

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 #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001794**Date Inspected:** 18-Mar-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 800**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Huang Wen-Pang**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:**

The Caltrans Quality Assurance (QA) Inspector Charlie Franco was present at the time requested to randomly observe welding and associated operations being performed for the Tower and Orthotropic Box Girders (OBG).

The QA Inspector performed a random 10% Visual Testing (VT) Inspection and a random 10% Magnetic Particle Testing (MT) Inspection on the cover passes of the welds attaching stiffeners to the Far Side of Floor Beam Web FB015-03. The QA Inspector randomly observed VT indications on Weld Joint (WJ) 013 (Undersized) and the corner WJ attaching the two flanges, does not run the full length of the WJ (this WJ is not identified on the ZPMC Weld Map). The QA Inspector marked up the areas and informed ZPMC CWI Huang Wen-Pang of the VT indications. The QA Inspector also observed that the Complete Joint Penetration WJ FB015-03-045 attaching the split flange to the 30 mm thick section of Floor Beam Web FB015-03, had a marked Ultrasonic Testing (UT) reject marked adjacent to WJ 045. The QA Inspector accepted all the welds on FB015-03 with the exception of WJ's 013, 045 and the corner WJ attaching the two flanges.

The QA Inspector performed a random 10% VT Inspection and a random 10% MT Inspection on the cover pass of the welds attaching stiffeners to the Far Side of Floor Beam Web FB016-03. The QA Inspector randomly observed a VT indication on WJ 004 at the beginning of the weld in the cope. The QA Inspector also observed that the Complete Joint Penetration WJ FB016-03-045 attaching the split flange to the 30 mm thick section of Floor Beam Web FB016-03, had a marked UT reject marked adjacent to WJ 045. The QA Inspector accepted all the welds on FB016-03 with the exception of WJ's 004 and 045.

The QA Inspector performed a random 10% VT Inspection and a random 10% MT Inspection on the cover pass of

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the welds attaching stiffeners to the Far Side of Floor Beam Web FB008-03. The QA Inspector also observed that the Complete Joint Penetration WJ FB008-03-045 attaching the split flange to the 30 mm thick section of Floor Beam Web FB008-03, had a marked ZPMC UT reject marked adjacent to WJ 045. The QA Inspector accepted all welds on the Far Side of FB008-03 with the exception of WJ FB008-03-045.



Summary of Conversations:

The QA Inspector informed ZPMC Quality Representative Zhang Jiadi that the ZPMC Weld Maps for all of the Floor Beam Web Sub-Assemblies, did not identify the WJ attaching the two flanges. Mr. Zhang informed the QA Inspector that he would follow it up.

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 Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Franco,Charlie

Quality Assurance Inspector

Reviewed By: Hager,Craig

QA Reviewer
