

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-015383**Date Inspected:** 30-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:	Sun Bo.			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 date Caltrans OSM Quality Assurance (QA) Inspector, Amit K. Juvekar, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Subassembly, Bay 04, 13AW, Deck panel to U-rib.

FCAW Repair welding of partial penetration weld joints DP3124-001-001(Y-Locations 8850, 5850, 4050, 50, 1050); located on subassembly, Bay 04, 13AW. Welder is identified as 062265; ZPMC Quality Control Inspector (QC) is identified as Sun Bo. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-345-FCAW-2G(2F)-FCM-REPAIR.

Subassembly, Bay 04, 13AW, Deck panel to U-rib.

FCAW Repair welding of partial penetration weld joints DP3124-001-007(Y-Locations 8250); located on subassembly, Bay 04, 13AW. Welder is identified as 062265; ZPMC Quality Control Inspector (QC) is identified as Sun Bo. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-345-FCAW-2G(2F)-FCM-REPAIR.

Subassembly, Bay 04, 13AW, Deck panel to U-rib.

FCAW Repair welding of partial penetration weld joints DP3124-001-008(Y-Locations 4650); located on subassembly, Bay 04, 13AW. Welder is identified as 062265; ZPMC Quality Control Inspector (QC) is identified as Sun Bo. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the

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Applicable WPS: WPS-345-FCAW-2G(2F)-FCM-REPAIR.

Subassembly, Bay 04, 13AW, Deck panel to U-rib.

FCAW Repair welding of partial penetration weld joints DP3124-001-006(Y-Locations 4650); located on subassembly, Bay 04, 13AW. Welder is identified as 062265; ZPMC Quality Control Inspector (QC) is identified as Sun Bo. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-345-FCAW-2G(2F)-FCM-REPAIR.

Subassembly, Bay 04, 13AW, Deck Panel U-ribs.

During Random Visual in process Inspection, this QA inspector observed ZPMC NDT personnel carrying out Magnetic Particle Testing (MT) on Deck panel to U-rib weld on PAUT reject locations. Deck Panel identified as DP3119-001. The attached photographs provide additional detail.

Subassembly, Bay 04, Deck Panel 13AE-DP3075-001.

This QA Inspector performed 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 ZPMC welding personnel performed weld repairs of tacked areas of the Partial Joint Penetration (PJP) welds joining u-ribs to deck plate. The deck panel examined is as follows:

DP3075-001: 27 tack weld location found compliant and 2 tack weld locations found non-compliant.

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, 1500.042.2372, who represents the Office of Structural Materials for your project.

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