

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017157**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) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. 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 Segments**Summary of Items Observed:**

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

Ultrasonic Testing (UT) – Document No: 006595

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Segment 11DE repaired areas. The weld designations reviewed are as follows:

1. SEG072A-033

Magnetic Particle Testing (MT) - Document No's: 006592

This QA inspector performed MT of approximately 15% of the area 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 Bike Path. The weld designations reviewed are as follows:

1. BK004A3-056-051, 052
2. BK004A4-056-041, 014, 015
3. BK004A7-056-007, 008, 067, 068, 230, 217, 013, 014, 079
4. BK004A7-056-080, 140, 141, 025, 026, 085, 086, 121, 122

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5. BK004A8-056-014, 015, 020, 021, 022, 027, 028, 031, 032

6. BK004A8-056-041, 042, 047, 048, 053, 054, 059, 060, 104

Outside Yard

OBG Segment 11EE

This QA inspector observed ZPMC qualified welding personnel identified as 049339 perform Shielded Metal Arc Welding (SMAW) welding on side plate misalignment location of OBG Segment 11EE, repair weld joint identified as SEG074A-010. ZPMC QC is identified as Mr. Wu Shi gao. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-4G (4F)-FCM-Repair, which is used as per Critical Welding Repair Report (CWR) B-WR1862.

Bay 19

This QA inspector observed ZPMC qualified welding personnel identified as 062806 perform Flux Core Arc Welding (FCAW) welding on OBG Bike path, weld joint identified as BK004A5-004-090. ZPMC QC is identified as Mr. Li Ming Yang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2231-Tc-U4b-F.

Incident Description: During random Quality Assurance visual review of the Suspender bracket components, this Quality Assurance Inspector (QA) observed that ZPMC personnel performing weld repair of one (1) Transverse Indication measuring approximately 10 mm without the prior approval of the Engineer or an approved CWR. This weld is rejected 3rd (third) time by Ultrasonic Testing NDT method. The transverse indication found in the excavation after removing the weld by carbon arc gouging. The weld is identified as SB019-074-004. The weld is Complete Joint Penetration (CJP) weld joining Edge plate to Bottom Plate. This member is located inside the OBG Fabrication shop Bay-19

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



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Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

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

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