

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-008444**Date Inspected:** 25-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 performed random VT after welding of the shim plate area. The member is identified as segment 1AAW. ZPMC QC-CWI Li Zhi Jiang and ABFJV Wang Wen Bin were present during observation. This QA found all weld within tolerances and acceptable.

Caltrans Quality Assurance Inspector observed on Segment 1AAW, moved to blast shop for blasting and painting. The following outstanding problems exist on this segment.

1. Segment Tag#2:- Deep grinding of 3.5mm found at location A13 on side plate-PL1473A.
2. Segment Tag#2:- No CWR's for the weld# Seg1-018, Seg1-021, Seg1-022, and Seg1-024. (Reference incident report#363)
3. Segment Tag#4:- RFI is not approved for weld# Seg1E-1000 and Seg1E-1001, at location A38, A39 and A40. According to drawing it should be mill to bear. ZPMC weld these areas and convert that into CJP joint. At both end 50mm area is fillet welds. (Reference incident report#496)
4. Segment Tag#4:- No CWR's for the weld# Seg1A-023, Seg1A-026, Seg1A-028, Seg1A-032, and Seg1A-033. (Reference incident report#363)
5. No CWR's for the cracked tack weld# Seg1E-031, Seg1E-034, Seg1E-039, Seg1E-040, Seg1E-078, Seg1E-486, Seg1E-489, Seg1E-658, Seg1E-659, Seg1E-660, Seg1E-661, Seg1E-662 and Seg1E-663. (Reference NCR# ZPMC-0257)

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Caltrans Quality Assurance Inspector observed on Segment 1AAE, Location A-00 to A-41, distortion in the plates, Plate# PL1472B and PL1472A respectively. Because of welding and cutting operations these plates have a measured distortion at the center of the plate PL1472A is 13mm and on PL1472B is 08mm. This QA Inspector submits a TL015 Incident report.

Bay #2, Segment 1AAW

This QA inspector observed the following work in progress:

FCAW welding repair of shim plates at locations A07, A08, A09, A10 on Segment 1AAW. Welder is identified as 048433 (3G). ZPMC QC-CWI is identified as Li Zhi Jiang . The welding variables recorded by QC appeared to comply with the Applicable WPS.

SMAW welding of pipe locations A13/14 on Segment 1AAW. Welder is identified as 058242(4G/F). ZPMC QC-CWI 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.

Inspected By:	Patel,Hiranch	Quality Assurance Inspector
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Reviewed By:	Prue,Erik	QA Reviewer
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