

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-024380**Date Inspected:** 30-May-2011**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:** Liu Hua Jie/Lv Li Qing**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**Summary of Items Observed:**

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

Ultrasonic Testing:-

OBG Trial Assembly

This QA Inspector performed Ultrasonic testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as OBG Segment 13AW Side Panel Stiffeners. The weld designation reviewed is as follows

SEG3013C-0048,054,060,066,264,266,270,274,276,278,280,282,284,095,290,291,097,099,143,145,147,149

SEG3013G-093,092,090,087,086,084,082,105,106,028,030,034,036

During the Quality Assurance Ultrasonic Testing (UT) verification of weld located on OBG Segment 13AW, this Quality Assurance Inspector (QA) discovered the following issue:

- A class "A" indications measuring approximately 15mm in length.

- The indication details are given as below;

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

The Indication rating is +7dB and length approximately 15mm.

The Thickness of the plate is 22mm and depth of the indication approximately 10mm.

The indication is located on the weld joint identified as SEG3013G-091.

The “Y” location for this indication is approximately 70mm from top edge of this I - Stiffener.

The weld is a Complete Joint Penetration (CJP) ‘T’ weld joint joining Side Plate (SP3091E) I - Stiffener to Floor Beam (FB3193A) at panel point 119+1500.

-The indications are clearly marked by QA near the weld.

-OBG Segment 13AW is located in North Side of OBG Trail Assembly Yard.

-Please see the attached picture.

The Notice of Witness Inspection Number (NWIT) is 009301. The indication is 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.

In process Inspection:-

OBG Trial Assembly

This QA Inspector observed the following work in progress:

SMAW in the 2G position for the OBG Segment 13CE Architectural Housing Assembly. The weld joint was designated as: AH3152A-057. The welder is identified as #051359. ZPMC CWI is identified as Mr. Lv Li Qing. The welding variables recorded by QC appear to comply with WPS-B-P-2212-TC-U4B-FCM-1.

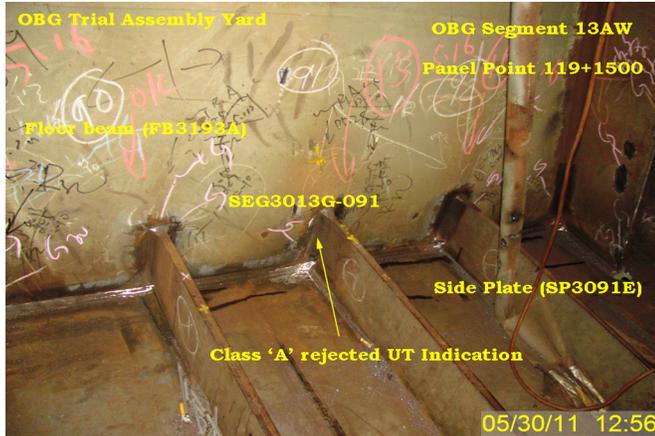
This QA Inspector observed the following work in progress:

SMAW in the 3G position for the OBG Segment 13BE Deck Panel “I” rib. The weld joint was designated as: OBE13J-03. The welder is identified as #070007. ZPMC CWI is identified as Mr. Lv Li Qing. The welding variables recorded by QC appear to comply with WPS-B-P-2213-TC-U4B-FCM-1.

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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



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 150-0042-2372, who represents the Office of Structural Materials for your project.

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| Inspected By: | Pillai,Pandaram | Quality Assurance Inspector |
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| Reviewed By: | Patel,Hiranch | QA Reviewer |
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