

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-018752**Date Inspected:** 10-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

Trial Assembly Yard

This QA Inspector observed the following work in progress:

SMAW in the 4F position for the OBG segment 11AE to 11BE, weld No.DP704-001-015. The welder is identified as #040320. ZPMC QC is identified as Mr.An Qing Xing .The welding variables recorded by QC appear to comply with WPS-B-T-4114-1.

SMAW in the 4F position for the OBG segment 11AE to 11BE, weld No.DP718-001-012. The welder is identified as #044504. ZPMC QC is identified as Mr.An Qing Xing .The welding variables recorded by QC appear to comply with WPS-B-T-4114-1.

Outside

This QA Inspector observed the following work in progress:

FCAW in the 3G position for the OBG segment 12AE, weld No.SEG3001T-034. The welder is identified as #044779. ZPMC QC is identified as Mr. Wang Xing Pin. The welding variables recorded by QC appear to comply with WPS-B-P-2213-Tc-U4B-FCM-1.

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Bay#16

This QA Inspector observed the following work in progress:

FCAW in the 3G position for the OBG longitudinal Diaphragm lifting Lug, weld No.LD3031-001-170. The welder is identified as #045280. ABF QA is identified as Mr.Li Shi You .The welding variables recorded by QC appear to comply with WPS-B-T-2233-Tc-U5-F.

FCAW in the 2F position for the OBG Segment 13AW bottom plate to stiffener, weld No.BP3056-001-089/090. The welders are identified as #070254 and #037705. ZPMC QC is identified as Mr.Liu Dao Fang .The welding variables recorded by QC appear to comply with WPS-B-T-2233-Tc-U5-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 Edge Plate to Deck Plate for segment 12CE at Cross Beam 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

CA3004-004

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 Edge Plate to Deck Plate for segment 12CE at bike path 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

CA3005-004

Ultrasonic Testing (UT) for Bike path

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 bike path weld joints.

The welds designation reviewed are as follows:

BK004A1-008-006,008

BK004A3-005,009

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BK004A5-008-004,007
BK004A5-008-125
BK4ASD1-008-005,018,021

During the Quality Assurance Ultrasonic Testing (UT) review of (2) welds located on OBG Bike Path, these Quality Assurance Inspectors (QA) discovered the following issues two (2) Class “A” indications measuring approximately 30-35mm in length. The welds are Complete Joint Penetration butt joints joining the stiffener to stiffener. The Indication rating is +8dB and length approximately 30mm. The depth of the indication approximately 8mm for weld BK004A5-008-122. The “Y” location for this indication approximately 50mm from deck plate. And the Indication rating is +1dB and length approximately 40mm for weld joint BK4ASD1-008-006. The depth of the indication approximately 12mm for weld BK4ASD1-008-006. The “Y” location for this indication approximately 250mm from edge of plate. The indications are clearly marked by the QA Inspectors near the weld. These welds joints are designated as non Seismic Performance Critical Member (non SPCM). The OBG Bike Paths are located in the inside of fabrication bay 19. The Notice of Witness Inspection Number (NWIT) is 006908. The indications are located within the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. As per the contract documents, ZPMC’s QC personnel are required to perform 100% UT inspection of this weld.

The QA inspector Mr. Vibin Kumar to made an incident report on 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 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