

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-014982**Date Inspected:** 23-May-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:** Xu Tao**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 #13

This QA Inspector observed the following work in progress:

SAW in the 1G position for the OBG Segment 13AE bottom plate, weld No. BP3032-001-002. The welder is identified as #044771. ZPMC QC is identified as Mr. Guo Xing Hui. The welding variables recorded by QC appear to comply with WPS-B-T-2221-B-U3-F.

Bay #14

This QA Inspector observed the following work in progress:

FCAW in the 1G position for the OBG Segment 12AE, weld No. SEG-3001J-240. The welder is identified as #055564. ZPMC QC is identified as Mr. Zhong Guo Hai. The welding variables recorded by QC appear to comply with WPS-B-T-2231-Tc-U4b-F.

FCAW in the 3G position for the OBG Segment 12CE, weld No. SEG-3003N-003. The welder is identified as #044790. ZPMC QC is identified as Mr. Zhong Guo Hai. The welding variables recorded by QC appear to comply with WPS-B-T-2233-B-U2-F.

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FCAW in the 1G position for the OBG Segment 12BE , weld No. SEG-3002F-250. The welder is identified as #044774. ZPMC QC is identified as Mr. Zhong Guo Hai . The welding variables recorded by QC appear to comply with WPS-B-T-2231-Tc-U4c-F.

FCAW in the 3G position for the OBG Segment 12CE , weld No. SEG-3003B-002. The welder is identified as #044830. ZPMC QC is identified as Mr. Zhong Guo Hai . The welding variables recorded by QC appear to comply with WPS-B-T-2233-B-U2-F.

Bay #16

This QA Inspector observed the following work in progress:

SAW in the 1G position for the OBG Segment 13AW bottom plate , weld No. BP3072-001-002. The welder is identified as #045265. ZPMC QC is identified as Mr. Tao Wei . The welding variables recorded by QC appear to comply with WPS-B-T-2221-B-U2c-S-2.

During Quality Assurance random in-process observations of the assembly of Orthotropic Box Girder (OBG) segments 12AW, this Quality Assurance Inspector (QA) discovered the following issues that ZPMC has deviated from the approved weld joint design without the Engineers approval. ZPMC has changed the fillet welds to Complete Joint Penetration (CJP) welds. The affected joints on segment 12AW are identified as SEG3004G-008/009 and SEG3004F-010/011. According to the approved drawings (SEG3004G & SEG3004F) the joints are designated as fillet weld joints. The length of mention affected area for joint SEG3004G-008/009 is approximately 4100mm. And the length of mention affected area for joint SEG3004F-010/011 is approximately 5700mm. The welds are located in Panel Point PP111.5. The weld SEG3004G-008/009 is joining Floor Beam Flange (FB3078A) X3177D to Deck Plate Diaphragm X3199B. The weld SEG3004F-010/011 is joining Floor Beam Flange (FB3079A) X3178C to Deck Plate Diaphragm X3199B. OBG Segments 12AW are located in the Bay 14.

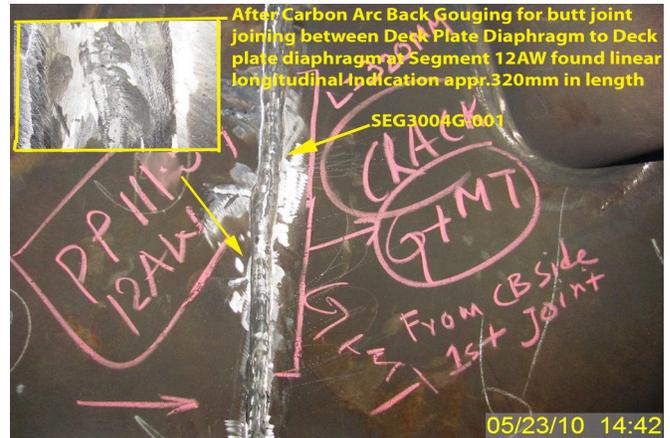
The QA inspector generated an incident report for this date.

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