

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:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020038**Date Inspected:** 13-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Geng Wei.**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 OSM Quality Assurance (QA) Inspector, Amit K. Juvekar, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Assembly, Bay 14, 12CE, Bottom Panel to Longitudinal Diaphragm.

FCAW welding of weld joint SEG3003S-056; located on assembly, Bay 14, 12CE. Welder is identified as 044774; ZPMC Quality Control Inspector (QC) is identified as Geng Wei. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2232-TC-U4B-F.

Assembly, Bay 14, 12AE, Bottom Panel to Longitudinal Diaphragm.

During the Quality Assurance (QA) random in-process visual inspection of OBG 12AE Caltrans Quality Assurance Inspector (QA) observed the following:

-ZPMC performed a Critical Weld Repair (CWR) on Seismic Performance Critical Material (SPCM) weld without an approved CWR procedure.

-The repair area was excavated to a depth exceeding 65% of the material thickness.

-The weld is identified as SEG3001V-046.

-The weld is a Complete Joint Penetration (CJP) T-joint joining Longitudinal Diaphragm (LD) LD3007A to the SPCM portion (between PP111.5 and PP112) of Bottom Panel (BP) BP3001A.

-The weld was tested and rejected by ZPMC Ultrasonic Testing (UT) technicians.

-Depth of the excavation measured approximately 21mm (as shown in photograph.).

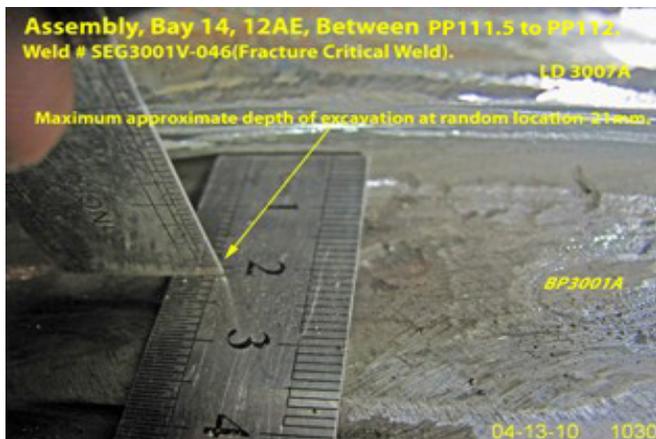
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-Thickness of the longitudinal diaphragm measured 18mm.

The attached photographs provide additional detail.

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



Summary of Conversations:

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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, 1500.042.2372, who represents the Office of Structural Materials for your project.

Inspected By:	Juvekar,Amit	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer
