

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-010944**Date Inspected:** 29-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yan Hua**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 Assembly**Summary of Items Observed:**

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

Segment Repair Yard (North of the Bay 14)

Segment 6CW

This QA Inspector performed Magnetic Particle testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (MT) report for this date. The members are identified as the external stiffeners at the crossbeam. The Weld Designations are as follows:

SEG031H-051, 114 and 114.

SEG031J-050, 102, 103, 123 and 131.

SSD11A-PP45-164, 165, 170, 171 and 178.

SSD12A-PP46-170, 171, 175, 176 and 183.

During random verification Magnetic Particle Testing of the internal components of OBG segment 6AW, Caltrans Quality Assurance (QA) Inspector discovered a total of two (4) longitudinal cracks that measured from 25mm to 30mm in length. In addition to the (MT) indications these welds were visually rejectable due to notches in the weld toe and at the weld terminations. These welds were previously tested accepted by ZPMC and ABF (MT) technicians.

The affected weld designations are as follows;

Horizontal FL3 stiffeners (X8) to edge plate attachment fillet welds (FCW)

Weld No. SSD11A-PP45-164 = (1) 30mm Longitudinal Crack.

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Weld No. SSD12A-PP46-170 = (1) 25mm Longitudinal Crack.

Weld No. SSD12A-PP46-175 = (1) 30mm Longitudinal Crack.

Longitudinal Open Rib Stiffener to FL3 Floor beam at PP44 CJP (FCW)

SEG031J-131 (1) 30 mm Longitudinal Crack.

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.

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| Inspected By: | Patterson,Rodney | Quality Assurance Inspector |
| Reviewed By: | Carreon,Albert | QA Reviewer |
