

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-008869**Date Inspected:** 13-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 MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member is identified as OBG Segment 1AAW welds. The weld designations reviewed are as follows:

-(Seg1E-380, 422, Seg1D-107) Location A-06

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-164, 254, Seg1C-026) Location-A-40

Bay#2- Segment 1AAE

This QA inspector witnessed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel of Segment 1AAE, seg2E 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:

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-(Seg2E-241, 151, Seg2C-041) Location-A-27

-(Seg2E-355, 313, Seg2C-148) Location-A-21

During verification of joint fit up of segment weld#Seg1E-380 at location A006, Caltrans Quality Assurance (QA) Inspector discovered a total of (4) Four, full length (100mm~150mm) linear indications in Tack Welds. Caltrans Quality Assurance (QA) Inspector also evaluates those linear indications by Magnetic Particle testing. ZPMC Quality Control starts final welding by FCAW near to tack welds without rectifies the problem and final welding was merged with the defective tack welds. See incident report on this date

During random verification Magnetic Particle Testing of segment weld#Seg1E-111, Seg1E-192 and Seg1C-015 at location a-028, Caltrans Quality Assurance (QA) Inspector observed that ZPMC QC welded all around. According to approved drawing, 25R cope holes at both side located at the bottom of the stiffener, plate detail X307S. ZPMC QC welds and fills the area of cope holes that does not comply with approved drawing. See incident report on this date

During random verification Magnetic Particle Testing of the internal components of OBG Segment 1AAW, Caltrans Quality Assurance (QA) Inspector discovered a total of (7) seven, linear indications from 05mm to 20mm in length in the base metal (weld removal area) at location A13, plate detail is X304A, X196S and X186A. On plate detail X304A, indication is on the top surface of excavation. These areas have been previously tested and accepted by ZPMC Quality Control MT Technicians. See incident report on this date

Bay #2, Segment 1AAE

This QA inspector observed the following work in progress:

SMAW welding of weld joint Seg2E-343, 301, 425, 383, Seg2D116, 118 located on A-09 on Segment 1AAE. Welder is identified as 045268 (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 weld joint Seg2E-083, 124, 334, 416 located on A-00 on Segment 1AAE. Welder is identified as 045268 (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 weld joint Seg2F-022, 023, 043, 024, 044, 025, 026, 027, Seg2D-002, 004, 088, 090 located on A-00 on Segment 1AAE. Welder is identified as 045268 (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 weld joint Seg1E-164, 254, Seg1C-026 located on A-40 on Segment 1AAW. Welder is identified as 045260 (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-362, 320, Seg1C-128 located on A-28 on Segment 1AAW. Welder is identified as 058245 (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 Seg1F-023, Seg1C-001, and Seg1E-255 located on A-41 on Segment 1AAW.

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Welder is identified as 066283 (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 Seg1F-026, Seg1C-088, and Seg1E-333 located on A-41 on Segment 1AAW. Welder is identified as 066283 (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-340, 298, Seg1D-105 located on A-0 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.

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
Reviewed By:	Prue,Erik	QA Reviewer
