

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-010172**Date Inspected:** 24-Oct-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:	Shen Fu You/Zhu Zhong Hai	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.

Segment 6AW

During random visual inspection of OBG segment 7EE, this QA inspector found that ZPMC has deviated the joint design on weld#CSD7-PP060-139, 140, 141, 142, 143, 144, 145, and 146. According to approved drawings these welds are 8mm fillet welds, ZPMC has changed these welds to CJP. For further information, please find attached pictures.

Segment 6AW

During a random witness of Magnetic Particle (MT) Testing performed by ABFJV MT technicians of the OBG Segment 6AW Welds. The Caltrans Quality Assurance (QA) inspector observed a total four (4) Linear Indications (transverse) located at welds SP514A-002, 009, 053 and SP473B- 061, 052 located on segment 6AW. ZPMC personal completed these weld repairs without prior Engineer approval or utilizing an approved critical weld repair procedure (CWR). For further information, please see the attached pictures below. Please see incident report on this date

Segment 6AW

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 Components. The weld designations reviewed are as follows:

-(SSD24-PP37.5-049, 050, 051, 052, 053, 054, 055, 056, 057, 058, 059, 060)

-(SSD24-PP37.5-037, 038, 039, 040, 041, 042, 043, 044, 045, 046, 047, 048)

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-(Seg027D-016, 017, 012, 002)

-(SSD24-PP37.5-049, 057)- found rounded indications

Segment6AW

This QA inspector was instructed by task leaders to carry out Ultrasonic testing (UT) with ABF QC utilizing scanning pattern 'D' for detecting transverse Indications on the transverse segment splice for OBG Segment6AW at corner assembly to deck plate joint. The indications found on this date were recorded onto a data sheet that Caltrans QA and ABF QA have jointly filled out.

The Weld Designations are as follows

CA025-004

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: Patterson,Rodney

QA Reviewer