

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-004413**Date Inspected:** 21-Oct-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Lie Yun, Peter Shaw**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 Office of Structure Materials (OSM) Quality Assurance Inspector (QA) Raymond Lara was present at jobsite in Zhenhua Port Machinery Company facility on Changxing island, China for the purpose of observing and monitoring the fabrication of the OBG.

QA observed ZPMC personnel in process grinding tack welds DP324-001 prior to having MT.

QA observed ZPMC Magnetic Particle Testing Technicians perform MT on 280 tack welds on DP 179-001. America Bridge/Flour Quality Assurance Inspector Lie Yun informed the Quality Assurance Inspector, 16 indications were discovered 8 out of the 16 were cracks.

The Quality Assurance Inspector performed magnetic particle testing on tack weld areas on DP 179-001. The Quality Assurance Inspector discovered 2 crack areas overlooked Quality Control. The Quality Assurance Inspector informed the ZPMC Quality Control Inspector on the 2 cracked tack welds that were overlooked. The ZPMC Quality Control Inspector informed the Quality Assurance Inspector the area will be repair prior to welding.

GMAW ROOT on DP 179-001

The Quality Assurance Inspector observed ZPMC welder 059378, utilizing the gas metal arc welding process on a partial penetration weld joint on DP 179-001 weld 9. The Quality Assurance Inspector observed ZPMC Quality Control Personnel record parameters and verify preheat temperatures. The welding parameters observed by the Quality Assurance Inspector appeared to be within welding procedure specification WPS-B-T-2342 (U rib)-4.

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The Quality Assurance Inspector observed ZPMC welder 0062265, utilizing the gas metal arc welding process on a partial penetration weld joint on DP 179-001 weld 10. The Quality Assurance Inspector observed ZPMC Quality Control Personnel record parameters and verify preheat temperatures. The welding parameters observed by the Quality Assurance Inspector appeared to be within welding procedure specification WPS-B-T-2342 (U rib)-4.

OBG Assembly Building

The Quality Assurance Inspector observed ZPMC perform an open root repair on DP050-001. The Quality Assurance Inspector observed ZPMC welder 066239 grind the cracked tack weld area completely open. The QA observed ZPMC perform a preheat on the repair area. When the area was brought up to temperature in accordance with WPS-345-SMAW-2G(2F)-repair ZPMC welder 066239 began welding the open root repair area with the shielded metal arc welding (SMAW) process. The Quality Assurance Inspector observed ZPMC Quality Control perform magnetic particle testing on the root. When the testing was completed, ZPMC welder 066239 completed welding the repair area. American Bridge /Flour Quality Assurance Inspector informed the Quality Assurance Inspector the repaired area will be inspected with ultrasonic testing weld the weld reaches ambient temperature.



Summary of Conversations:

No relevant conversations on this date.

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 Joshua Ishibashi, (707) 649-5453, who represents the Office of Structural Materials for your project.

Inspected By:	Lara, Raymond	Quality Assurance Inspector
Reviewed By:	Wright, Mark	QA Reviewer
