

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-010370**Date Inspected:** 18-Nov-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:** 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 COMPONENT**Summary of Items Observed:**

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

Bay #14

This QA Inspector observed the following work in progress:

FCAW in the 1G position of the OBG Segment 9CW, weld No. SSD-14A-PP79-221. The welder is identified as #050316. ZPMC QC is identified as Mr. Xu Tao. The welding variables recorded by QC appear to comply with WPS- B -T-2231-Tc-L-U4b-F.

FCAW in the 1G position of the OBG Segment 10AW, weld No. SSD-12-PP88-220. The welder is identified as #201215. ZPMC QC is identified as Mr. Xu Tao. The welding variables recorded by QC appear to comply with WPS- B -T-2231-Tc-L-U4b-F.

Trial Assembly Yard

QA Verification UT performed after repair on portion of Deck Plate to Edge plate weld of 3AW and 3BW(Cross beam side). This Inspection was performed after ABF UT Inspectors performed UT of this joint.

The Weld Designation are as follows

SEG-013-043 and 047

CA-005-002,004 and 006

WELDING INSPECTION REPORT

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For further information See Caltrans Ultrasonic Transverse Indication Evaluation sheet on this date .

QA Verification UT performed after repair on portion of Deck Plate to Edge plate weld of 4AW and 4BW(Cross beam side). This Inspection was performed after ABF UT Inspectors performed UT of this joint.

The Weld Designation are as follows

SEG-019-035 and 037
CA-009-002,004 and 006

For further information See Caltrans Ultrasonic Transverse Indication Evaluation sheet on this date .

QA Verification UT performed after repair on portion of Deck Plate to Deck plate Splice weld of 1AW to 1BW. This Inspection was performed after ABF UT Inspectors performed UT of this joint.

The Weld Designation is as follows

OBW1-006

For further information See Caltrans Ultrasonic Transverse Indication Evaluation sheet on this date .

Ultrasonic Testing (UT)

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as Floor Beam joint at segment 7EE.

The Weld Designation is as follows

SSD-19-PP059-132,138,135,108
SSD-19-PP059A-128,131,134,105

This Quality Assurance Inspector (QA) performed 10% verification Ultrasonic Testing (UT) on weld joints identified as SSD-19A-PP59-128 for OBG segment 7EE, weld between FL2 flange to FL1. This QA Inspector discovered One class "A" rejectable indications measuring approximately 30 mm in length.

This weld was previously not tested by ZPMC QC UT technician (Outside ZPMC 25% UT Scanned area) .

This QA Inspector generated an incident report for this date.

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

Summary of Conversations:

No relevant conversations

Comments

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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:	Bera,Subhasis	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
