

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-010891**Date Inspected:** 30-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:** Liu Hua Jie**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 day Caltrans OSM Quality Assurance (QA) Inspector Christopher D'souza was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China. QA Inspector observed and/or found the following:

Trial Assembly

ABF Inspection Request No. 12302009-1

This QA Inspector witnessed ABF Inspectors performing VT and UT of OBE5A-003, 004 and 005 (5AE – 5BE transverse splice SP bike path side and BP)

This QA Inspector performed Ultrasonic Testing (UT) on approximately 10% of OBE5A-003, 004 and 005 (5AE-5BE Splice welds) previously accepted by ZPMC ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3 and Detection of Transverse Planar Discontinuities with Significant Flaw Height Dimension Procedure. The QA Inspector observed one rejectable indication at the time of testing. The QA Inspector generated a TL-6027 UT report on this date. Weld identification numbers were

OBE 5A – 003

OBE 5A - 004, 005

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This QA Inspector performed conventional UT (Ultrasonic Testing) in conjunction with ABF UT department for detection of planar transverse indication.

See Caltrans Ultrasonic Transverse Indication Evaluation sheet dated December 30th, 2009 for further information on inspection.

6AE – 6BE

This QA Inspector performed Ultrasonic Testing (UT) on approximately 10% of OBE6-001 (6AE-6BE Splice welds) previously accepted by ZPMC ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3 and Detection of Transverse Planar Discontinuities with Significant Flaw Height Dimension Procedure. The QA Inspector observed one rejectable indication at the time of testing. The QA Inspector generated a TL-6027 UT report on this date. Weld identification numbers were

OBE6 – 001

See Caltrans Ultrasonic Transverse Indication Evaluation sheet dated December 30th, 2009 for further information on inspection.

5BW – 5CW

This QA Inspector performed Ultrasonic Testing (UT) on approximately 10% of OBE5-007 and OBE5-009 (5AE-5BE Splice welds) previously accepted by ZPMC ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3 and Detection of Transverse Planar Discontinuities with Significant Flaw Height Dimension Procedure. The QA Inspector observed no rejectable indication at the time of testing. The QA Inspector generated a TL-6027 UT report on this date. Weld identification numbers were

OBE5 – 007

OBE5 – 009

BAY 9

This QA Inspector observed ZPMC personal excavating areas rejected by Phased Array Ultrasonic Testing (PAUT) on DP 3024-001, DP3051-001 and DP3059-001 for Y – locations of excavation see Caltrans U-rib to Deck Panel- Tack Weld Assessment sheets for the above panels.

Bay 14

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as SEG073A-007. The welder is identified as 051348 and was observed welding in the 4G position using approved Welding Procedure Specification WPS-B-P-2214-B-U2-FCM-1.

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as SEG073A-004. The welder is identified as 058242 and was

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observed welding in the 4G position using approved Welding Procedure Specification WPS-B-P-2214-B-U2-FCM-1.

ZPMC Quality Control (QC) Inspector is identified as Xu Tao. QA Inspector observed QC Inspector verify welding parameters. The welding variables recorded by QC appeared to comply with the Applicable WPS.

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 Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Dsouza,Christopher	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
