

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-015053**Date Inspected:** 13-Jun-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:** Yang Bai Qiang.**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:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Amit Juvekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG Bay 12, Deck Panel 13CW-DP3152-001.

QA inspector performed conventional Ultrasonic Testing (UT) Inspection of approximately 10% for Lack of Penetration (LOP) on deck panel (U-rib to deck plate) Partial Penetration weld areas previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated UT report for this date. The members are identified as Deck Panel. The weld designations reviewed are as follows

DP3152-001-001 to 006, 138 to 141, 173, 174, 176 to 181.

Subassembly, Bay 09, Deck Panel 13CW-DP3152-001.

This QA inspector performed conventional Ultrasonic Testing (UT) Inspection on deck panel tack weld areas. The inspection is preliminary prior to using the phased array (PAUT) testing system to verify indications found with conventional Ultrasonic testing. QA inspector performed UT on deck panel DP3152-001, 09 ribs, 18 welds, 138 total tack welds inspected.

Weld 1 scanned 9 locations with 1 indication.

Weld 2 scanned 9 locations with no indications.

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Weld 3 scanned 9 locations with no indications.
Weld 4 scanned 9 locations with no indication.
Weld 5 scanned 9 locations with 2 indications.
Weld 6 scanned 9 locations with no indications.
Weld 138 scanned 9 locations with no indication.
Weld 139 scanned 9 locations with 1 indications.
Weld 173 scanned 9 locations with no indications.
Weld 174 scanned 9 locations with no indication.
Weld 140 scanned 9 locations with no indications.
Weld 141 scanned 9 locations with no indications.
Weld 176 scanned 5 locations with no indications.
Weld 177 scanned 5 locations with 1 indications.
Weld 178 scanned 5 locations with no indications.
Weld 180 scanned 5 locations with no indications.
Weld 179 scanned 5 locations with no indications.
Weld 181 scanned 5 locations with 1 indications.

QA Inspector performed initial Phased Array Ultrasonic Testing (PAUT) following the guide lines of UT procedure titled “Phased Array Ultrasonic Testing for the Detection and Sizing of Suspected Planar Discontinuities (Cracks) in PJP Welds, # UT 04-0120F4 PJP Rib Weld” after conventional UT was performed on tack welded areas of the Partial Joint Penetration (PJP) welds joining u-ribs to deck plate. The deck panels examined are as follows:

DP-3152-001: 2 tack weld locations found compliant and 4 tack weld location found non-compliant.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the 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, 1500.042.2372, who represents the Office of Structural Materials for your project.

Inspected By:	Juvekar,Amit	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
