

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-011376**Date Inspected:** 03-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:** Mr. Liufa Wen**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:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

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

Magnetic Particle Testing (MT) - Document No's: 004983

This QA inspector performed 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 members are identified as OBG Components. The weld designations reviewed are as follows:

1. FB3073-004-001~006
2. FB3069-001-001~008
3. LD017-026-005~008
4. LD018-026-001~004
5. LD3013-001-001~012
6. LD3013A-001-001~012
7. LD3014-001-001~012
8. LD3014A-001-001~012
9. LD016-040-001~004
10. LD015-040-005~008
11. LD3018-001-001~004
12. LD3017-001-001~004

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- 13. LD3016-001-001~004
- 14. LD3015-001-001~004
- 15. FB3069-003-001~008

OBG Segment 10AW

This QA inspector observed ZPMC personnel appears to have performed base metal weld repairs on material designated as SPCM on the approved shop drawings without the Engineers approval. The areas being repaired were damaged while removing temporary lifting lug welds at the corners of this Segment. The component is identified as OBG Segment 10AW. The Non SPCM panels affected are identified as side deck panel DP262A & DP235A and weld number joining deck panel is SEG059*00. AWS D1.5 2002 section 3.3.7.3 specifies “Tack welds not incorporated into the final weld shall be removed in such a manner that the base metal is not nicked or undercut. Repair of base metal accidentally removed shall be approved by the Engineer prior to making the repair. This QA informed ZPMC QA identified as Mr. Xu Tao and ABF QA inspector identified as Mr. Jim of this issue and that an incident report would be generated. See attached photo.

Bay 5

This QA inspector observed ZPMC qualified welding personnel identified as 069895 perform Flux Cored Arc Welding (FCAW) welding on Bike Path, weld joint identified as BK001-048-002. ZPMC QC is identified as Mr. Wang Liang. The welding parameters as measured using QC’s calibrated instruments appeared to be in general compliance with WPS-B-T-2231-Tc-U4c-F.

This QA inspector observed ZPMC qualified welding personnel identified as 204342 perform FCAW welding on Bike Path, weld joint identified as BK001-049-004. ZPMC QC is identified as Mr. Wang Liang. The welding parameters as measured using QC’s calibrated instruments appeared to be in general compliance with WPS-B-T-2231-Tc-U4c-F.

This QA inspector observed ZPMC qualified welding personnel identified as 067275 perform FCAW welding on Bike Path, weld joint identified as BK001-050-004. ZPMC QC is identified as Mr. Wang Liang. The welding parameters as measured using QC’s calibrated instruments appeared to be in general compliance with WPS-B-T-2231-Tc-U4c-F.

Bay 7

This QA inspector observed ZPMC qualified welding personnel identified as 066695 perform FCAW Welding on Traveler Rail, weld joint identified as 22TR1-001-001. ZPMC QC is identified as Mr. Zhou Jie. The welding parameters as measured using QC’s calibrated instruments appeared to be in general compliance with WPS-B-T-2232-Tc-U5-F.

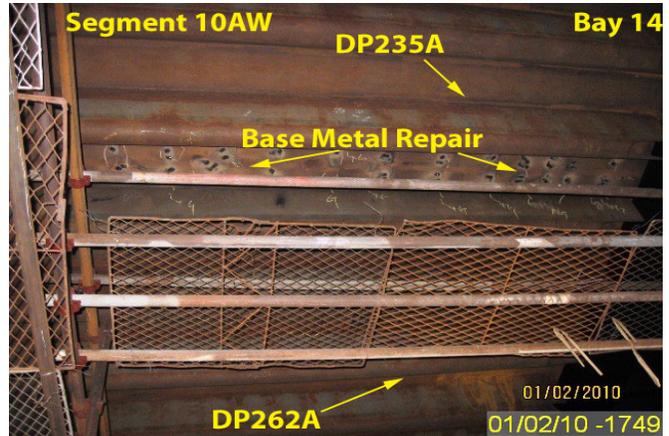
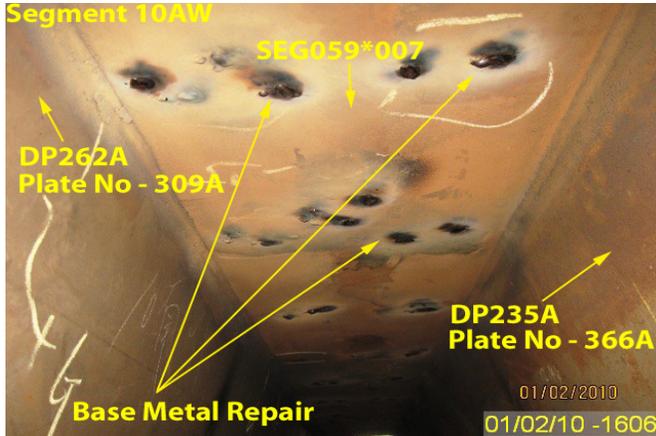
This QA inspector observed ZPMC qualified welding personnel identified as 068859 perform FCAW Welding on Traveler Rail, weld joint identified as 22TR1-001-005. ZPMC QC is identified as Mr. Zhou Jie. The welding parameters as measured using QC’s calibrated instruments appeared to be in general compliance with WPS-B-T-2232-Tc-U5-F.

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This QA inspector observed ZPMC qualified welding personnel identified as 067942 perform FCAW Welding on Traveler Rail, weld joint identified as 22TR1-001-009. ZPMC QC is identified as Mr. Zhou Jie. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-Tc-U5-F.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

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: Kumar,Vibin

Quality Assurance Inspector

Reviewed By: Hall,Steven

QA Reviewer