

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-017923**Date Inspected:** 10-Nov-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 Bike Path**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.

Magnetic Particle Testing (MT) – NWIT Document No's: 007297

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. BK004A1-003-030, 031, 033, 035, 036, 037, 039
2. BK004A1-003-040, 041, 042, 014, 015, 028, 029
3. BK004A3-003-064, 073
4. BK004A4-003-079, 084
5. BK004A1-008-030, 031, 033, 035, 036, 037, 039
6. BK004A1-008-040, 041, 042, 014, 015, 028, 029
7. BK004A3-008-064, 073
8. BK004A4-008-079, 084
9. BK004A3-004-064, 073
10. BK004A4-004-079, 084

Ultrasonic Testing (UT) – NWIT Document No: 007307

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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 Suspended Bracket The weld designations reviewed are as follows:

1. SB022-104-003

Magnetic Particle Testing (MT) – NWIT Document No's: 007305

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. BK004A5-006-014, 015, 110, 111, 034, 035, 113, 114

2. BK004A5-006-044, 055, 126, 127, 084, 085, 132, 133

Bay 19

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) welding of weld joint SB026-110-059 located on Suspender Bracket SB110W. ZPMC Welder is identified as 062786. ABF Quality Control (QC) is identified as Mr. Peng Wen Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2232-Tc-U4b-F.

FCAW welding of weld joint SB024-108-064 located on Suspender Bracket SB108W. ZPMC Welder is identified as 062762. ABF Quality Control (QC) is identified as Mr. Peng Wen Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2232-Tc-U4b-F.

FCAW welding of weld joint SB025-108-075 located on Suspender Bracket SB108E. ZPMC Welder is identified as 062755. ABF Quality Control (QC) is identified as Mr. Peng Wen Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2232-Tc-U4b-F.

FCAW welding of weld joint SB018-100-001 located on Suspender Bracket SB108E. ZPMC Welder is identified as 062807. ABF Quality Control (QC) is identified as Mr. Peng Wen Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2231-Tc-U4b-F.

FCAW welding of weld joint SB021-096-001 located on Suspender Bracket SB096E. ZPMC Welder is identified as 058782. ABF Quality Control (QC) is identified as Mr. Peng Wen Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2231-Tc-U4b-F.

Description of Incident: During random Quality Assurance visual and work in progress of welds located on OBG Bike Path, ZPMC Quality Control Inspector (QC) discovered that forty one (41) Transverse Linear Cracks with each measuring approximately 8 to 13mm in length. The cracks were found on sole plate of bike path identified as BK004B3-001-052. The weld is fillet weld joint, joining the deck panel to stringer plate, this plate are identified as

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non Seismic Performance Critical Member (non SPCM). The indications are clearly marked on the material near the weld. OBG Bike Path BK004B-001 is located at Bay#19. The Caltrans (CT) Quality Assurance Inspector (QA) requested to ZPMC QC, to prepare Critical weld repair report (CWR) and perform weld repair on above mention weld and after 48 hrs perform MT on same locations. See the attached picture.

This QA inspector observed ABF personnel performed Magnetic Particle Testing on Bottom Cover Plate of OBG Bike Path BK004A-007 and on stringer plate to deck plate joint of OBG Bike Path BK004B-001.

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



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:	Patel,Hiranch	QA Reviewer
