT) verification of Suspender brackets SB86W and SB78E, this Caltrans Quality Assurance Inspector (QA) discovered the following issues:

SB86W

-During MT of fillet weld, this QA observed one linear indication on weld identified as SB017-086-041.

-The indication was ground by ZPMC personnel and a 10mm long slag inclusion was observed near the root of the fillet weld.

-During QA VT of Cope holes, this QA observed slag inclusion, underfill and overlap.

SB78E

-During VT this QA observed an incomplete weld at cope hole location, the fillet weld is identified as SB019-078-002.

- Arc strike observed on weld and base metal, the fillet weld is identified as SB019-078-042.

-Approx. 5mm deep grinding mark observed on fillet weld identified as SB019-078-035.

- Slag inclusion observed on fillet weld identified as SB019-078-053.

For more information please see the Incident report

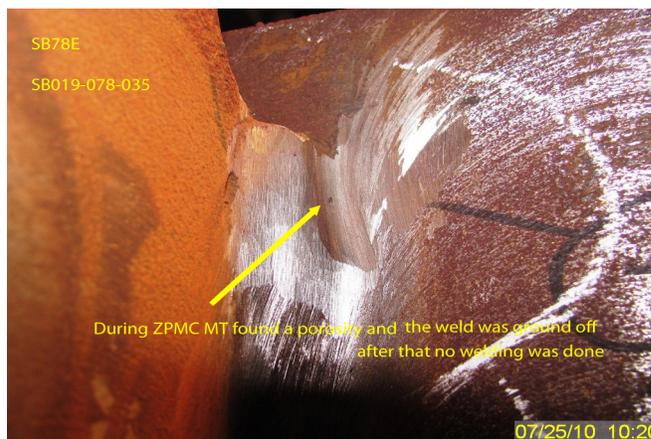
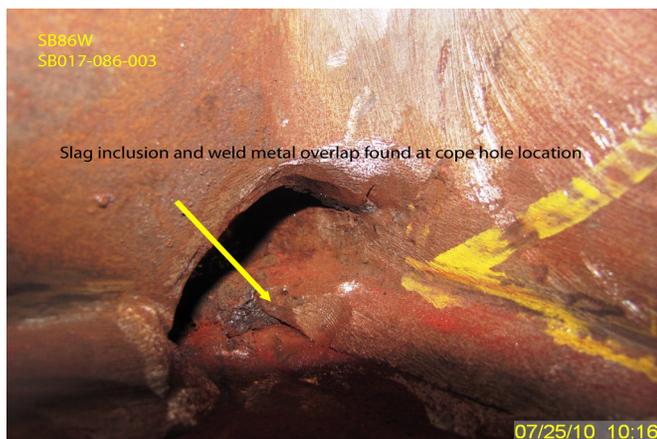
04-0120F4_TL-15_B247_07-25-10_SB86West & SB78E__MT and VT issues.

OUTSIDE SHOP

SMAW welding of weld joint 2F-300 located on PCMK SP745-001 for Segment 11DW the welder is identified as 045263. ZPMC QC is identified as Mr. Li ping. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2112-FCM-1.

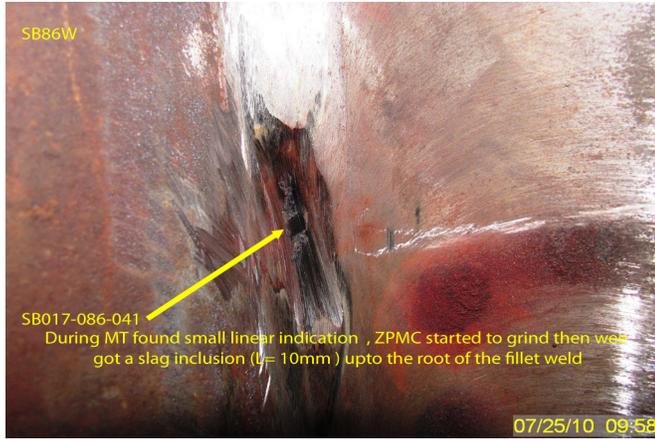
FCAW welding of weld joint 2F-301 located on PCMK SP507-001 for Segment 11DW the welder is identified as 040344. ZPMC QC is identified as Mr. Li ping. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2131.

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



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Summary of Conversations:

No relevant Conversation.

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-15--0042-2372, who represents the Office of Structural Materials for your project.

Inspected By: Kumar,Chadra

Quality Assurance Inspector

Reviewed By: McClendon,Timothy

QA Reviewer
