

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-020602**Date Inspected:** 23-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), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. 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:** BAY 14 OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Robert A. DeArmond was present during the time noted above and conducted observations relative to the work being performed.

Magnetic Particle Testing (MT)

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. All components were as listed on NWIT notification no. 07459. The member(s) is/are identified as Corner Assembly. The weld designations reviewed are as follows:

CA3016A-004~016, 054~065

CA3016B-004~015, 054~065

CA3016C-151~162, 055~065

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OBG BAY 14

This QA Inspector observed the following work in progress:

FCAW welding of complete joint penetration weld joint(s) located on U-Rib to Deck Plate identified as DP3120-001 weld number(s) 070 and 063. Welder is identified as welder no. 069043. The welding variables recorded by ZPMC QC identified as Zhong Guo Hui appeared to comply with applicable WPS(s) WPS-B-T-2233-TC-U5-F.

FCAW welding of complete joint penetration weld joint(s) located on U-Rib to Deck Plate identified as DP3121-001 weld number(s) 011, 018, 221, and 028. Welder is identified as welder no. 070217. The welding variables recorded by ZPMC QC identified as Zhong Guo Hui appeared to comply with applicable WPS(s) B-T-2233-TC-U5-F.

This QA observed the following preheat and post weld thermal treatment conditions identified as DP3091-001 weld no. 180 that did not appear to comply with the contract documents. This QA informed ZPMC QC identified as Mr. Zhong Guo Hui of this issue and that an incident report would be generated concerning this issue. For further details refer to the incident report issued by this QA on this date and the attached photos

This QA observed ZPMC personnel not following QA_QC Peer Review Report, dated November 19, 2010 rev3. Doc. This QA discovered the following issue(s) that were not followed:

1. Pre-Heat
2. Welding starts and stops not ground
3. Postweld Thermal Treatment

FCAW welding of complete joint penetration weld joint(s) located on U-Rib to Deck Plate identified as DP3122-001 weld number(s) 203, 206, 213, 218, 223, 228, 233, and 238. Welder is identified as welder no. 070006. The welding variables recorded by ZPMC QC identified as Zhong Guo Hui appeared to comply with applicable WPS(s) B-T-2233-TC-U5-F.

FCAW welding of complete joint penetration weld joint(s) located on U-Rib to Deck Plate identified as DP3089-001 weld number(s) 160 and 161. Welder is identified as welder no. 044790. The welding variables recorded by ZPMC QC identified as Zhong Guo Hui appeared to comply with applicable WPS(s) B-T-2133-ESAB.

FCAW welding of complete joint penetration weld joint(s) located on U-Rib to Deck Plate identified as DP3092-001 weld number(s) 152 and 153. Welder is identified as welder no. 044790. The welding variables

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recorded by ZPMC QC identified as Zhong Guo Hui appeared to comply with applicable WPS(s) B-T-2133-ESAB.

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



Summary of Conversations:

As mentioned above 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 Jim Devy 150-002-6784, who represents the Office of Structural Materials for your project.

Inspected By:	DeArmond,Robert	Quality Assurance Inspector
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Reviewed By:	Riley,Ken	QA Reviewer
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