

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-008442**Date Inspected:** 12-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:** Li Zhi jiang**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 Components**Summary of Items Observed:**

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

Bay#2- Segment 1AAW

This QA inspector witnessed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel of Segment 1AAW, seg1E stiffeners weld removal areas. ZPMC QC-CWI Li Zhi Jiang and ABFJV Wang Wen Bin were present during observation. The member is identified as Segment 1AAW. The weld designations reviewed are as follows:

-(Seg1E-096, 177, 137, 227, 429, 385, 347, 305) Location-A-013

-(Seg1D-150, 151, 127, 128) Location A-013

-(Seg1E-299, 341) Location A-007

-(Seg1D-108) Location A-007

-(Seg1E-422, 340, 380, 298) Location A-006

-(Seg1D-105, 107) Location A-006

-(Seg1E-295, 337) Location A-003

-(Seg1D-096) Location A-003

During random verification Magnetic Particle Testing of the internal components of OBG Segment 1AAW, Caltrans Quality Assurance (QA) Inspector discovered a total of (4) Four, linear indications from 05mm to 12mm in length in the base metal (weld removal area) at location A13, plate detail is X181A. After grinding excavation is

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5 mm deep. These areas have been previously tested and accepted by ZPMC Quality Control MT Technicians.

Bay #2, Segment 1AAW

This QA inspector observed the following work in progress:

FCAW welding of weld joint Seg1E-111, 192, Seg1C-015, Seg1E-444, 402, Seg1C-130 located on A-028 on Segment 1AAW. Welder is identified as 068916 (3G). ZPMC QC-CWI is identified as Li Zhi Jiang . The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint Seg1E-417, 455, Seg1C-097 located on A-039 on Segment 1AAW. Welder is identified as 066251 (3G). ZPMC QC-CWI is identified as Li Zhi Jiang . The welding variables recorded by QC appeared to comply with the Applicable WPS.

Joint Fit-Up verified, SMAW welding of weld joint Seg1E-417, 455, Seg1C-097 located on A-039 on Segment 1AAW. Welder is identified as 066457 (3G). ZPMC QC is identified as Li Zhi jiang. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Joint Fit-Up verified, SMAW welding of weld joint Seg1E-096, 177, Seg1D-151 located on A-013 on Segment 1AAW. Welder is identified as 066457 (3G). ZPMC QC is identified as Li Zhi jiang. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Joint Fit-Up verified, SMAW welding of weld joint Seg1F-022, Seg1E-214, and Seg1C-001 located on A-041 on Segment 1AAW. Welder is identified as 066457 (3G). ZPMC QC is identified as Li Zhi jiang. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Joint Fit-Up verified, SMAW welding of weld joint Seg1E-353, 311, Seg1D-146 located on A-019 on Segment 1AAW. Welder is identified as 066457 (3G). ZPMC QC is identified as Li Zhi jiang. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Joint Fit-Up verified, SMAW welding of weld joint Seg1E-148, 238, Seg1C-058 located on A-024 on Segment 1AAW. Welder is identified as 066457 (3G). ZPMC QC is identified as Li Zhi jiang. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Unless otherwise noted, all 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: Patel,Hiranch

Quality Assurance Inspector

Reviewed By: Prue,Erik

QA Reviewer