

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-008613**Date Inspected:** 25-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:** Li Jia, Du Zhi Gun**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.

BAY#10

This QA Inspector randomly observed the following work in progress

SMAW welding process of weld joint 132B located on PCMK NSD1-FBSA4-1E/E. Welder is identified as 040269 ZPMC QC is identified as Shi Jing Wei. The welding variables recorded by QC appeared to comply with the WPS-B-T-3311-TC-P5.

FCAW welding process of weld joint 56 located on PCMK NSD1-TL8J/L. Welder is identified as 070212 ZPMC QC is identified as Deng Zhi Bing. The welding variables recorded by QC appeared to comply with the WPS-B-T-2331-TC-P4-F.2

FCAW welding process of weld joint 55 located on PCMK NSD1-TL8J/L. Welder is identified as 068865 ZPMC QC is identified as Deng Zhi Bing. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P4-F.2

TRIAL ASSEMBLY YARD

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This QA Inspector randomly observed the following work in progress.

OBG SEGMENT-3AE

FCAW welding process of weld joint 005 located on PCMK SSD17-PP021. Welders are identified as 050242, 051356 ZPMC QC is identified as Zhong Hai Tao. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-2G (2F) Repair.

OBG SEGMENT-4AE

This QA Inspector observed that the ZPMC NDT Inspector performing Magnetic Particle Inspection on the excavation of the weld joint between deck panel diaphragm to floor beam diaphragm (SSD20-PP25-005).

FCAW welding process of weld joint 005 located on PCMK SSD20-PP025. Welders are identified as 044795, 044774 ZPMC QC is identified as Li Jia. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-2G (2F) Repair.

OBG SEGMENT-1AAE

SMAW welding process for the base metal repair on the 'I' rib of the bottom panel. Welder are identified as 050433, 045133, 045196, 045138 ZPMC QC is identified as Zhong Hai Tao. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G (3F) Repair.

OBG SEGMENT-3AE&4AE

Visual Inspection

This Caltrans Quality Assurance Inspector (QA) observed that the Contractor is in the process of performing weld repairs without an approved procedure. The weld joints in question are being repaired due to what appears to be delayed transverse cracks discovered using Magnetic particle Testing (MT) at the trial assembly stage. These welds were previously tested and accepted using the MT method. This condition exists on OBG segment 3AE at PP21, PP22 and OBG segment 4AE at PP24, PP25, The weld joints are identified as SSD18-PP22-004, 005; SSD17A-PP21-004, 005; SSD20-PP25-004, 005; SSD19-PP24-005, 004. See the photos below for more information. For this issue incident report was issued.

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

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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 Serge Sinevod 13482570045, who represents the Office of Structural Materials for your project.

Inspected By: Utekar,Shrikant

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer