

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-010278**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:** An Qin Xiang.**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:

Bay10, East Tower, Lift 4, Skin A, Temporary Attachment Area.

During random visual inspection at South Shaft, Lift 4, Skin A (Temporary Attachment Area near Corner Seam A/E) this Caltrans Quality Assurance (QA) Inspector observed "Crack Like" indications at the removed Temporary attachment Weld area. The indications were shown to ZPMC and ABF QC Inspectors. No Incident Report has been written on this issue. The attached photographs provide additional detail.

Bay10, North Tower, Lift 3 (Inside).

During In-process inspection this QA Inspector observed ZPMC personnel performing an excavation of a UT-Repair. The excavated area measured approximately 35mm in depth with a length of approximately 130mm. The excavation was performed at a location where ZPMC NDT personnel marked a UT rejected indication measuring approximately H=30mm, X=10mm, Length=130mm-as marked by ZPMC NDT personnel. The excavation was performed on the top nearside of 109M Double Diaphragm.

Upon initial observation by this QA Inspector, ZPMC NDT personnel completed the Magnetic Particle Inspection of the excavated area. ZPMC personnel began to grind to the area. This QA inspector could not determine what type of discontinuity was discovered and or removed by ZPMC personnel. This QA Inspector asked ZPMC QC Inspector, Gao Zhi Chun what type of discontinuity was detected and removed and where the

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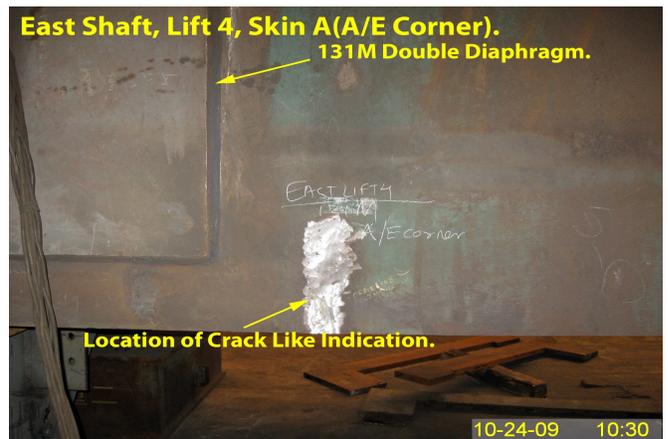
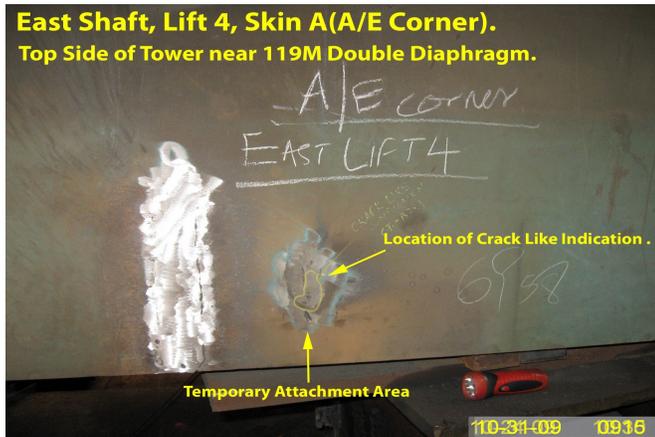
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applicable documentation was that supported the repair (i.e. WRR, CWR). Mr. Chun provided this QA Inspector with a WRR that was not relevant to the repair (no weld number ID, the joint illustrated in the WRR was for a "T"-joint, the joint welded is a corner joint. Additionally, Mr. Chun refused to provide this QA Inspector with a WPS that would support the repair of the excavation. It should also be noted that Mr. Chun could not tell this QA Inspector what the reason for the repair was other than it was some type of UT indication. This QA Inspector also wrote Incident Report on this issue on the same date.

Bay 11, West tower, Interior Splice Plate.

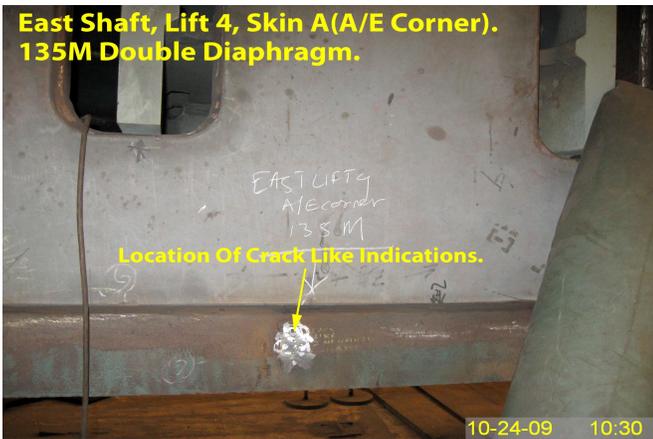
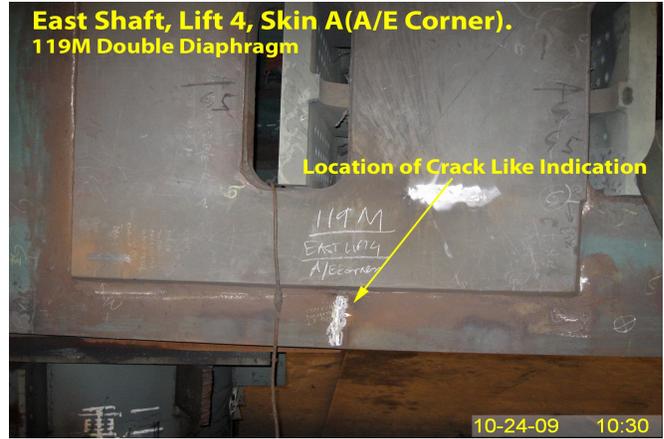
FCAW Repair welding of weld Overlay(Buttering) for Interior Splice Plate WSD1-SA97(WRR # T-WR2583); located on Bay 11, West tower. Welders are identified as 040723, 046706; ZPMC Quality Control Inspector (QC) is identified as An Qin Xiang. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: 1) WPS-345-FCAW-2G(2F)-REPAIR, 2) WPS-345-FCAW-3G(3F)-REPAIR.

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