

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-007456**Date Inspected:** 08-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

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|------------------------------------|------------|----------------------------------|---------------|----|
| CWI Name: | N/A | 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 COMPONENT | |

Summary of Items Observed:

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

Magnetic Particle Testing

The Quality Assurance Inspector (QA) performed 100% verification of Magnetic Particle Testing (MT) after ZPMC QC repair on weld joint identified as SSD16A-PP26-003 located in 4BE. The QA Inspector discovered a non conforming transverse linear indication measuring approximately 7 mm in length. The weld was previously tested and accepted by ZPMC QC MT technicians. For further information please see the MT report for this date.

For more details please refer the incident report.

The MT members are identified as

SSD16A-PP26-003
SSD18A-PP28-005
SSD18-73&175

Visual Inspection

Segment 4AE the weld joints CA008-026,027 The QA observed ZPMC welder (066480) utilizing a buttering weld

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technique to repair the base metal the end of stiffener X37B. The welder mentioned above was working without a Welding Repair Report (WRR), Approved WPS and CWI present during the welding process. This repair was being performed on weld joint CA008-026,027 in segment 4AE.

The QA Inspector performed for segment 4AE & 4BE ,clearing the outstanding Punch list .

The item was 37 numbers but the QA Inspector found only 4 item was ready for inspection and remaining all item to be rectified from ZPMC.

The cleared item number were 885,886,888&889.

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

Summary of Conversations:

No relevant conversations

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.

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| Inspected By: | Bera,Subhasis | Quality Assurance Inspector |
| Reviewed By: | Prue,Erik | QA Reviewer |
