

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-008000**Date Inspected:** 05-Jul-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhang Zhi Neng**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:** Tower&OBG**Summary of Items Observed:**

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

TRIAL ASSEMBLY YARD**Magnetic Particle inspection**

This Q.A Inspector performed Magnetic Particle Inspection of approximately 15% of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (M.T) report for this date. The members are identified as the Floor Beam Designation are as follows.

SSD27-PP21-17, 21, 25, 27, 33, 34, 42, 44, 51, 52, 129, 130, 134, 135, 165, 166, 161, 162

SSD25-PP21-21, 22, 33, 34, 41, 42, 43, 44, 97, 98, 109, 110, 178, 172, 173, 165, 166, 161

BAY#11

This QA Inspector randomly observed the following work in progress

SAW welding process of weld joint 32B located on PCMK WSD1-FESA4-4D/D. Welder is identified as 040772
ZPMC QC is identified as Zhi Zhang. The welding variables recorded by QC appeared to comply with the
WPS-B-T-2221-B-U3-C-S-2

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FCAW welding process of weld joint 48 located on PCMK ESTL3-4-J/K. Welder is identified as 069043 ZPMC QC is identified as Li Jing Bo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133.

FCAW welding process of weld joint 120 located on PCMK ESTL3-4-H/K. Welder is identified as 070212 ZPMC QC is identified as Li Jing Bo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133.

TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress.

FCAW welding process of weld joint 15 located on PCMK SEG013B. Welder is identified as 202841 ZPMC QC is identified as Chen Bo. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-2G (2F) Repair.

FCAW welding process of weld joint 16 located on PCMK SEG013B. Welder is identified as 202841 ZPMC QC is identified as Chen Bo. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-2G (2F) Repair.

This QA Inspector observed LD at PP28-29 in segment 4BE south side tacked and welding in progress.

This QA Inspector observed LD at PP22-23 in segment 3BW North side tacked and welding in progress.

This QA Inspector observed LD short at PP25 in segment 4AW North side tacked and welding in progress.

This QA also noted that ZPMC performing Drilling holes on Edge panel and Deck panel for the Suspender bracket 34, 32, 30 Bike path side.

TRIAL ASSEMBLY YARD

Visual Inspection

During the random visual inspection this Caltrans QA Inspector observed the root opening between floor beam stiffener to short Longitudinal Diaphragm more than 15mm at PP25 in segment 4AW North side. According to ZPMC CWI this joint is CJP but ZPMC performed welding without making groove. For additional information see photo below. For this issue informed to task leader and other supervisor.

During the random Visual inspection this Caltrans QA Inspector observed the root opening between floor beam stiffener to Longitudinal Diaphragm more than 8mm at PP28 in segment 4BE South side. According to ZPMC CWI this joint is CJP but ZPMC performed welding without making groove. For additional information see photo below.

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

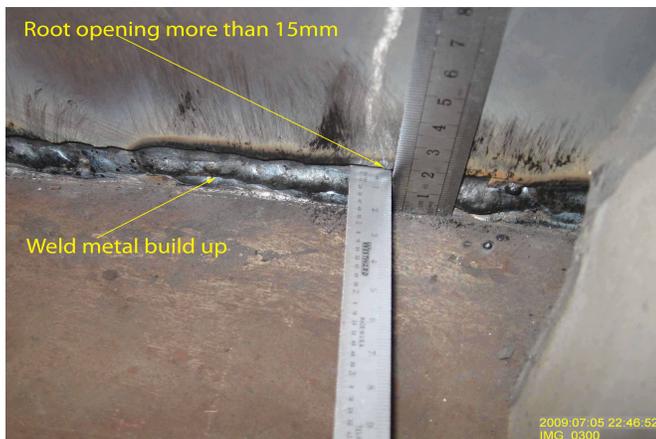
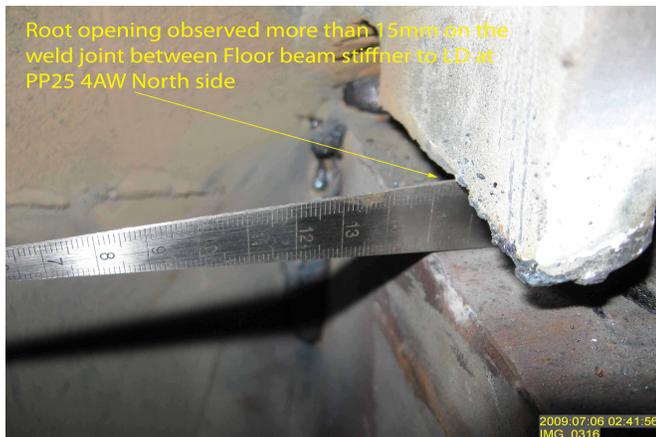
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documents. For this issue informed to task leader and other supervisor.

During random in-process visual inspection in trial assembly of segment 3BW, Caltrans Quality Assurance (QA) Inspector observed the root opening of the weld joint between Longitudinal Diaphragm to Bottom panel (SEG013B-15, 16) to be more than 15mm. This root opening exceeds the tolerances specified in AWS D1.5 2002. Incident report issued. For additional information see photo below.

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



Summary of Conversations:

No relevant conversation

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 + (86) 15000422372, who represents the Office of Structural Materials for your project.

Inspected By: Utekar, Shrikant

Quality Assurance Inspector

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Reviewed By: Clifford, William

QA Reviewer