

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-007339**Date Inspected:** 19-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Huang Wen pang**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 / TOWER**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, D.Sukanthan was present during the time noted above for observations relative to the work being performed.

OBG # Cross Beam 10- BAY 3

This QA inspector performed Magnetic Particle Test of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an Magnetic Particle Test report for this date. The member is identified as Cross Beam. The weld designations reviewed are as follows:

(CB202F-010-002)

(CB202D-010-002)

TOWER # BAY 11

This QA inspector performed Magnetic Particle Test of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an Magnetic Particle Test report for this date. The member is identified as West Tower 7 pieces double diaphragms. The weld designations reviewed are as follows:

(WSD1-A423 B/H – 2B)

(WSD1-A115 E/J – 24B)

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This QA Inspector randomly observed the following work in progress:

OBG # Cross Beam 7- BAY 1

Flux Cored Arc Welding Process:

Welding of weld joint –040 located on PCMK FB204-013. Welder is identified as 054460. ZPMC QC is identified as Huang Wen pang. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-3G(3F)Repair.

Submerged Arc Welding Process:

Welding of weld joint –004 located on PCMK CB201C-007. Welder is identified as 207345. ZPMC QC is identified as Huang Wen pang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-B-L2C-S-2.

OBG # Cross Beam 10 - BAY 3

Submerged Arc Welding Process:

Welding of weld joint –001,002 located on PCMK CB202B-010. Welder is identified as 044780. ZPMC QC is identified as Huang Wen pang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-B-L2C-S-2.

OBG # Cross Beam 06 – Open yard

This QA Inspector observed ZPMC personnel performing weld buttering (build up with weld) on a FCM and Non FCM component without an approved Critical Weld Repair procedure. The member is identified as bottom plate and side plate (Drawing No: CB202C, CB202D & CB202F). The buttering is being performed to correct a dimensional issue with the member. The material is 12mm thick. The amount of buttering exceeds ¼ of the thickness of the material. The contractor has buttered all bottom plates and side plates for the entire length of the plate.

Summary of Conversations:

The QA Inspector informed ZPMC QC Mr. Liu wei wei that the QA Inspector observed ZPMC personnel performing weld buttering (build up with weld) on a FCM and Non FCM component without an approved Critical Weld Repair procedure. The member is identified as bottom plate and side plate (Drawing No: CB202C, CB202D & CB202F). The contractor has buttered all bottom plates and side plates for the entire length of the plate. The QA Inspector informed that the QA Inspector will be issuing incident report.

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 150-00422372, who represents the Office of Structural Materials for your project.

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Inspected By:	Sukanthan,Dhanasingh	Quality Assurance Inspector
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Reviewed By:	Prue,Erik	QA Reviewer
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