

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-003794**Date Inspected:** 05-Aug-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1430**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wang 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 Panels**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 1 – OBG Sub Assembly

Magnetic Particle Testing

This QA Inspector performed Magnetic Particle Testing (MT) of tack welds for closed rib Partial Joint Penetration (PJP) on deck panel designated as DP467-001. This QA Inspector found six (6) cracked tack welds of the forty-four (44) tested.

Weld #001 - 13 tested - 3 rejections.

Weld #004 - 8 tested - 1 rejections.

Weld #005 - 9 tested - 0 rejections.

Weld #008 - 7 tested - 2 rejections.

Weld #009 - 7 tested - 0 rejections.

This QA Inspector observed ZPMC Quality Control (QC) personnel performing MT of 100% of tack welds on this deck panel, DP467-001, previously tested. ZPMC did not locate a crack on tack weld located on preparation for weld 001 that had been previously discovered by this QA Inspector. This QA Inspector then retested the tack weld in question with ZPMC QC, ZPMC MT technicians, and Caltrans QA Inspector Dave McClary present. The crack was again located through MT testing and all parties in attendance agreed with this QA Inspectors finding.

ZPMC disputed this QA Inspectors finding of another crack in a tack weld located on preparation for weld 001.

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This tack weld was retested by Caltrans QA Inspector Dave McClary and Mr. McClary was in agreement with this QA Inspector.

ZPMC MT technicians MT tested 270 tack welds in total. Of tack welds tested, ZPMC recorded 34 rejectable indications.

Tracking and Log Book

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:

Conversations as noted above.

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 Ady Velasco, (858) 232-6799, who represents the Office of Structural Materials for your project.

Inspected By:	Clifford,William	Quality Assurance Inspector
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Reviewed By:	Cuellar,Robert	QA Reviewer
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