

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-015264**Date Inspected:** 27-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 / Li yan hua**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 Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

Out Side Shop

SMAW welding of weld joint 3G-036 located on PCMK SEG072E of Segment 11DE the welder is identified as 201087. ZPMC QC is identified as Mr. Tang ya jun. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2213-Tc-U4b-FCM.

SMAW welding of weld joint 3G-154 located on PCMK SEG072D of Segment 11DE the welder is identified as 201087. ZPMC QC is identified as Mr. Tang ya jun. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2213-Tc-U4b-FCM.

Bay #14

During the Quality Assurance visual inspection the QA Inspector observed that the ZPMC personnel performing heat straightening of side plate SP3060 for segment 13AE is appeared to comply with the HR8663.

BAY#19

Magnetic particle Testing (MT) for Suspender Bracket

This QA Inspector performed Magnetic particle testing (MT) 15% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (MT) report for this date. The members are identified as suspender brackets.

WELDING INSPECTION REPORT

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The weld designation reviewed is as follows:

SB008-048-031,043,055,067,011,001,006,004,007,008,019.

SB007-048-026, 043, 055, 061, 011, 018, 004, 005, 007.

SB007-048- 032, 001. Reject able indication found Incident report made for these welds.

SB012-054-025, 037, 049, 061, 067, 018, 001, 004, 005, 007, 008, 019.

During the Quality Assurance Magnetic particle Testing (MT) review of welds located on OBG Suspender bracket SB48W, this Quality Assurance Inspector (QA) discovered the following issue:

-Three (3) linear longitudinal indication that measured approximately 15mm to 60mm in length.

-The weld is identified as SB007-048-001

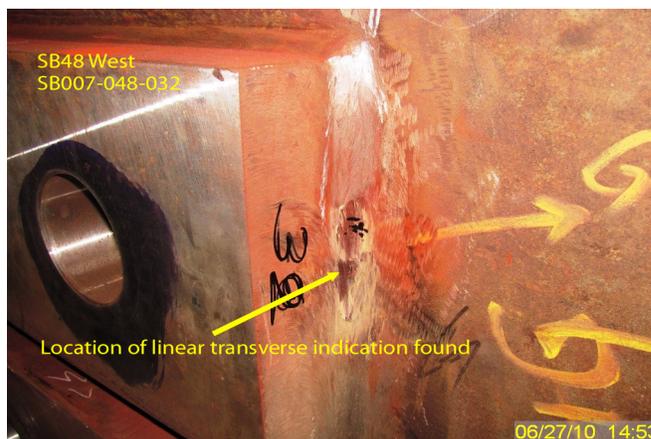
Ten (10) linear Transverse indications that measured approximately 3mm to 6mm in length.

-The weld is identified as SB007-048-032.

For more information please see the Incident report

04-0120F4_TL-15_B247_06-27-10_SB48West__MT_Linear_Indication [1]

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



Summary of Conversations:

No relevant Conversation.

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-15--0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Chadra	Quality Assurance Inspector
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Reviewed By:	McClendon,Timothy	QA Reviewer
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