

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-012394**Date Inspected:** 09-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/Liu Fa 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:** OBG Components**Summary of Items Observed:**

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

During the Quality Assurance after blast Visual Inspection (VT) review of part located on Segment 7DW, this Quality Assurance Inspector (QA) discovered the following issues:

- One (1) damaged segment part located @ Panel Point (PP) 056.
- The damaged part is Bottom of Floor Beam (FB) 019B Web Plate.
- According to approved drawing X73A, this plate is Seismic Performance Critical Member (SPCM).
- Due to improper handling of segment, resulted in damage of FB 19B- Web Plate.
- The OBG 7DW segment is located at in the blast shop.

For further information, please see the attached pictures below. Please see incident report on this date.

Segment 7DW

This QA Inspector performed a preliminary random visual inspection after the grit blast of the internal components of the deck panel and corner assemblies of this segment. Areas of visual weld defects that will require welding were taped and will be repaired after the coating is applied. ZPMC QC personnel are aware of these areas and were present during the inspection.

Segment 9BW

This QA inspector performed MT of approximately 100% 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

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

OBG Components. The weld designations reviewed are as follows:

-(FB027B-092)

-(FB003A-005)

-(FB003A-035)- Rejectable indication found.

Bay#1

FCAW welding of weld joint 21TR3-001-001 located on Traveler Rail 21TR3. Welder is identified as 219188 (1G). ZPMC QC is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-Tc-U5-F.

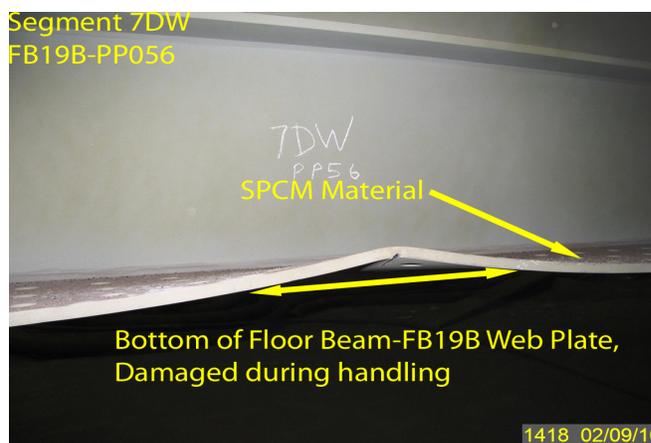
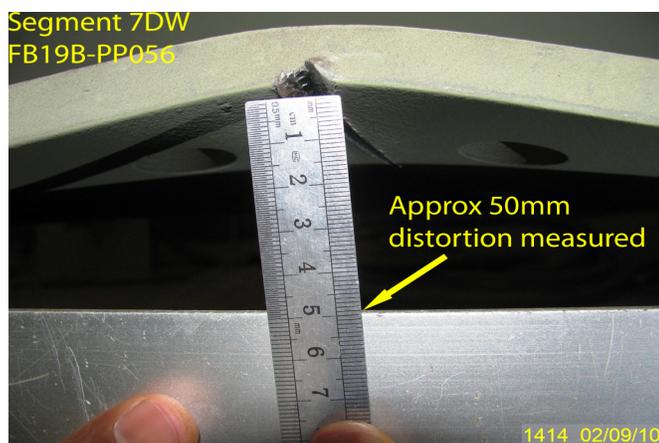
FCAW welding of weld joint 21TR3-001-003 located on Traveler Rail 21TR3. Welder is identified as 219188 (1G). ZPMC QC is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-Tc-U5-F.

FCAW welding of weld joint 21TR3-001-003 located on Traveler Rail 21TR3. Welder is identified as 219188 (1G). ZPMC QC is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-Tc-U5-F.

Bay#7

Weld repair performed by FCAW welding in reference of weld repair report B-WR10289, weld joint 11TR3-001-003 located on Traveler Rail 11TR3. Welder is identified as 220061 (2G). ZPMC QC is identified as Zhong Dian Xing. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-Tc-U5-F.

Unless otherwise noted, all 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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

your project.

Inspected By:	Patel,Hiranch	Quality Assurance Inspector
----------------------	---------------	-----------------------------

Reviewed By:	McClendon,Timothy	QA Reviewer
---------------------	-------------------	-------------