

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:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003617**Date Inspected:** 17-Aug-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 430**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** Cheng Xi**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:**

UT of Deck Panel tack welds

This Quality Assurance (QA) inspector arrived at ZPMC in Shanghai China for observation of Orthotropic Bridge Girders (OBG) and Self Anchored Suspension (SAS) Bridge. This QA inspector received notification from day shift task leader of Ultrasonic Inspection for tack welds on deck panels. The inspection is preliminary prior to using the phased array system to verify tack welds for crack indications. This QA inspector performed UT on deck panel DP 432-001 weld 4 scanned 26 locations with 2 indications and weld 5 scanned 26 locations with 5 indication., Total tack welds inspected were 52 with 7 tack welds marked with indications for further review with the phase array system. This QA inspector was informed by the task leader that no TL-6027 was required at this time.

PMT

This QA inspector observed ZPMC performing the Production Monitoring Test (PMT) for deck panels DP063-001 and DP458-002. The PMT included 3 ribs located on a single plate welded simultaneously with the Gas Metal Arc Welding (GMAW) root pass and the Submerged Arc Welding (SAW) cover pass. The PMT was started at 12:19 am and was completed by 12:56 am. ZPMC performed UT testing and accepted the PMT which was witnessed by this QA inspector. After completion of the UT testing this QA inspector identified the areas for the macro etches and marked them to be cut by ZPMC and acid etched. Later in the shift ZPMC, ABF and Caltrans METS viewed the 15 macros and determined them to be within the specified requirements as agreed upon by all 3 parties.

Final MT deck panels

The QA Inspector received notification for final MT of deck panel repairs in tower shop bay 3. ZPMC was observed performing the MT testing on the 4 panels requested and had found them to be acceptable. This QA inspector then performed a 10% QA review for these panels which are as follows; DP 549-002, DP 559-001,

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DP554-001 and DP 584-001. At the time of this QA inspectors review the MT appeared to be within compliance and a TL-6028 will be generated for these locations. This was a 3 party final MT for deck panel repairs.

Summary of Conversations:

No conversations today.

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 Ady Velasco , 1-381-694-2685, who represents the Office of Structural Materials for your project.

Inspected By:	Riley, Ken	Quality Assurance Inspector
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Reviewed By:	Carreon, Albert	QA Reviewer
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