

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-017979**Date Inspected:** 23-Oct-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:	An Qing Xing	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

Outside Yard

This QA Inspector observed the following work in progress:

FCAW in the 2F position for the OBG segment 11BW, weld No.BP160-001-045. The welder is identified as #040736. ZPMC QC is identified as Mr. Wang Zhu. The welding variables recorded by QC appear to comply with WPS-B-T-2132.

FCAW in the 3G position for the OBG segment 11BW to 11CW, weld No.OBW11B-009. The welder is identified as #040609. ZPMC QC is identified as Mr. Wang Zhu. The welding variables recorded by QC appear to comply with WPS-B-T-2233T-1.

FCAW in the 1G position for the OBG segment 11BE to 11CE, weld No.OBE11B-008. The welder is identified as #04367. ZPMC QC is identified as Mr. Wang Li Yang. The welding variables recorded by QC appear to comply with WPS-B-T-223(2)1T-1.

SMAW in the 3G position for the OBG segment 11BW, weld No.SEG067D-049. The welder is identified as #044779. ZPMC QC is identified as Mr. Zhang Qian. The welding variables recorded by QC appear to comply

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with WPS-B-P-2213-Tc-U4b-FCM-1.

Ultrasonic Testing (UT) for Segment 10AW

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 OBG segment 10AW weld joints.

The welds designation reviewed are as follows:

SSD10A-PP086-170
SSD12A-PP088-169
FB023-008-PP087-128
FB027-005-PP086-128
FB027-009-PP086-128

During the Quality Assurance Ultrasonic Testing (UT) review of welds located on Orthotropic Box Girder (OBG) Segment 10AW, this Quality Assurance Inspector (QA) discovered the following issues One (1) longitudinal linear Class "A" rejectable indication measuring approximately 30mm in length. The indication dbS rating is a +4. Material thickness is 16mm. The depth of the indication is approximately 6.5mm. The weld is identified as SSD11A-PP87-168. The weld is Complete Joint Penetration (CJP) "T" joint. The joint joining between floor beam to Deck Plate. The weld is designated as seismic Performance Critical Material (SPCM). The indication is clearly marked near the weld. The Y distance for this indication is 230 mm from floor beam edge. Segment 10AW is located at backside of bay#14. The Notice of Witness Inspection (NWIT) No. is 007070. The indication is located within an 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 on this date because after found the indication ZPMC QA Mr. Lay Tao cancelled the notification.

Magnetic Particle Testing (MPT) for OBG Cross Beam Weld

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

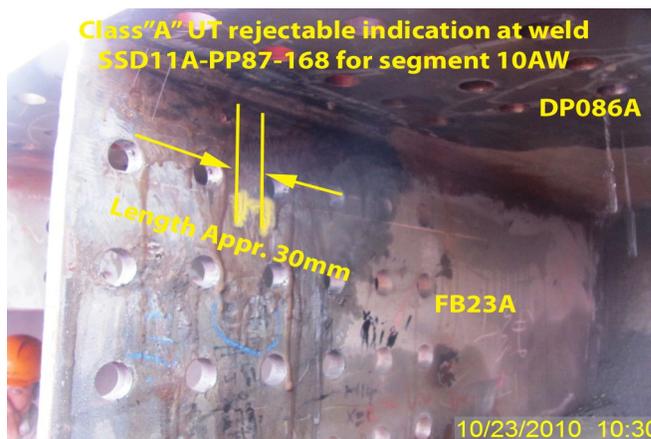
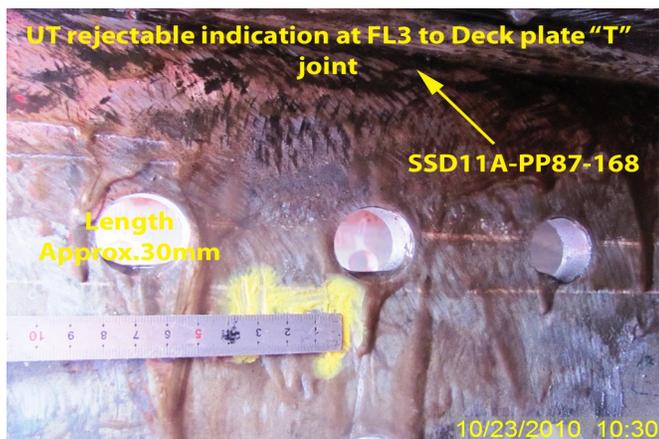
The Weld Designations are as follows

FB204-049-55
CB202G-051-185
CB202G-049-185
FB205-050-027
CB202G-051-180

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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 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: McClendon, Timothy

QA Reviewer
