

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-024515**Date Inspected:** 28-May-2011**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:** Liu Hua Jie**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 day Caltrans OSM Quality Assurance (QA) Inspector Subhasis Bera was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China. QA Inspector observed and/or found the following:

Ultrasonic Testing (A, B, C and D-Scan)

This QA Inspector performed Ultrasonic testing (UT) verification of the area previously tested and accepted by ABF Quality control personnel. This QA inspector generated a (UT) report for this date. The member is identified as butt joint joining between side Plate to bottom plate for OBG segment 13AW. The result was recorded onto a data sheet according to rejection criteria of "D" Scan procedure 001 rev.1 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 designations are as follows

SEG3013A-002~005

This QA Inspector performed Ultrasonic testing (UT) verification of the area previously tested and accepted by ABF Quality control personnel. This QA inspector generated a (UT) report for this date. The member is identified as butt joint joining between side Plate to bottom plate for OBG segment 14W. The result was recorded onto a data sheet according to rejection criteria of "D" Scan procedure 001 rev.1 that Caltrans QA and ABF QA have jointly

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filled out on this date. The QA inspector found no rejectable indication at scanned area.

The Weld Designation is as follows

SEG3020AL-007

CWR verifications (CWR2994R0)

Type – (UT Reject - Multiple Time Repair)

This QA Inspector was notified via email for verification of B-CWR2994 R0 at 1510 hours the following was observed:

- The components for verification were identified as EP3023-001-033(13AW)
- Welds repair were to be performed on location where rejectable indication was observed during Ultrasonic Testing (UT)
- ZPMC QC Zhou Zhong Hai was present on site to direct and record all repair work.
- WPS to be used for repair was WPS-345-SMAW-3G(3F)-FCM-Repair-1.

CWR verifications (CWR2995R0)

Type – (Crack Repair)

This QA Inspector was notified via email for verification of B-CWR2995 R0 at 1530 hours the following was observed:

- The component for verification was identified as BK011A4-001-008(BK11A-001)
- Weld repair was to be performed on location where rejectable indication was observed during visual inspection.
- ZPMC QC Xu Le Feng was present on site to direct and record all repair work.
- WPS to be used for repair was WPS-345-SMAW-2G(2F)-Repair-1.

Magnetic Particle Testing (MPT) for side plate splice joint temporary attachment area on 13AE to 13BE at cross beam side

This Quality Assurance (QA) Inspector performed Visual inspection and verification of Magnetic Particle Testing (MT) 15% for OBG segment 13AE to 13BE side plate splice joint temporary attachment area at Cross Beam side. This QA inspector generated a (MT) report for this date .This area was previously tested and accepted by ABF QC MT technicians.

The Weld Designations are as follows

OBE13D-003,004

During the Quality Assurance Magnetic particle Testing (MT) review of welds located on Orthotropic Box Girder (OBG) Segment 13AE to 13BE side plate splice joint temporary attachment area adjacent the weld OBE13D-003 , this Quality Assurance Inspector (QA) discovered one (1) Longitudinal linear indication measuring approximately 18mm in length. After that the notification was canceled by ABF inspector Kevin Chen. This QA inspector did not generate an incident report on this date.

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

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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
Reviewed By:	Dsouza,Christopher	QA Reviewer
