

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:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017095**Date Inspected:** 26-Aug-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

Bay #19

This QA Inspector observed the following work in progress:

FCAW in the 2F position for the OBG suspender Bracket, weld No. SB020-082-026. The welder is identified as #062806. ZPMC QC is identified as Mr. Xu Tao. The welding variables recorded by QC appear to comply with WPS-B-T-2132.

Bay #14

This QA Inspector observed the following work in progress:

SAW in the 1G position for the OBG Segment 13AE, weld No. SEG3007AE-002. The welder is identified as #044771. ZPMC QC is identified as Mr. Xing Chen Hui. The welding variables recorded by QC appear to comply with WPS-B-T-2221-B-L2c-S-2.

SAW in the 1G position for the OBG Segment 13BW, weld No. SEG3014-002. The welder is identified as #045270. ZPMC QC is identified as Mr. Wang Xu. The welding variables recorded by QC appear to comply with

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

WPS-B-T-2221-B-L2c-S-2.

Magnetic Particle Testing (MPT) for Trial Assembly

This Quality Assurance (QA) Inspector performed Visual inspection and verification of Magnetic Particle Testing (MT) 15% for OBG segment 9CW to 9DW hold back area . This QA inspector generated a (MT) report for this date .This area was previously tested and accepted by ZPMC QC MT technicians.

The Weld Designations are as follows

EP127-001-009,010

EP128-001-013,014

DP686-001-011,012

DP685-001-018

SP671-001-025,026

SP672-001-025,026

SP731-001-032~036

SP732-001-017~022

BP154-001-033~036

BP153-001-047~050

During the Quality Assurance Magnetic Particle Testing (MT) review of welds located on Suspender OBG segment 9CW to 9DW hold back weld , this Quality Assurance (QA) Inspector discovered two (2) Linear indications on the following welds: Weld # SP731-001-031: One(1) Transverse linear indications measuring approximately 8mm in length. Weld # DP685-001-017: One (1) Transverse linear indications measuring approximately 12mm in length. All indications are clearly marked on the material near the weld. OBG Segment 9CW and 9DW are located in trail assembly area .The Notice of Witness Inspection Number (NWIT) is 06488. The indications are located inside an area that has been previously tested by ZPMC Quality Control (QC) personnel.

Visual Inspection after Blast at 11AE

This Quality Assurance (QA) Inspector performed random visual inspection of OBG segment 11AE internal deck panel U-rib and floor beam surfaces after grit blasting in between panel point PP95 to PP97. Areas that marked for repair were recorded for future repair. Areas requiring additional grinding were marked by QA and repaired by ZPMC personnel.

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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



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