

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-005762**Date Inspected:** 14-Mar-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 500**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Sun Bo			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:

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Larry Viars was present during the times noted above for observations relative to the work being performed.

Bay 9-

Gantry 1 / PMT 1

The Caltrans QA Inspector monitored the OBG Production Monitoring Test (PMT) for Deck Panels DP371-001 (10BE) and 401-001 (11BE). The Caltrans QA inspector recorded amperage, voltage and travel speed of the Gas metal Arc Welding (GMAW) root pass and the Submerged Arc Welding (SAW) cover pass. A Visual inspection of the fit up, tack welds, root pass and cover pass was performed by ZPMC QC Sun Bo, American Bridge Flour (ABF) Cao Hai Zhou and the Caltrans QA. The Caltrans QA observed ZPMC QC Xue Hai Rong perform Ultrasonic testing of the Partial Joint Penetration weld for depth of penetration. Mr. Tang found the depth of penetration of the PMT welds to be in compliance with contract documents. The Caltrans QA inspector designated locations for Macroetch samples (15 locations). Macroetch samples were evaluated with a 7x optical comparator and accepted by ZPMC QC, ABF QC and the Caltrans QA Inspector.

The Caltrans QA recorded the following results of tack weld MT by ZPMC QC on DP371-001 and DP401-001.

DP371-001: 360 tack welds 28 indications found by ZPMC QC

DP401-001: 300 tack welds 5 indications.

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ZPMC performed MT of excavation areas of tack welds for DP371-001 and DP401-001 tack welds and found them to be acceptable.

Bay 2-

This QA inspector performed Magnetic particle testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as OBG 1AA Segment 2D and 2E. The weld identification numbers are as follows, SEG2D-005, 006, 009, 012, 015, 018, 021, 024, 027, 030, 033, 036, 094, 095, 097, 103, 106, 109, 112, 115, 118, 121, 124, 127, SEG 2E-084 through 094, 165 through 175, 176 and 417 through 427.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversations between QA and QC occurred 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 Eric Tsang 150 0042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
