

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-020670**Date Inspected:** 22-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**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**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Mike Hasler was present during the times noted above for observations relative to the work being performed.

OBG Segment Name: 6CE / Trial Assembly

This Caltrans QA inspector observed Shielded Metal Arc Welding (SMAW) in progress. Welder is identified as #058087 welding critical weld repair B-CWR-1139, CA030-004, 006 in the 1G position. ZPMC QC inspectors are identified as Mr. Wang Li Yang and certified welding inspector (CWI); Mr. Wu Zhi Cheng. The welding variables recorded by QC appeared to comply with the CWR welding specification (WPS).

OBG Segment Name: OBG 5AW-5BW, BP to SP-W4 (CB side) / Trial Assembly

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. The welds tested were scanned with Pattern "D" only in locations where flush grinding was present. All rejectable Indications were recorded on a data sheet that ABF and Caltrans QA generated after performing a joint inspection. The members are identified as the Edge to deck plate splice welds at W4 for segment 5AW-5BW. The weld designations are as follows:

SEG021A-007

SEG023A-021

This Caltrans QA inspector performed UT inspection using the conventional scan pattern A, B, C, and "D" per ABF Verification Witness Request #01212010-1 Item 1, weld repair, 5W BP to SP-W4 @ 5AW-5BW (CB side). QAMT/VT was not performed, due to the surface condition of the plate having coupling on it from ABF UT inspection. See Segment Splice NDT Tracking, dated 01-22-10 and Caltrans Ultrasonic Test Report (TL6027),

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dated 01-22-10 for additional information.

OBG Segment Name: 8CW / Blast Shop 1

This QA Inspector and Caltrans QA Inspectors Paul Dawson and George Goulet performed random Visual Test (VT) inspections of the upper internal surfaces, after grit blast, from transverse weld seam to PP68 and too PP69 per ZPMC Notification of Inspection Request #2553. Areas of visual weld and base metal defects that will require welding were taped and will be repaired after the coating is applied. Locations where arc strikes were observed were marked up for MT after repair. ZPMC QC personnel were informed of these areas and were partially present during QA's inspection. However, QA observed that ZPMC QC/ABF were not thorough in their inspection. Since this QA inspector observed numerous locations were marked-up for grinding, MT and welding, that should have been observed and marked-up by QC/ABF during their inspection. ZPMC/ ABF performance was verbally passed on to Caltrans day-shift Lead Inspectors in regards to informing ZPMC /ABF lead personnel of the poor performance of their inspectors.

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

Summary of Conversations:

“As noted within the contents of this report.”

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

Inspected By:	Hasler, Mike	Quality Assurance Inspector
Reviewed By:	Riley, Ken	QA Reviewer
