

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-017108**Date Inspected:** 07-Sep-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

Out Side Yard

This QA Inspector observed the following work in progress:

SMAW in the 4G position for the OBG segment 12AE, weld No. SEG3001AA-001. The welder is identified as #044779. ZPMC QC is identified as Mr. Li Ping. The welding variables recorded by QC appear to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

SMAW in the 4G position for the OBG segment 12BE, weld No. SEG3002F-253. The welder is identified as #051013. ZPMC QC is identified as Mr. Li Ping. The welding variables recorded by QC appear to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

Bay#16

This QA Inspector observed the following work in progress:

FCAW in the 1G position for the OBG segment 13AW, weld No. BP3056-001-002. The welder is identified as #201888. ZPMC QC is identified as Mr. Wang Jie. The welding variables recorded by QC appear to comply with WPS-B-T-2231-B-U2-F.

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

FCAW in the 2G position for the OBG segment 13BW, weld No. LD3031-001-045. The welder is identified as #045143. ZPMC QC is identified as Mr.Wang Jie. The welding variables recorded by QC appear to comply with WPS-B-P-2232-Tc-U5-F.

Bay#19

This QA Inspector observed the following work in progress:

FCAW in the IG position for the OBG bike path, weld No. BK004A5-004-090. The welder is identified as #062806. ZPMC QC is identified as Mr.li Ming Yang. The welding variables recorded by QC appear to comply with WPS-B-T-2231-Tc-U4b-F.

Ultrasonic Testing (A,B,C and D-Scan)

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The member is identified as corner joint joining between deck plate to edge Plate for segment 12BW at counter weight side. This Inspection was performed after ABF UT Inspectors performed UT of this joint. The result was recorded onto a data sheet according to rejection criteria of "D" Scan procedure that Caltrans QA and ABF QA have jointly filled out on this date. The QA inspector found no rejectable indication at scanned area.

The Weld Designation is as follows

CA3008-004

Magnetic Particle Testing (MPT) for suspender bracket

This Quality Assurance (QA) Inspector performed Visual inspection and verification of Magnetic Particle Testing (MT) 15% for OBG Suspender bracket weld. This QA inspector generated a (MT) report for this date .This area was previously tested and accepted by ZPMC QC MT technicians.

The Weld Designation is as follows

SB020-080-004

Ultrasonic Testing (UT) for suspender bracket

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as suspender bracket weld joint.

The welds designation reviewed is as follows:

SB020-080-004

WELDING INSPECTION REPORT

(Continued Page 3 of 4)

During the Quality Assurance Ultrasonic Testing (UT) review of welds located on Orthotropic Box Girder (OBG) Suspender Bracket SB80E, this Quality Assurance Inspector (QA) discovered the following issues that Three(3) longitudinal measuring approximately 35 ~50mm in length. The indication db ratings are a -3db,+3 and +4db. Material thickness is 22mm. The depth of the indication is approximately 14mm and 17mm. The weld is identified as SB020-080-004. The weld is Complete Joint Penetration (CJP) "T" joint. The weld is designated as Non Seismic Performance Critical Material (Non SPCM). The indication is clearly marked on or near the weld. The Y distance for this indication are 290mm,550 mm and 700mm from edge. Suspender Bracket SB80E is located at Bay#19. The Notice of Witness Inspection (NWIT) No. is 006615. The indication is located within the area previously tested and accepted by ZPMC Quality Control (QC) personnel. As per the contract documents, ZPMC's QC personnel are required to perform hundred (100%) percent UT inspection of this weld.

The QA inspector did not generate any incident report for this date.

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



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

WELDING INSPECTION REPORT

(Continued Page 4 of 4)

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
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Reviewed By:	Patterson,Rodney	QA Reviewer
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