

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-018931**Date Inspected:** 16-Dec-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 Xian Ping**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:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this date Caltrans Office of Structural Material (OSM) Quality Assurance (QA) Inspector, D.Sukanthan was present during the time noted above for observations relative to the work being performed.

OBG # CROSSBEAM CB18

This QA inspector received ZPMC Non Destructive Testing (NDT) notification 07782 to perform Magnetic particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated a Magnetic particle Test report for this date. The member is identified as Crossbeam CB18. The weld tested is identified as follows:

- (CB3002J-002-158) Non compliant Indication
- (CB3002J-002-154) Non compliant Indication
- (CB3002J-002-320) Non compliant Indication
- (CB3002K-003-029) Non compliant Indication
- (CB3002K-004-158) Non compliant Indication

This QA notified ZPMC Certified Welding Inspector (CWI) identified as Mr. Huang ming of this issue and that an incident report would be generated. For more information please refer generated incident report on this date. See attached pictures.

ZPMC Quality Control (QC) inspectors have issued a report stating that they had visually tested and accepted a

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fillet weld where the fillet appears to be missing. VT report identified as B-VT-87758, documents that this weld was visually tested and accepted. The weld is identified as CB3002J-002-138.

This weld is a fillet weld joining Floor Beam (FB4100A) to the I-rib stiffeners (X3726E) and the interior Diaphragm identified as SA3075A. The notice of witness Inspection Number (NWIT) is 07782. This weld joint is within an area that has been previously tested and accepted by ZPMC Quality Control (QC) personal. As per contract documents ZPMC is required to perform 100% visual testing (VT) of this weld. This QA notified ZPMC Certified Welding Inspector (CWI) identified as Mr. Huang ming of this issue and that an incident report would be generated. See attached pictures.

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



Summary of Conversations:

As mention above

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 150-00422372, who represents the Office of Structural Materials for your project.

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Inspected By:	Sukanthan,Dhanasingh	Quality Assurance Inspector
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Reviewed By:	Hall,Steven	QA Reviewer
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