

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-012240**Date Inspected:** 21-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**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 COMPONENT	

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

Ultrasonic Testing (UT)

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as OBG Segment 6AE to 6BE splice joints for T-rib to T-rib and I-rib to I-rib.

The Weld Designations are as follows

SP-088-001-039

SP-566-002-055

SP-606-002-055,058,059 and 060

BP-167-001-029,031

BP-059-001-021,023,025

SP-361-001-027,029

SP-334-001-023,029,031

SP-426-001-041

DP-653-001-023

EP-054-001-015

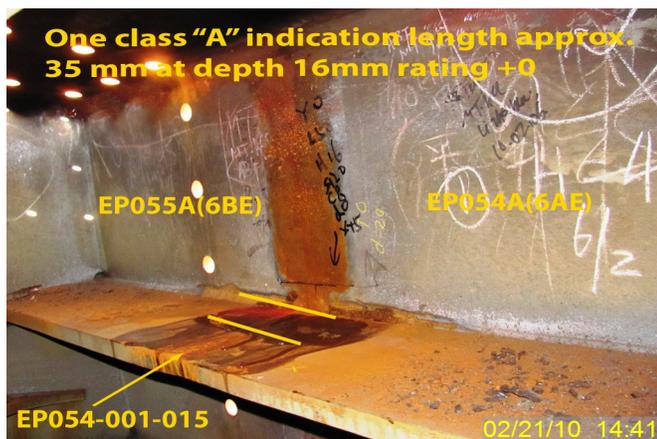
WELDING INSPECTION REPORT

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During the Quality Assurance Ultrasonic Testing (UT) review of welds located on Orthotropic Box Girder (OBG) segment 6AE to 6BE, this Quality Assurance Inspector (QA) discovered that One (1) longitudinal Class “A” indication measuring approximately 35mm in length. The indication dbS rating is +0. Material thickness is 28mm. The depth of the indication is approximately 16.5mm. The weld is identified as EP054-001-015 joining between I-rib to I-rib stiffener. The indication is clearly marked on or near the weld. The Y distance for this indication is 45 mm from edge of the Stiffener plate. The weld is a Complete Joint Penetration (CJP) Butt joint joining I-rib RS88HR to I-rib RS88EA. Segment 6AE+6BE is located at Trial Assembly Area. The Notice of Witness Inspection (NWIT) No. is 005218. The indication is located outside the area previously tested and accepted by ZPMC Quality Control (QC) personnel. As per the contract documents, ZPMCs QC personnel are required to perform 25% UT inspection of this weld.

This QA Inspector generated an incident report for this date.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract 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:	Patterson,Rodney	QA Reviewer
