

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-011181**Date Inspected:** 03-Jan-2010**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:** Mr. Chen Ying Xin**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**Summary of Items Observed:**

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

Magnetic Particle Testing:-**BAY #11:-**

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 an MT report for this date.The member is identified as Tower Strut Plate.The weld designations reviewed are as follows:-

SD1-STSA3-1-109M-1-9B,10A,11A,12B,16,23,25A,26B,28,32,33,39.

IN PROCESS INSPECTION:-**BAY #10:-**

This QA inspector observed the following work in progress:

SMAW welding of weld joint no:ND1-STSA3-1-89M-1-43 located on Strut Plate.Welder is identified as 053049.

ZPMC CWI is identified as Mr.Chen Ying Xin.The welding variables recorded by QC appeared to comply with the WPS-B-T-2113.

This QA inspector observed the following work in progress:

FCAW welding of weld joint no:SSTL4-1B/L-20 located on Diagonal Plate to "CD" Corner Skin Plate.Welder is identified as 037907.ZPMC CWI is identified as Mr.Gang Liang Zhu.The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P4-F.

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BAY #11:-

This QA inspector observed the following work in progress:

FCAW welding of weld joint no:ESTL4-2B/L-16 located on Diagonal Plate to “BC” Corner Skin Plate.Welder is identified as 049220.ZPMC CWI is identified as Mr.Yu Liang.The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P4-F.

This QA inspector observed the following work in progress:

FCAW welding of weld joint no:ESTL4-2B/L-22 located on Diagonal Plate to “BC” Corner Skin Plate.Welder is identified as 048810.ZPMC CWI is identified as Mr.Yu Liang.The welding variables recorded by QC appeared to comply with the WPS-B-T-2331-TC-P4-F.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: WSTL4-2B/L-57A/B located on “CD” Corner Seam. Welder is identified as 053916.ZPMC CWI is identified as Mr.Peng Guo.Welding was been performed against Weld Repair Report T-WR2950 and UT report number:T787-UT-2571.The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G(2F)-Repair.

During the Quality Assurance (QA) random in-process visual inspection of Bay 11,this QA inspector discovered the following issue:

Base metal repairs(BMR)were being performed that were caused by the removal of temporary attachments on Interior Splice Plate, without the prior approval of the Engineer. The approximate length of the BMR is:1300mm. The Interior Splice Plate is identified as:WSD1-SPSA3-3.The associated welds in between the BMR areas are identified as:WSD1-SPSA3-3-1A/B,2A/B,3A/B,4A/B.This Green Tag inspection was identified as:Green Tag No:10444.The material is A709M Grade 345 non SPCM.Interior Splice Plate is located in Shop Bay 11.Incident report for the same has been raised.

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



Summary of Conversations:

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The incident report is issued for the above mentioned discrepancy observed in Tower, Bay#11,Interior Splice plate and prior to issue it was informed to ZPMC QC and ABF QA.

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:	Pillai,Pandaram	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
