

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-004242**Date Inspected:** 16-Oct-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1330**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2230**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	NA	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 Fabrication	

Summary of Items Observed:

Caltrans Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. The QA Inspector observed the following:

OBG Bay 1

This Caltrans QA Inspector arrived in OBG bay 1 at 1615 hours to determine the status of deck plate DP109-001 which had the closed ribs tack welded to the deck plate using tack weld procedure number WPS-B-T-2342-U5. No workers were observed to be performing any work on deck panel DP109-001 and the deck panel is clamped to the east side of gantry #2 camber table. The QA Inspector observed workers taking 1.4mm diameter JM-56 / ER70S-6 GMAW welding electrode from a barrel shaped drum and rolling it onto a small drum that is attached to a FCAW welding machine. See the photograph below for additional information. Caltrans had been informed that ZPMC is going to commence magnetic particle inspections of DP109-001 tack welds at 1900 hours. At around 1930 hours ZPMC magnetic particle Inspector Mr. Cai Xinxin arrived in bay #1 and he started to perform magnetic particle inspections of DP109-001 closed rib tack welds. Each of the closed ribs have a total of 28 tack welds on each side of the closed rib. The QA Inspector observed Mr. Xinxin marked a total of 111 tack welds as having rejectable linear indications. Some of the tack welds had linear indications in the center of the welds and other welds had linear indications near one of the ends of the weld. Below is a list of the tack welds that Mr. Xinxin identified as having rejectable indications. Following ZPMC completion of the magnetic particle inspection of the tack welds, the QA Inspector performed random magnetic particle inspections of four tack welds

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on west end of each of the eight closed rib welds which had previously been accepted by Mr. Xinxin. Items observed using MT appear to comply with project specifications. See the TL6028 magnetic particle test report for additional information.

At around 2030 hours the QA Inspector observed one worker preparing to grind the linear indications that have been identified by Mr. Xinxin.

OBG Assembly Bay #2

ABF representative Mr. Kevin Dye informed the QA Inspector that he is going to install green tags on 4BE longitudinal diaphragm plates. The QA Inspector witnessed Mr. Dye installing the green tags and the QA Inspector documented verification of this tagging on the ABF green tag sheet provided by Mr. Dye.

Below is a list of the items that were tagged.

LD009-001 tag #1086

LD010-001 tag #1087

LD004-004 tag #1108

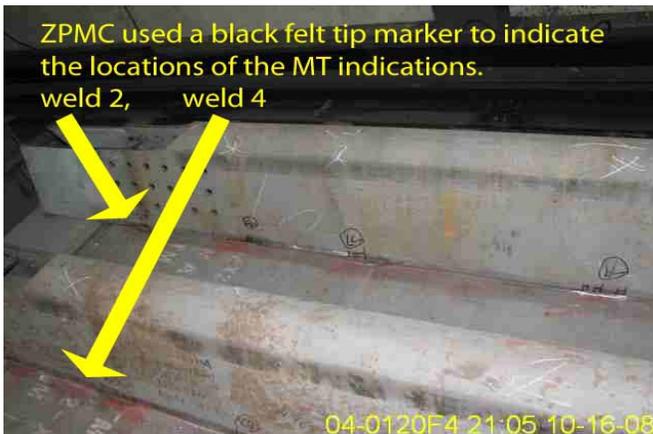
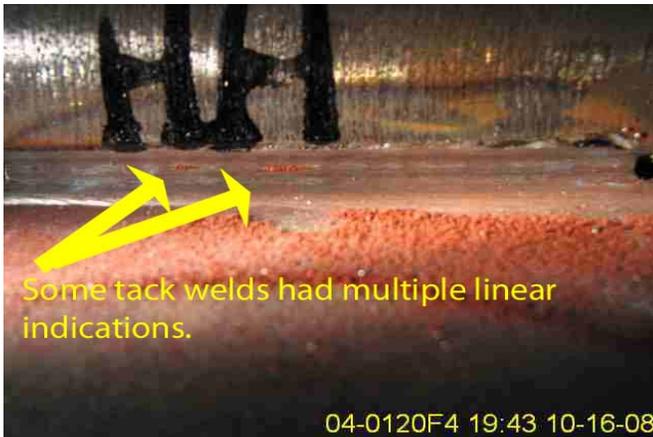
LD003-004 tag #1111

LD003-003 tag #1112

LD018-001 tag #1009

LD017-001 tag #1113

LD004-003 tag #1110



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Summary of Conversations:

See 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 13816942685, who represents the Office of Structural Materials for your project.

Inspected By:	Dawson,Paul	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
