

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-015146**Date Inspected:** 22-Jun-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

Out Side

This QA Inspector observed the following work in progress:

SMAW in the 2F position for the OBG Segment 11BE, weld No. SEG068D-015. The welder is identified as #216086. ZPMC QC is identified as Mr. Li Ping. The welding variables recorded by QC appear to comply with WPS-B-P-2112-FCM-1.

SMAW in the 3G position for the OBG Segment 11DE, weld No. SEG072D-115. The welder is identified as #054013. ZPMC QC is identified as Mr. Tan Ya Jun. The welding variables recorded by QC appear to comply with WPS-B-P-2213-Tc-U4b-FCM.

Bay #14

This QA Inspector observed the following work in progress:

FCAW in the 2F position for the OBG Segment 13BE side Plate to stiffener, weld No. SP3063A-001-041~050. The welders are identified as #044830/044795. 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 the Quality Assurance visual inspection the QA Inspector observed that the ZPMC personnel performing heat straightening of side plate SP3065A for segment 13CE . The heat straightening report find as HR8650.

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. BP3074-001-001. The welder is identified as #045265. ZPMC QC is identified as Mr. Li Ming Yang. The welding variables recorded by QC appear to comply with WPS-B-T-2221-B-U3c-S-2.

Ultrasonic Testing (UT) for Suspender Bracket

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 suspender brackets.

The weld designation reviewed is as follows:

SB012-050-025,037,049,061,001,004,005,007,008,019,018

SB015-060-025,037,049,061,001,004,005,007,008,019,018

SB016-070-005,043

Green Tagging

This QA inspector performed Visual Inspection for Green Tagging which were previously tested and accepted by ZPMC Quality Control personnel and ABF QA personnel. The members are identified as Suspender Brackets.

Suspender Brackets No. Green Tag No.

SB50W 12309

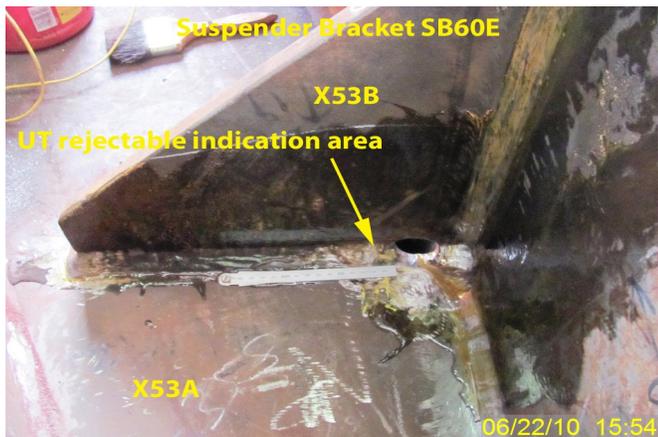
During the Quality Assurance Ultrasonic Testing (UT) review of welds located on Orthotropic Box Girder (OBG) Suspender Bracket SB60E, this Quality Assurance Inspector (QA) discovered the following issues that One (1) longitudinal linear indication measuring approximately 25mm in length. The indication dbS rating is a +4. Material thickness is 20mm. The depth of the indication is approximately 14mm. The weld is identified as SB015-060-019. The weld is Complete Joint Penetration (CJP) "T" joint. The joint joining between X53A to X53B. The weld is designated as Non Seismic Performance Critical Material (Non SPCM). The indication is clearly marked on or near the weld. The Y distance for this indication is 5 mm from cope hole. Suspender Bracket SB60E is located at Bay#19. The Notice of Witness Inspection (NWIT) No. is 006035. The indication is located within the area previously tested and accepted by ZPMC Quality Control (QC) personnel. As per the contract documents, ZPMC's QC personnel are required to perform hundred (100%) percent UT inspection of this weld.

The QA inspector generated an incident report for this date.

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Unless otherwise noted, all work 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 your project.

Inspected By: Bera,Subhasis

Quality Assurance Inspector

Reviewed By: Patterson,Rodney

QA Reviewer
