

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-013201**Date Inspected:** 07-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 7000**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:	N/A	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, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

OUTSIDE SHOP

Segment 9CE

The following weld did not appear to comply with the applicable contract documents:

SEG 9CE:

1)PP75-FB003-147 – 006.

-During in process visual inspection of the above mentioned weld, this QA observed Two (2) transverse indications.

-This was confirmed with MT wherein, One (1) transverse crack measuring approximately 10 mm length. Second (1) transverse crack measuring approximately 8mm length respectively were observed.

-The above mentioned welds were previously Magnetic Particle Testing (MT) tested and accepted by ZPMC Quality Control (QC) personnel.

-The member(s) are identified as OBG components – Floor Beam & Floor Beam Flange on PP79 west side.

-This QA Inspector has generated MT report for this date.

-For further information, please see the attached photos.

SEG 9CE

-This QA inspector performed in process Visual Inspection of the below mentioned fillet welds between Floor

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Beam Flange and Floor Beam Web.

-PP79 West side

-FB010-026-001

-FB016-035-003.

Blast Shop 1

Caltrans Quality Assurance (QA) Inspectors performed random visual inspection of OBG segment 7DW external side panel, bottom panel, Deck panel floor beam surfaces from the panel point 56 to 58 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.

Bay 19

Grinding of Suspender bracket welds of SB40W,SB38E,SB44W,SB36E,SB36W are going on for further MT and UT by ZPMC . ZPMC QC Mr. Cheng zheng present during their work.

During the Quality Assurance Magnetic particle Testing (MT) review of welds located on OBG Segment 9CE, this Quality Assurance Inspector (QA) discovered the following issue:

-Two (2) linear transverse indication that measured approximately 10mm and 08mm in length.

For more information please see the Incident report

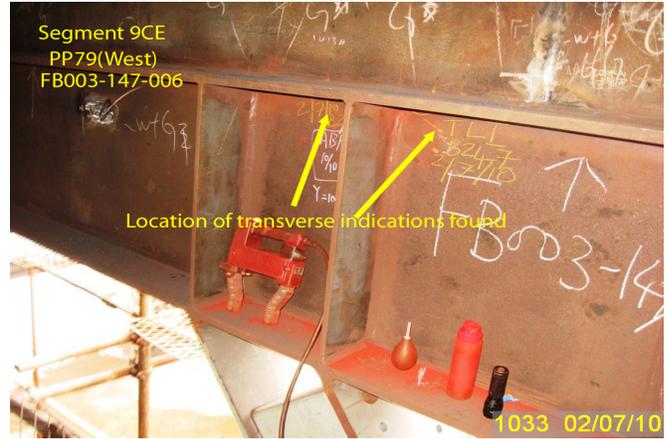
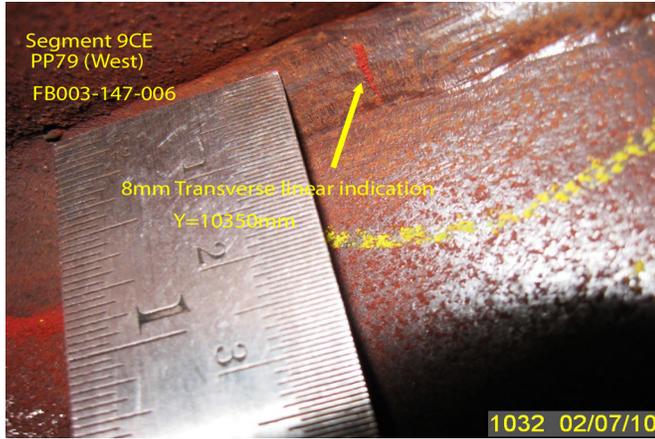
04-0120F4_TL-15_B247_02-07-10_Seg9CE__MT_Linear_Indication[1].

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



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Summary of Conversations:

No relevant Conversation.

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-15--0042-2372, who represents the Office of Structural Materials for your project.

Inspected By: Kumar, Chadra

Quality Assurance Inspector

Reviewed By: McClendon, Timothy

QA Reviewer