

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-002783**Date Inspected:** 02-Jun-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wei Sei Fa**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 Deck Panel Repairs**Summary of Items Observed:**

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

Bay 3 – New Tower Building

This QA Inspector randomly observed ZPMC welding and quality control personnel performing inspection, grinding, and Flux Core Arc Welding (FCAW) repairs of Orthotropic Box Girder (OBG) deck panel Partial Joint Penetration (PJP) welds. The deck panels in repair process are designated as: DP037-001, DP031-001, DP067-001, DP071-001.

In process deck panel repairs appear to be progressing in compliance with Caltrans Engineer Approved Repair Procedure with exception of that noted as "rejected" below in this report.

The deck panels located in Tower Shop Bay #3 are designated as:

DP038-002 DP077-001 DP074-001 DP051-001 DP043-001 DP042-001
DP080-001 DP006-001 DP053-001 DP049-001 DP055-001 DP025-001
DP026-001 DP007-001 DP030-001 DP031-001 DP068-001 DP071-001
DP075-001 DP078-001 DP042-002 DP072-001 DP065-001 DP006-002
DP056-001 DP067-001 DP054-001 DP001-001 DP005-001 DP040-001
DP041-001 DP050-001 DP015-001 DP039-001 DP038-001 DP037-001
DP029-001 DP052-001 DP003-001

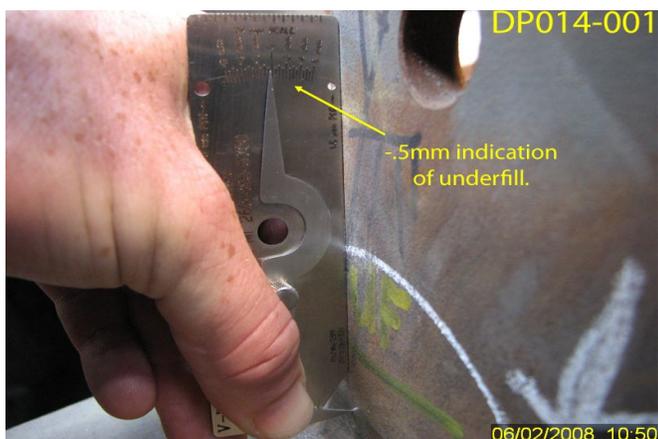
Visual Testing After Repair (REJECT)

WELDING INSPECTION REPORT

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This QA performed Visual Testing (VT) of completed deck panel repairs. The weld repairs were found to be visually rejectable per Caltrans Engineer Approved Repair Procedure. The weld designation number is as follows: DP014-001.

This QA Inspector reviewed the contract files and tracking logs for the Magnetic Particle Testing (MT), Ultrasonic Testing (UT), Welding Procedure Specifications (WPS), Procedure Qualification Records (PQR), and QC Inspector records for the deck panel repairs to date.



Summary of Conversations:

This QA Inspector noted that per ZPMC storage procedures of deck panels after repair completion final QA Magnetic Particle Testing (MT) and final Visual Testing (VT) could not be performed due to lack of access. This QA Inspector performed VT of deck panel designated as DP014-001 at next available access in the NEW OBG Assembly Bay 2. The deck panel was found to contain rejectable indications of Underfill (UF) that would require additional welding before acceptance per Caltrans Engineer Approved Repair Procedure. This QA Inspector informed ZPMC Quality Control personnel Chen Xi of these findings. Mr. Chen informed this QA Inspector that “Caltrans had been provided enough time to perform the necessary inspections in the “repair bay” (New Tower Shop Bay 3) and ZPMC would not repair any deck panels once they arrived in the “assembly bay” (New OBG Assembly Bay 2). This QA Inspector photographed the ZPMC storage of completed deck panel repairs as well as an example of a rejectable indication discovered.

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: Clifford,William

Quality Assurance Inspector

Reviewed By: Cuellar,Robert

QA Reviewer