

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-009627**Date Inspected:** 02-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1745**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Peng guo.**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 Components**Summary of Items Observed:**

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

This QA Inspector observed the following work in progress:

Bay11, East Tower, Lift 4, A/E Corner Seam(Inside).

FCAW welding of weld joint ESTL4-2B/L-43, 44; located on Bay11, East Tower, Lift 4. Welders are identified as 066471; ZPMC Quality Control Inspector (QC) is identified as Peng guo. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: 1)WPS-B-T-2333-TC-P5-F.

Bay11, East Tower, Lift 4, B/C Corner Seam(Inside).

FCAW welding of weld joint ESTL4-2B/L-58B; located on Bay11, East Tower, Lift 4. Welders are identified as 048810; ZPMC Quality Control Inspector (QC) is identified as Peng guo. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: 1)WPS-B-T-2232-TC-U4-F.

Bay11, South Tower, Struts Repair.

Repair gouge out noticed on strut weld Identified as SD1-A6002-1-9B. see attached picture for details.

Tower Jetty(Heavy Dock), East Tower, Lift 1.

1) Installing Interior Splice Plate on skin A & C.

2)Drilling holes on Doubler Plates between 47.6M, 43M, 28M, 18M Double Diaphragms on Skin A & E.

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This QA Inspector carried out NDE on following:

Outside Yard(Heavy Dock), East Tower, Lift 1, Grating Brackets.

This QA inspector performs Random Visual Testing (VT) of area previously tested and accepted by ZPMC Quality Control personnel, for GREEN TAG. The members are identified as,

- 1) GGSA-2PLAN-15M-LOT.
- 2) GGSA-4PLAN-18M-LOT.
- 3) GGSA-6PLAN-18M-LOT.
- 4) GGSA-8PLAN-23M-LOT.
- 5) GGSA-10PLAN-23M-LOT.
- 6) GGSA-12PLAN-28M-LOT.
- 7) GGSA-14PLAN-28M-LOT.
- 8) GGSA-16PLAN-33M-LOT.
- 9) GGSA-18PLAN-33M-LOT.
- 10)GGSA-20PLAN-38M-LOT.
- 11)GGSA-22PLAN-38M-LOT.
- 12)GGSA-24PLAN-43M-LOT.
- 13)GGSA-26PLAN-43M-LOT.
- 14)GGSA-28PLAN-47.6M-LOT.
- 15)GGSA-30PLAN-47.6M-LOT.

During this Inspection this QA inspector observed three weld joints with unacceptable weld profile. Weld joints Identified as

- 1) GGSA-30PLAN-47.6M-1
- 2) GGSA-2PLAN-15M-5
- 3) GGSA-4PLAN-18M-1

ZPMC agreed to repair rejected welds & renotify for visual Inspection. This QA inspector have submitted Incident report on this issue on same date.

Unless otherwise noted, all work observed on this date 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:	Juvekar,Amit	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
