

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-015593**Date Inspected:** 10-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Shi Gang.**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 OSM Quality Assurance (QA) Inspector, Amit K. Juvekar, was present during the times noted above for observations relative to the work being performed.

Subassembly, Bay 09, Gantry# 2, 13CE, Deck Plate to U-rib.

GMAW welding of Partial Penetration weld joints DP3099-001-001 to 006 & 138 to 141 & 173 to 181; located on Bay 09, Gantry# 2. Welder is identified as 059421, 059418, 201788, 059416; ZPMC Quality Control Inspector (QC) is identified as Duan Ya Bing. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2342-U1(U-rib)-5. The attached photographs provide additional detail.

Subassembly, Bay 09, Gantry# 2, 13CE, Deck Plate to U-rib.

SAW welding of Partial Penetration weld joints DP3099-001-001 to 006 & 138 to 141 & 173, 174, 176 to 181; located on Bay 09, Gantry# 2. Welder is identified as 059421, 059418, 201788, 059416; ZPMC Quality Control Inspector (QC) is identified as Duan Ya Bing. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2342-U1(U-rib)-5.

Subassembly, Bay 09, Gantry# 2, 13CE, Deck Plate to U-rib.

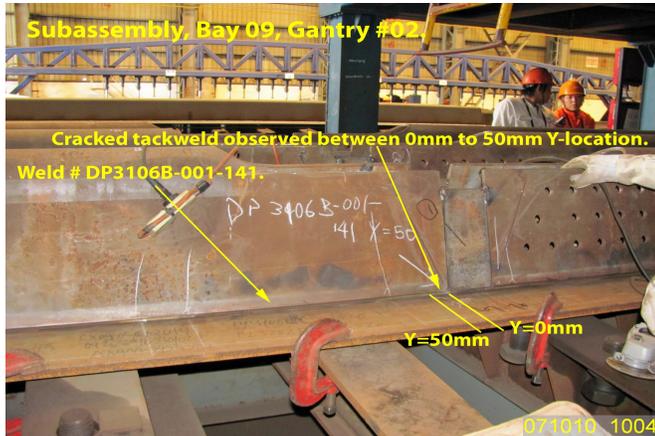
GMAW welding of Partial Penetration weld joints DP3106B-001-001 to 006 & 138 to 141 & 173, 174, 176 to 181; located on Bay 09, Gantry# 2. Welder is identified as 201788, 059416, 059421, 059418; ZPMC Quality Control Inspector (QC) is identified as Duan Ya Bing. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2342-U1(U-rib)-5.

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Before welding above panel; During random Visual testing this QA inspector observed Cracked Tack weld between Y-location 0mm & 50mm. Weld was identified as DP3106B-001-141. ZPMC marked this location & ZPMC NDT personnel “Wang Wei” carried out Magnetic Particle Testing (MT) at all similar locations on the above mentioned deck panel. On the completion of NDT, ZPMC continued the production. Attached photographs provide additional detail.

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



Summary of Conversations:

Subassembly, Bay 09, Gantry# 2, 13CE, Deck Plate to U-rib.

This QA inspector informed ZPMC QC “Duan Ya Bing” about cracked tack weld (Time: 0930). ZPMC NDT personnel Completed MT on all similar locations. (Time: 1045). ZPMC Started production (Time: 1400).

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, 1500.042.2372, who represents the Office of Structural Materials for your project.

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Inspected By:	Juvekar,Amit	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer