

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-015856**Date Inspected:** 24-Jul-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:** Geng wei / 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.

BAY#14

SMAW welding of Critical repair weld joint 2F-010 located on PCMK SEG3006B for Segment 12CW the welder is identified as 068091, 069493. ZPMC QC is identified as Mr. Wang wei ming. The welding variables recorded by QC appeared to Comply with the WPS-345-SMAW-2G(2F)-Repair and CWR-1744.

SMAW welding of weld joint 4F-006 located on PCMK SEG3004Y for Segment 12AW the welder is identified as 067589. ZPMC QC is identified as Mr. wang wei ming. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2114-FCM-1.

SMAW welding of weld joint 3F-023 located on PCMK CA3006 for Segment 12AW the welder is identified as 047864. ZPMC QC is identified as Mr. Wang wei ming. The welding variables recorded by QC appeared to Comply with the WPS-B-T-4113-2.

BAY#19

This QA inspector performed 15% MT of weld areas previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an MT report for this date. The Members are identified as OBG Suspender bracket. The weld designations reviewed as follows.

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SB02-086-002,027,029,051,054,066,060,048,045,072,076. Green tag-12291.

SB17-088-035 - 15 no of Transverse linear indications found, IR made for this weld.

During the Quality Assurance Magnetic particle Testing (MT) review of welds located on OBG Suspender bracket SB88W, this Quality Assurance Inspector (QA) discovered the following issue:

-Fifteen (15) linear Transverse indication that measured approximately 03mm to 08mm in length.

-The weld is identified as SB017-088-035.

For more information please see the Incident report

04-0120F4_TL-15_B247_07-24-10_SB88West__MT_Linear_Indication [1].

BLAST SHOP#1

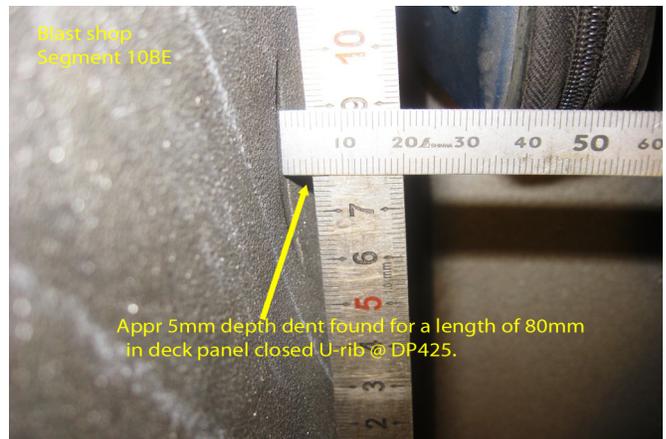
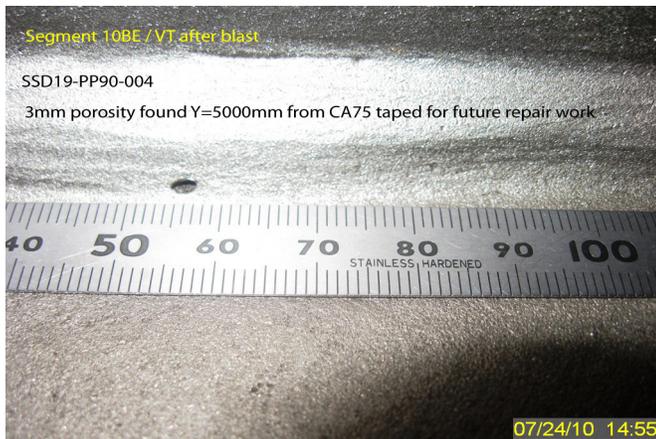
Caltrans Quality Assurance (QA) Inspectors performed random visual inspection of OBG segment 10BE internal deck panel U-ribs, floor beam and corner assembly surfaces from the panel point 89 to 90 after grit blasting. Areas that marked for repair were recorded for future repair. Areas requiring additional grinding were marked by QA and repaired by ZPMC personnel.

- In DP425 (18th U-rib from CA75) approximately 5mm depth dent, 2800mm from west end of segment.

- PP90 ; 3mm porosity found at FB016-001-003 ; Y=6500 from CA75.

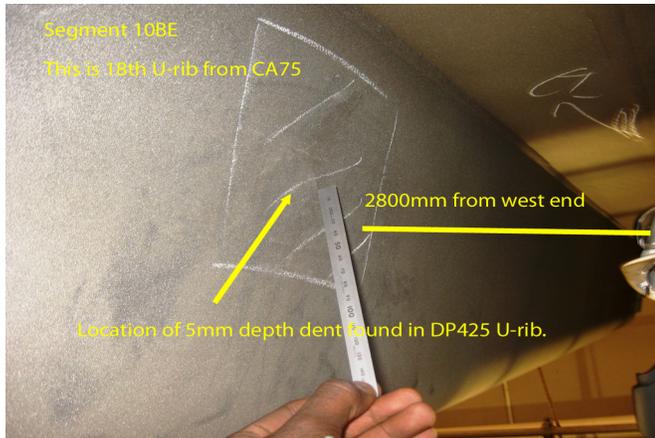
- PP90; 3mm porosity found at SSD19-PP90-004 ; Y=5000 from CA75.

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 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.

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