

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-010656**Date Inspected:** 26-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:	An Qin Xiang, Yu Dong Ping.	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:

Bay 10, East Tower, Struts.

SMAW welding of weld joint ESD1-STSA3-2-109M-2-29, 31; located on Bay 10, East Tower. Welders are identified as 051259; ZPMC Quality Control Inspector (QC) is identified as Chen Ying Xin. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-4113-1.

Bay 10, East Tower, Struts.

SMAW Repair welding of weld joint ESD1-A6003-8-9B (CWR # T-CWR486); located on Bay 10, East Tower. Welders are identified as 053049; ZPMC Quality Control Inspector (QC) is identified as Chen Ying Xin. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-485-SMAW-2G(2F)-FCM-REPAIR-1.

Bay 11, West Tower, Struts.

SMAW welding of weld joint WD1-STSA3-2-109M-1-11A; located on Bay 11, West Tower. Welders are identified as 040669; ZPMC Quality Control Inspector (QC) is identified as Yu Dong ping. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-3212-TC-U5B-1.

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Bay 11, East Tower, Lift 4, CD Corner 123M.

During in-process visual inspection this Quality Assurance (QA) Inspector observed ZPMC personnel performing an excavation of a Complete Joint Penetration (CJP) weld at C/D Corner Seam of East Shaft Lift 4. This weld was previously rejected by ZPMC Non Destructive Testing (NDT) personnel. The excavation was performed at the 123m double diaphragms, near temporary attachment area.

This QA Inspector observed ZPMC NDT personnel performing Magnetic Particle Testing (MT) of the excavated area. This QA inspector observed a “Crack like Linear Indication Transverse to the Weld axis” approximate 6mm in length.

This QA Inspector asked ZPMC Quality Control (QC) Inspector An Qin Xiang for applicable documentation supporting this repair. ZPMC QC Inspector provided this QA Inspector with a temporary Weld Repair Report (WRR) which had no document number.

ZPMC personnel performed Shielded Metal Arc Welding (SMAW) of this excavated area without prior approval of the Engineer. Incident Report has been submitted on this issue.

Bay 10, North Tower, Lift 4, Skin D to 139M(BOT) Double Diphragm to (Inside).

FCAW welding of weld joint NSTL4-3J/L-132, 133; located on Bay 10, North tower. Welders are identified as 066328, 067499; ZPMC Quality Control Inspector (QC) is identified as Gong Liang Zhu. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-4332-TC-P5-F-1.

Unless otherwise noted, all work 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 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
