

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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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-013652**Date Inspected:** 17-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**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:** Gang Wai**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

Bay #14

This QA Inspector observed the following work in progress:

FCAW in the 2G position for the OBG Segment 12CE, weld No.DP3027-001-009. The welder is identified as #206623. ZPMC QC is identified as Mr. Wang Xu. The welding variables recorded by QC appear to comply with WPS-B-T-2232-B-U4b-F.

FCAW in the 2G position for the OBG Segment 12CE, weld No.DP3029-001-024. The welder is identified as #044790. ZPMC QC is identified as Mr. Wang Xu. The welding variables recorded by QC appear to comply with WPS-B-T-2232-B-U4b-F.

FCAW in the 3G position for the OBG Segment 12AE, weld No.DP3005-001-114. The welder is identified as #048038. ZPMC QC is identified as Mr. Wang Xu. The welding variables recorded by QC appear to comply with WPS-B-T-2233-B-U4b-F.

FCAW in the 2F position for the OBG Segment 12AE, weld No.DP3007-001-060/061. The welder is identified as #206623. ZPMC QC is identified as Mr. Wang Xu. The welding variables recorded by QC appear to comply with WPS-B-T-2132.

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During Quality Assurance random in-process observations of the fabrication of segment 12AW, this Quality Assurance Inspector (QA) observed that the ZPMC personnel welded the cope hole in Longitudinal Diaphragm to Floor Beam flange area both side of the panel points PP109, PP110 and PP111. According to approved drawing X7 the cope hole R=30mm.

For details please see the attached photo.

During Quality Assurance random in-process observations of the fabrication of segment 12CE, this Quality Assurance Inspector (QA) discovered the following issue that ZPMC welded oversize fillet welds in a single pass at a U-rib to Deck Plate Diaphragm connections. The QA inspector measured the fillet weld size of the U-rib to Deck Plate Diaphragm and found these welds to be approximately 15mm to 18mm. The Deck Plates affected are identified as DP3027-001, DP3028-001 and DP3029-001. The Deck Plate Diaphragm piece marks are identified as: X3032B. The U-Rib piece marks are identified as: RS3013C. The Deck Plate Diaphragm panel points (PP) are PP115 to PP117. The steel plate materials are designated as non Seismic Performance Critical Member (non SPCM). According to the approve WPS the fillet size should be no more than 9mm in single pass utilizing the 3F position.

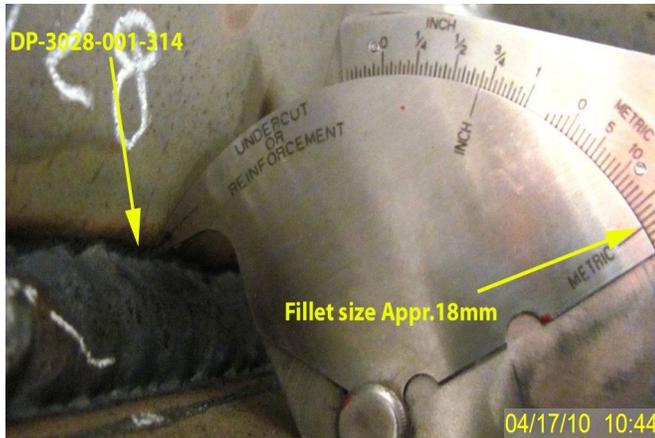
This QA Inspector generated an incident report for this date.

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



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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