

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017410**Date Inspected:** 10-Oct-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) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. 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 Bike Path**Summary of Items Observed:**

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

Ultrasonic Testing (UT) – NWIT Document No: 006902

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Bike path. The weld designations reviewed are as follows:

1. BK006A1-002-006, 008
2. BK006A5-002-112, 125, 128, 121, 131

Ultrasonic Testing (UT) – NWIT Document No: 006908

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Bike path. The weld designations reviewed are as follows:

1. BK004A1-001-006, 008
2. BK004A5-001-122, 125, 131, 112
3. BK006A1-001-006, 008

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This QA Inspector observed the following work in progress:

Description of Incident: During the Quality Assurance Ultrasonic Testing (UT) review of weld located on OBG Bike Path, this Quality Assurance Inspector (QA) discovered one (1) Class “A” indications measuring approximately 25-30mm in length. The welds are Complete Joint Penetration butt joints joining the stiffener to stiffener. The indication details that The Indication rating is +3dB and length approximately 25mm. The Thickness of the plate is 10mm and depth of the indication approximately 6mm. The indication is located on the weld joint identified as BK004A5-001-112. The “Y” location for this indication is approximately 50mm from top edge of the stiffener. The weld is a Complete Joint Penetration (CJP) butt weld joint splice of stiffener (BKX7) to stiffener (BKX7). The indications are clearly marked by the QA Inspectors near the weld. These welds joints are designated as non Seismic Performance Critical Member (non SPCM). The OBG Bike Paths are located in the inside of fabrication bay 19. The indications are located within the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. As per the contract documents, ZPMC’s QC personnel are required to perform 100% UT inspection of this weld.

Bay 19

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) welding of weld joint BK004A8-003-130 and 001 located on Bike Path. Welder is identified as 062806. ZPMC Quality Control (QC) is identified as Mr. Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2333-Tc-P4-F.

FCAW welding of weld joint BK004A8-003-002 and 007 located on Bike Path. Welder is identified as 062732. ZPMC Quality Control (QC) is identified as Mr. Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2332-Tc-P4-F.

FCAW welding of weld joint BK004A6-003-002 and 007 located on Bike Path. Welder is identified as 062732. ZPMC Quality Control (QC) is identified as Mr. Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2332-Tc-P4-F.

FCAW welding of weld joint BK006A6-001-002 and 007 located on Bike Path. Welder is identified as 062749. ZPMC Quality Control (QC) is identified as Mr. Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2332-Tc-P4-F.

FCAW welding of weld joint BK004A2-002-002 and 008 located on Bike Path. Welder is identified as 062806. ZPMC Quality Control (QC) is identified as Mr. Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2133.

FCAW welding of weld joint BK004A2-002-013 and 021 located on Bike Path. Welder is identified as 062808. ZPMC Quality Control (QC) is identified as Mr. Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2132.

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FCAW welding of weld joint BK004A2-012-014 located on Bike Path. Welder is identified as 062904. ZPMC Quality Control (QC) is identified as Mr. Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2132-2-plug.

Visual Inspection after Blast

OBG Segment 11DE

This QA Inspector performed a preliminary random visual inspection on OBG Segment 11DE, after the grit blast of the interior components of the deck panel, floor beams and corner assemblies of this segment. Areas of visual weld defects that will require welding were taped and will be repaired after the coating is applied. ZPMC QC personnel are aware of these areas and were present during the inspection.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

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 , who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Vibin	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
