

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-010947**Date Inspected:** 02-Jan-2010**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:	Sun Bo			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:	Deck Panel		

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:

North lay down

Notification of Witness of Inspection (NWIT) – 4980

This QA Inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested by ZPMC MT personnel. This QA Inspector generated a TL-6028 MT report on this date. The weld designation numbers is as follows:

DP 3056-001

During the Quality Assurance Magnetic particle Testing (MT) review of welds located on Deck Panel (DP 3056-001), this Quality Assurance Inspector (QA) discovered the following issues:

- One (1) transverse indication measuring approximately 8mm in length at Y location 450mm.
- The weld is identified as: DP 3056-001-010
- The Weld is a Partial Joint Penetration (PJP) Tee weld joining the Rib stiffener (RS3032C) to the deck plate

WELDING INSPECTION REPORT

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(PL3119A).

-The member is located in Outside Yard

The Notice of Witness Inspection Number (NWIT) is 4980. The indication is located inside the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. As per the contract documents, ZPMC's QC personnel are required to perform twenty-five (25) percent MT inspection of this weld.

QA Inspector generated an Incident report for this issue.

Bay 9

This QA Inspector observed ZPMC welding personnel's performing Flux cored arc welding (FCAW) on visually rejectable areas on DP 3046-001. Welder is identified as 059378. ZPMC QC is identified as Duan Ya Bing. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2342

This QA Inspector observed ZPMC welding personnel performing Flux Core Arc Welding (FCAW) on PAUT repair areas of closed rib Partial Joint Penetration (PJP) welds on deck panels designated as DP3059-001. Welder is identified as 059378. ZPMC QC is identified as Duan Ya Bing. In process FCAW appears to be progressing in compliance with WPS 345-FCAW-2G (2F) Repair-1.

Trial Assembly

ABF Inspection Request No. 01022010-1

This QA Inspector witnessed ABF Inspectors performing VT and MT of OBE5- 004 (5AE – 1BE transverse splice DP)

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
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Reviewed By:	Carreon,Albert	QA Reviewer
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