

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-007458**Date Inspected:** 16-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:** WU ZHI CHENG**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.

In process Inspection

OUTSIDE SEGMENT ASSEMBLY AREA

This QA Inspector randomly observed ZPMC welding personnel performing fillet welding of weld joint EP-105A-001-016&018 filler passes at segment 2AE. The personnel were observed welding in the 2F position utilizing a FCAW process. Welder is identified as 220077. The welding variables recorded by QC appeared to comply with the WPS- B – T – 2132.

This QA Inspector randomly observed ZPMC welding personnel performing fillet welding of weld joint EP-105A-001-017&019 filler passes at segment 2AE. The personnel were observed welding in the 4F position utilizing a SMAW process. Welder is identified as 037748. The welding variables recorded by QC appeared to comply with the WPS- B –P-2114-FCM-1.

This QA Inspector randomly observed ZPMC welding personnel performing groove welding of weld joint SEG-010A-007&008 filler passes at segment 2BE. The personnel were observed welding in the 2G position utilizing a FCAW process. Welder is identified as 220069. The welding variables recorded by QC appeared to comply with the WPS- B – T – 2232-TC-U5-F.

WELDING INSPECTION REPORT

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This QA Inspector randomly observed ZPMC welding personnel performing groove welding of weld joint SEG-014A-005&031 filler passes at segment 3AE. The personnel were observed welding in the 4G position utilizing a SMAW process. Welder is identified as 048659. The welding variables recorded by QC appeared to comply with the WPS- B -P-2214-B-U2-FCM-1.

Magnetic Particle Testing

This Quality Insurance Inspector (QA) performed 15% verification Magnetic Particle Testing (MT) for segment 4AE &4BE at X37A to I-rib. This weld was previously tested and accepted by ZPMC QC MT technicians.

The weld designations reviewed are as follows:

For Segment 4AE

CA-008-58,60,46,48,34,36,22&24

CA-012-26,38,50,62,74& 86

SEG-20D-10&31

For Magnetic Particle Testing verification on weld joint identified as CA-010-22,24,34,36,46,48,58&60 and CA-28,40,52,64,76,88 of segment 4AE and 4BE at X37A to I-rib location, the QA Inspector found undercut ,side wall fusion and cavity at weld and base Metal area. These welds were previously inspected and accepted by ZPMC Quality Control (QC) personnel.

For details refer the incident report.

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.

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