

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-013875**Date Inspected:** 06-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhoe Chang**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 and TOWER 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 #19

This QA Inspector observed the following work in progress:

FCAW in the 2G position for the OBG Suspender Bracket SB60W , weld No. SB013-060-007. The welder is identified as #062749. ZPMC QC is identified as Mr. Zhoe Chang. The welding variables recorded by QC appear to comply with WPS-B-T-2232-Tc-U4B-F.

FCAW in the 2G position for the OBG Suspender Bracket SB56E , weld No. SB014-056-055. The welder is identified as #062738. ZPMC QC is identified as Mr. Zhoe Chang. The welding variables recorded by QC appear to comply with WPS-B-T-2232-Tc-U4B-F.

FCAW in the 2G position for the OBG Suspender Bracket SB60E , weld No. SB015-060-049. The welder is identified as #062761. ZPMC QC is identified as Mr. Zhoe Chang. The welding variables recorded by QC appear to comply with WPS-B-T-2232-Tc-U4B-F.

OUT SIDE

This QA Inspector observed the following work in progress:

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SMAW in the 1G position for the OBG Segment 11CE , weld No. SSD20-PP101-137. The welder is identified as #201087. ZPMC QC is identified as Mr. Li Ping. The welding variables recorded by QC appear to comply with WPS-B-P-2211-Tc-U4B-FCM-1.

Magnetic Particle Testing (MPT)

This Quality Assurance (QA) Inspector performed Visual inspection and verification of Magnetic Particle Testing (MT) 15% for Tower Facade Pad Eye weld. This QA inspector generated a (MT) report for this date .This weld was previously tested and accepted by ZPMC QC MT technicians.

The weld designations reviewed are as follows:

SL3-38-10, 13
SL3-38-24, 27

Ultrasonic Testing (UT)

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as OBG U-rib Connecting Plate.

The weld designations reviewed are as follows:

USPL1-498-001,002
USPL1-607-001,002
USPL1-591-001,002
USPL1-614-001,002
USPL1-621-001,002

During the Quality Assurance Ultrasonic Testing (UT) review of welds located on Orthotropic Box Girder (OBG) U-rib connecting plate , this Quality Assurance Inspector (QA) discovered the following issues that one (1) longitudinal linear indication measuring approximately 25mm in length. The indication dbfs rating is +7. Material thickness is 18mm. The depth of the indications is approximately 10.2 mm. The weld is identified as USPLI-607-002. The weld is designated as Non Seismic Performance Critical Members (non SPCM). The indication is clearly marked on or near the weld. The weld USPLI-607-002 is a Complete Joint Penetration (CJP) Corner joint .U-rib connecting plate is located at Bay # 19. The Notice of Witness Inspection (NWIT) No. is 005671. The indication is located inside the area previously tested by ZPMC Quality Control (QC) personnel .

The QA inspector did not generate any 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
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Reviewed By:	Patterson,Rodney	QA Reviewer
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