

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-012023**Date Inspected:** 16-Feb-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:** Li Yang**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 COMPONENT**Summary of Items Observed:**

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

In process Inspection

Trial Assembly Area

This QA Inspector observed the following work in progress:

SMAW in the 1G position for the OBG Segment 6BW to 6CW, weld No. OBW6C-003. The welder is identified as #066179. ZPMC QC is identified as Mr. Hai Yang Bing. The welding variables recorded by QC appear to comply with WPS-345-SMAW-1G (1F)-FCM-REPAIR-1. The weld repair report is identified as B-CWR-1209.

SMAW in the 1G position for the OBG Segment 6BW to 6CW, weld No. OBW6C-002. The welder is identified as #037743. ZPMC QC is identified as Mr. Hai Yang Bing. The welding variables recorded by QC appear to comply with WPS-345-SMAW-3G (3F)-FCM-REPAIR-1. The weld repair report is identified as B-CWR-1209.

After Blast Inspection

This Quality Assurance (QA) Inspector performed random visual inspection of OBG segment 8CE internal side panel, bottom panel, floor beam and longitudinal diaphragms surfaces from the panel point 68 to 69 after grit blasting. Areas that marked for repair were recorded for future repair. Areas requiring additional grinding were marked by QA and repaired by ZPMC personnel.

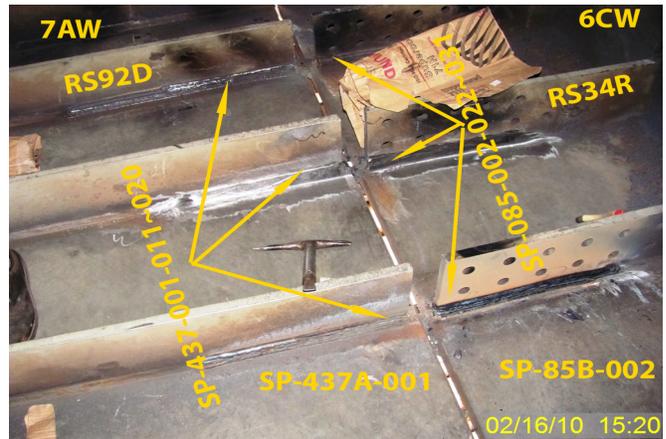
WELDING INSPECTION REPORT

(Continued Page 2 of 2)

During Quality Assurance random in-process observations of the assembly of Orthotropic Box Girder (OBG) segments 6CW and 7AW, this Quality Assurance Inspector (QA) discovered that the ZPMC has deviated from the approved weld joint design without the Engineers approval. ZPMC has changed the hold back fillet welds to Complete Joint Penetration (CJP) welds. The affected joints on segment 6CW are identified as SP085-002-022~031. The affected joints on segment 7AW are identified as SP437-001-011~020. According to the approved drawings (SP085 and SP437) the joints are designated as fillet weld joints. The welds are located in between Panel Point 47 (PP47) and PP48 on the crossbeam side. The welds are joining I-ribs RS34R to side panel SP085B-002 on segment 6CW and I-ribs RS92D to side panel SP437A-001 on segment 7AW.

This QA Inspector generated an incident report for this date.

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 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By: Bera,Subhasis

Quality Assurance Inspector

Reviewed By: Patterson,Rodney

QA Reviewer