

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-005072**Date Inspected:** 01-Dec-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	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:

Caltrans Quality Assurance (QA) Inspector, Erik Prue was present to perform Ultrasonic Testing (UT) of Orthotropic Box Girder (OBG) components, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Outside OBG Assembly:

Quality Assurance (QA) inspector arrived at ZPMC in Shanghai China for observation of Orthotropic Bridge Girders (OBG) and Self Anchored Suspension (SAS) Bridge. QA inspector received notification from day shift task leader to perform conventional Ultrasonic (A scan) Inspection for tack welds on deck panels. The inspection is preliminary prior to using the phased array system to verify indications found with conventional Ultrasonic testing. QA inspector performed UT on deck panel DP598-001 (14mm TM), 5 ribs, 10 welds, 200 total tack welds inspected. Weld 1 scanned 20 locations with 0 indications, weld 2 scanned 20 locations with 1 indication, weld 3 scanned 20 locations with 0 indications, weld 4 scanned 20 locations with 0 indications, weld 5 scanned 20 locations with 1 indication, weld 6 scanned 20 locations with 0 indications, weld 7 scanned 20 locations with 1 indication, weld 8 scanned 20 locations with 1 indication, weld 9 scanned 20 locations with 2 indications, and weld 10 scanned 20 locations with 0 indications. All indications are marked on top of u-ribs. Please see U-rib Deck Panel Tack Weld Assessment report dated 01 December, 2008 for specific locations of indications. QA inspector performed UT on deck panel DP617-001 (14mm TM), 5 ribs, 10 welds, 198 total tack welds inspected. A total of 49 indications were marked on U-ribs for investigation by phased array. Y location was marked on top of u-ribs but not recorded, NPI personnel started phased array UT inspection and will record the Y locations. See Caltrans U-rib to Deck Panel- Tack Weld Assessment sheets dated 01 December, 2008 for

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additional information on inspection

No other activities observed.

Summary of Conversations:

No significant conversations this day.

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 Peter Dauterman, 15002199593, who represents the Office of Structural Materials for your project.

Inspected By:	Prue,Erik	Quality Assurance Inspector
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Reviewed By:	Carreon,Albert	QA Reviewer
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