DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-010442
Date Inspected: 30-Nov-2009

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 645
OSM Departure Time: 1845
Location: Shanghai, China

CWI Name:	Lv Li Qing/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

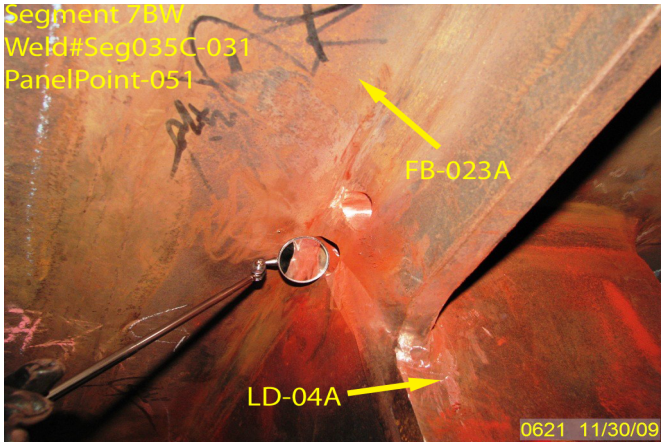
Summary of Items Observed:

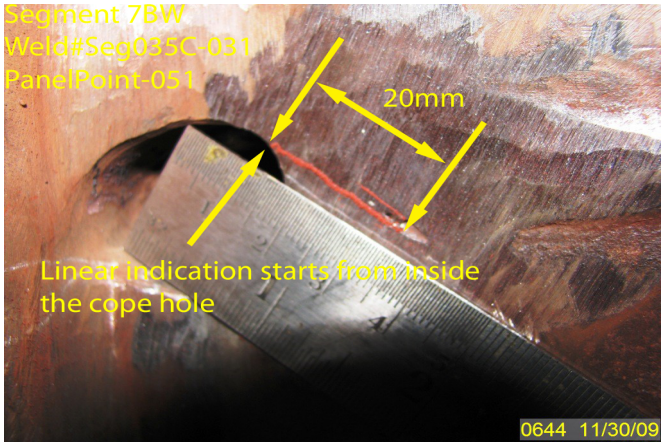
On this date Caltrans OSM Quality Assurance (QA) Inspector, Hiranch Patel, was present during the times noted above for observations relative to the work being performed.
During the Quality Assurance Magnetic Particle Testing (MT) review of welds located on Segment7BW, this Quality Assurance Inspector (QA) discovered the following issues:
-One (1) longitudinal linear indication measuring approximately 20mm in length.
-The weld is identified as: Seg035C-031, Panel Point (PP)-051, LD to FB.
-The Weld is a Complete Joint Penetration (CJP) butt weld joining the Longitudinal Diaphragm (LD) to Floor Beam (FB).
-The OBG Segment is located at outside yard.
The Notice of Witness Inspection Number (NWIT) is 004768. The indication is located outside the area previously not tested and accepted by ZPMC Quality Control (QC) personnel.
For further information, please see the attached pictures below. Please see incident report on this date.

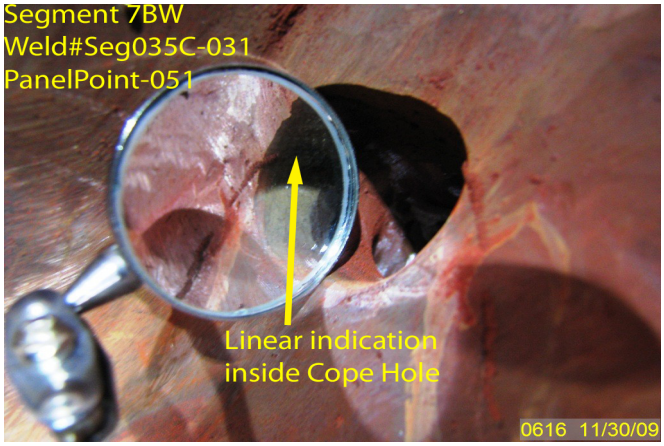
Segment7BW
This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member is identified as OBG Components. The weld designations reviewed are as follows:
-(Seg035C-001~005, 022~027, 032~039, 040, 042, 060~065)
-(Seg035C-040, 042, 060~065)
-(Seg035C-022~027)
-(Seg035C-031) Rejectable indication found

Bay#13
FCAW welding of weld joint SSD29-PP101.5-059~094 located on Segment 11CE. Welder is identified as 050988 (2F). ZPMC QC is identified as Zhong Qiao. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132.
SMAW welding of weld joint SSD18-PP100-232/242 located on Segment 11BE. Welder is identified as 067589 (4G). ZPMC QC is identified as Zhang Qiao. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-Tc-U4b-FCM-1.
FCAW welding of weld joint SSD20A-PP103-234/244 located on Segment 11CE. Welder is identified as 044774 (3G). ZPMC QC is identified as Zhang Qiao. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2333-Tc-U5-F.
FCAW welding of weld joint SSD20-PP103-236/246 located on Segment 11CE. Welder is identified as 058551 (2G). ZPMC QC is identified as Zhang Qiao. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232-Tc-U4b-F.

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







Summary of Conversations:
No relevant conversations.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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