

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-015217**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:** Le Zhi Jiang**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:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this date Caltrans Office of Structural Material (OSM) Quality Assurance (QA) Inspector, D.Sukanthan was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

OBG # CROSS BEAM CB09

During Quality Assurance random in-process observations of the fabrication of Cross Beam CB9, this Quality Assurance inspector (QA) discovered the following issue. ZPMC performing 3rd time excavation of Seismic Performance Critical Material (SPCM) welds identified as CB202A-009-018 & 006 without Engineers approval. The welds are Complete Joint Penetration (CJP) joints joining the SPCM bottom panels to the SPCM side panels. The affected panels are identified as bottom panels BP205A and BP204A, Side panels SP202A and SP205A. All are identified as SPCM. These welds were previously removed and re-welded on 06/08/10 for the purpose of aligning the bottom panel of the crossbeam to the FL3 bottom panel of Orthotropic Box Girder (OBG) segment 8AE (refer WRR No: B-WR13530 Rev-0 Date: 06/08/10) and 6/14/10 for the same purpose. For more information, please refer the incident report dated 6/14/10. Welds are being excavated and welded today (6/22/10) for non compliant Ultrasonic Testing (UT) indications discovered by ZPMC QC UT technicians. Cross Beam 9 (CB9) is located in the bay 16. This QA notified ZPMC QA identified as Mr. Testino of this issue and that an incident report would be generated. See attached picture.

OBG # CROSS BEAM CB10

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This QA observed ZPMC qualified welding personnel identified as 066179 perform Shielded Metal Arc Weld (SMAW) Process repair welding on weld joint CB202A-010-001. ZPMC Quality Control Personnel (QC) identified as Mr. Li yang was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-4G (4F)-Repair and Weld Repair Report B-WR13694.

OBG # CROSS BEAM CB 11

This QA observed that no significant work was being performed on this crossbeam during the time QA was present.

OBG # CROSS BEAM CB12

This QA observed that no significant work was being performed on this crossbeam during the time QA was present.

OBG # CROSS BEAM CB13

This QA observed that no significant work was being performed on this crossbeam during the time QA was present.

OBG # CROSS BEAM CB14

This QA observed that no significant work was being performed on this crossbeam during the time QA was present.

OBG # CROSS BEAM CB15

This QA observed that no significant work was being performed on this crossbeam during the time QA was present.

OBG # CROSS BEAM CB16

This QA observed that no significant work was being performed on this crossbeam during the time QA was present.

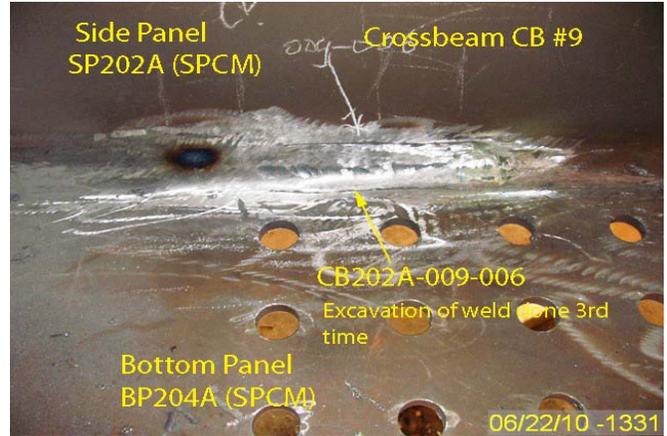
OBG # CROSS BEAM CB17

This QA observed that no significant work was being performed on this crossbeam during the time QA was present.

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

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Summary of Conversations:

As mention above

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 150-00422372, who represents the Office of Structural Materials for your project.

Inspected By: Sukanthan,Dhanasingh

Quality Assurance Inspector

Reviewed By: Hall,Steven

QA Reviewer
