

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:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018024**Date Inspected:** 09-Nov-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:	An Qing Xing	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

Outside Yard

This QA Inspector observed the following work in progress:

FCAW in the 2F position for the OBG segment 11DW, weld No.SP507-001-059. The welder is identified as #054386. ZPMC QC is identified as Mr. Zhou Peng. The welding variables recorded by QC appear to comply with WPS-B-T-2132.

FCAW in the 2F position for the OBG segment 11EW, weld No.SP508-001-007. The welder is identified as #054386. ZPMC QC is identified as Mr. Zhou Peng. The welding variables recorded by QC appear to comply with WPS-B-T-2132.

SMAW in the 4G position for the OBG segment 11DW to 11EW, weld No.SP116-001-061. The welder is identified as #057333. ZPMC QC is identified as Mr. Zhou Peng. The welding variables recorded by QC appear to comply with WPS-B-P-2214-B-U2-FCM-1.

SMAW in the 4G position for the OBG segment 11DE to 11CE, weld No.OBE11C-003. The welder is identified as #040458. ZPMC QC is identified as Mr. An Qing Xiang. The welding variables recorded by QC appear to comply

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with WPS-B-P-2214-B-U2-FCM-1.

FCAW in the 3G position for the OBG segment 11DE to 11CE, weld No.OBE11C-007.The welder is identified as #040367. ZPMC QC is identified as Mr. An Qing Xiang. The welding variables recorded by QC appear to comply with WPS-B-T-2233T.

Ultrasonic Testing (A,B,C and D-Scan)

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The member is identified as Butt joint joining between side Plate to bottom Plate for OBG segment 11BW at crossbeam side. This Inspection was performed after ABF UT Inspectors performed UT of this joint. The result was recorded onto a data sheet according to rejection criteria of “D” Scan procedure that Caltrans QA and ABF QA have jointly filled out on this date. The QA inspector found one rejectable indication at scanned area.

The Weld Designation is as follows

SEG67A-045

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The member is identified as Butt joint joining between side Plate to bottom Plate for OBG segment 11CW at crossbeam side. This Inspection was performed after ABF UT Inspectors performed UT of this joint. The result was recorded onto a data sheet according to rejection criteria of “D” Scan procedure that Caltrans QA and ABF QA have jointly filled out on this date. The QA inspector found no rejectable indication at scanned area.

The Weld Designation is as follows

SEG69A-014

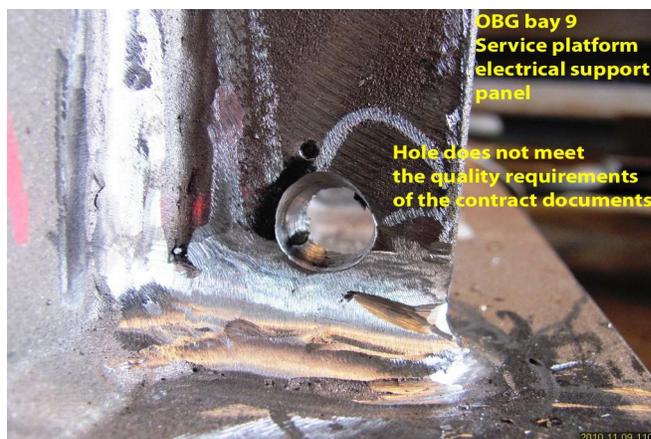
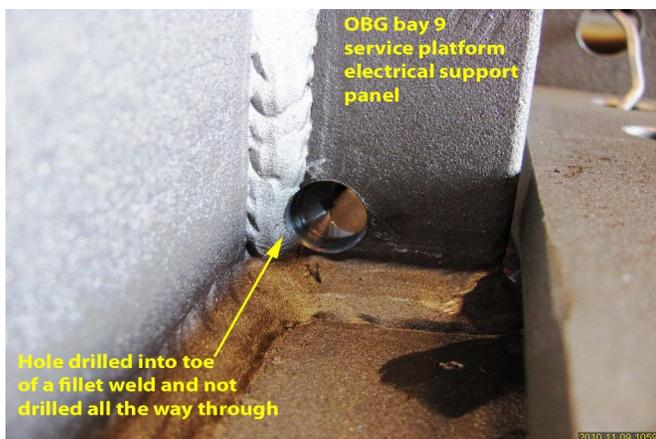
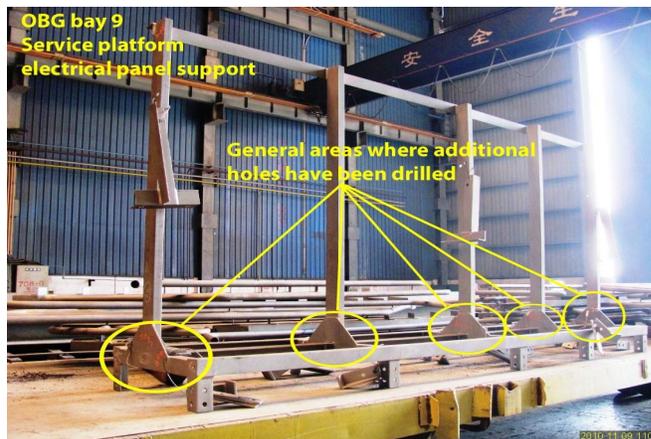
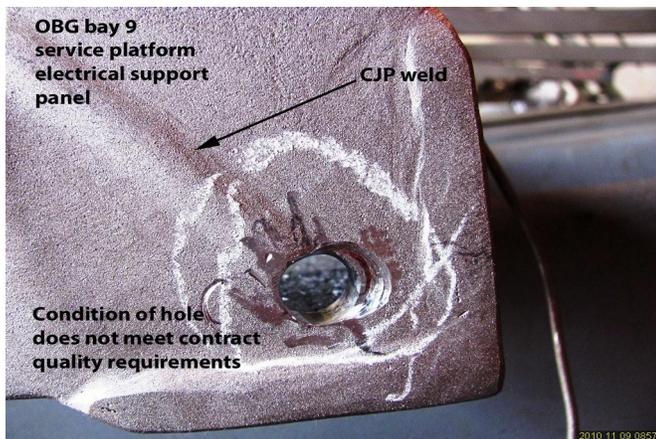
During Quality Assurance (QA) random visual inspection after grit blasting of OBG Service Platform Electrical Panel Support, this Caltrans QA Inspector observed the following issues that ZPMC has drilled approximately 15 to 20 holes which were not specified on the approved shop drawings. The additional holes were drilled in one of the service platform electrical panel supports. These holes were added without the Engineer’s approval. Additionally, The holes do not appear to meet the quality requirements of the contract documents. A number of the holes have been drilled into fillet and CJP welds. The approved shop drawings are identified as SPEP1-A. OBG Service Platform Electrical Panel Support components are located at bay#9.

This QA inspector generated an incident report on this date.

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 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.

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Inspected By:	Bera,Subhasis	Quality Assurance Inspector
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Reviewed By:	McClendon,Timothy	QA Reviewer
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