

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-012223**Date Inspected:** 15-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:** Chen Xi.**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 (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:

Subassembly, Bay 01, Traveler rail.

FCAW welding of weld joint 20TR1-018-007; located on Subassembly, Bay 01. Welder is identified as 219188; ZPMC Quality Control Inspector (QC) is identified as Chen Xi. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2231-TC-U5-F.

During the Quality Assurance (QA) random in-process visual inspection of OBG traveler rail weld, this Caltrans Quality Assurance Inspector (QA) observed the following:

-ZPMC welded over Cracked Tack weld.

-The weld is a Complete Joint Penetration (CJP) T-joint joining the web to flange.

-The weld is identified as 20TR1-018-007.

-Cracks were detected visually for the above mentioned weld found cracked at the ends.

This QA inspector also submitted Incident Report on the same date. The attached photographs provide additional detail.

Subassembly, Bay 2 to 9.

This QA observed that no significant work was being performed on this crossbeam during the time QA was

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

present.

Tower, Bay 11, West Tower, Lift 4, Skin D.

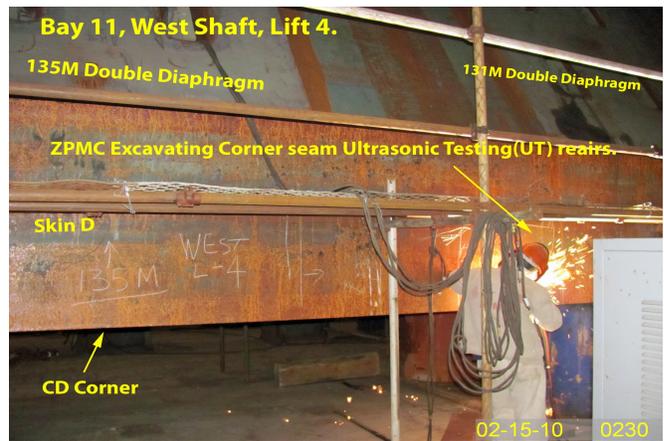
During random inprocess inspection this QA observed ZPMC Personnel excavating Ultrasonic Testing (UT) Repair on CD Corner Seam between 131M & 135M Double Diaphragm. The attached photographs provide additional detail.

This QA Inspector carried out NDE on following

Segment# 8CE-PP68, 69.

This QA inspector performed Random Visual Testing (VT) after Blast on Segment 8CE Panel Point 68, 69.

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 Serge Sinevod, 13482570045, who represents the Office of Structural Materials for

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

your project.

Inspected By: Juvekar,Amit

Quality Assurance Inspector

Reviewed By: Miller,Mark

QA Reviewer