

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-010838**Date Inspected:** 19-Dec-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:** As identified below**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**Summary of Items Observed:**

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

North of Blast 1-

During a random visual inspection at OBG Segment 8CE of Seismic Performance Critical Members (SPCM) Bottom Panels (BP), the Quality Assurance (QA) Inspector observed ZPMC performing unapproved base metal repairs on SPCM BP's at temporary attachment removal areas. Approximately fifty (50) areas have been excavated and ten (10) areas have been welded prior to the QA inspector's arrival. An incident report was issued for the unapproved base metal repairs on segment 8CE. Additional information about the non-conforming base metal repairs are listed below.

- 1) The BP's are identified as: BP177A, BP069A and BP123A
 - 2) The material was identified as: A709 Grade 345 SPCM
 - 3) The locations of these non-conformances were located between PP67 to PP71
 - 4) ZPMC performed base metal repairs without the prior approval of the Engineer.
- For further information, please see the attached pictures below.

OBG Blast Bay 1-

Caltrans Quality Assurance (QA) Inspectors performed random visual inspection of OBG segment 8AE internal

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bottom panel, side panel, longitudinal diaphragm and floor beam surfaces between panel point 61 and panel point 62 after grit blasting. Areas that marked for repair were recorded for future repair. Areas requiring additional grinding were marked by QA and repaired by ZPMC personnel.

Bay 14-

This QA Inspector observed the following work in progress: Submerged Arc Welding (SAW) of OBG Segment 11DE deck panel DP349A to DP511A Complete Joint penetration (CJP) weld, SEG072*-001. ZPMC welder was identified as 044771. ZPMC QC is identified as Geng Wei. ZPMC CWI was identified as Lv Li Qing. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2221-B-L2c-S-2.

Submerged Arc Welding (SAW) of OBG Segment 11EW deck panel DP134A to DP296A Complete Joint penetration (CJP) weld, SEG073*-008. ZPMC welder was identified as 045265. ZPMC QC is identified as Geng Wei. ZPMC CWI was identified as Lv Li Qing. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2221-B-L2c-S-2.

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



Summary of Conversations:

As identified within the contents of this report.

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.

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| Inspected By: | Viars,Larry | Quality Assurance Inspector |
| Reviewed By: | Dawson,Paul | QA Reviewer |
