

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-011100**Date Inspected:** 16-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:	Xu Le Feng, 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, North Tower, Strut.

SMAW welding of weld joint ND1-A6002-8-21, 22, 23, 24; located on Bay 10, North Tower. Welders are identified as 056364, 057266; 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-2113.

Bay 11, South Tower, Strut.

SMAW Repair welding of weld joint SD1-STSA3-1-9A (CWR # T-CWR500); located on Bay 11, South Tower. Welders are identified as 040733; 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-485-SMAW-2G(2F)-FCM-REPAIR-1.

This QA Inspector carried out NDE on following

Bay 11, Tower Spare Strut.

This QA inspector performs Random Visual Testing (VT), Magnetic Particle Testing (MT) of approximately

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15% area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report(TL-6028) for this date. The members are identified as

- 1) ND1-A6002-3.
- 2) ND1-A6002-6.

During random Magnetic Particle Testing (MT) of Tower Spare Strut ND1-A6002-3, ND1-A6002-6; the Quality Assurance Inspector (QA) observed "Transverse linear indications" approximately 2 to 4 mm in Length. Fillet weld joints ND1-A6002-3-39 & ND1-A6002-6-28. ZPMC provided the NDT Notification Sheet # 004865 informing Caltrans QA that they have completed their NDT requirements. This indication was discovered inside of ZPMC personnel's testing area. ZPMC Repaired the indication found on Strut # ND1-A6002-6.

Then this QA inspector performs Random Visual Testing (VT), Magnetic Particle Testing (MT) of approximately 15% area previously tested and accepted by ZPMC Quality Control personnel for Strut # ND1-A6002-6.

Bay 11, Tower Spare Strut.

This QA inspector performs Random Ultrasonic Testing (UT) of approximately 10% area previously tested and accepted by ZPMC Quality Control personnel, FOR GREEN TAG. This QA Inspector generated an UT report(TL-6027) for this date. The members are identified as ND1-A6002-6.

GREEN TAG # 9316.

Bay 10, North Tower, Lift 4, Triangle Plate with Diagonal Stiffener.

This QA inspector performs Random Visual Testing (VT), Magnetic Particle Testing (MT) of approximately 15% area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report(TL-6028) for this date. The members are identified as

- 1) NSTL4-3B/L-50, 22.
- 2) NSTL4-3C/L-64, 125, 21, 77.
- 3) NSTL4-3F/L-63, 125, 4, 74.
- 4) NSTL4-3G/L-58, 122, 2, 73.
- 5) NSTL4-3H/L-58, 119, 2, 73.
- 6) NSTL4-3I/L-59, 122, 4, 73.
- 7) NSTL4-3J/L-58, 120, 2, 73.
- 8) NSTL4-3K/L-61, 120, 2, 73.

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

Summary of Conversations:

ZPMC NDT Notification # 004872.

Cable Tray of East Shaft Lift 2.(For GREEN TAG).

This Caltrans OSM Quality Assurance (QA) Inspector asked for weld joint details for Visual Testing (VT) of "Cable Tray" of East Shaft Lift 2. ZPMC Quality Control Inspector (QC) provided "WELD MAP" (Drawing # B22 Layout for Lift 2, B 22-2). Weld Detail in this Drawing(WELD MAP)did NOT mention anything about weld being Intermitant. There was no other referance available on the location with ZPMC QC which describes weld being Intermitant.

The weld that has to be inspected was "Intermitant", so this QA told ZPMC QC "An Qin Xiang" that; this needs

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clarification from SMR(Serge Sinevod). This QA Inspector then left the site informing ZPMC QC that he will continue inspection after SMR's clarification(time-1630Hrs.).

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
