

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-015384**Date Inspected:** 01-Jul-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.

During the Quality Assurance (QA) random in-process visual inspection of Orthotropic Box Girder (OBG) Deck Panels (DP), this QA inspector discovered ZPMC excavation a Partial Joint Penetration (PJP) weld joint on DP3117(PL 3313A)-001 that exceeded the thickness of the U-Rib. QA inspector notified ZPMC QC "Zhang Qiao" about this issue. For additional details please refer incident report submitted on same date.

Subassembly, Bay 04, Deck Panel 13AE-DP3080-001.

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:

DP3080-001: 13 tack weld location found compliant and 4 tack weld locations found non-compliant.

Subassembly, Bay 04, Deck Panel 13CE-DP3103-001.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

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-3103-001: no tack weld locations found compliant and 9 tack weld location found non-compliant.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Subassembly, Bay 04, 13AW, DP3117(PL 3313A)-001.

ZPMC stopped working on repair located at DP3117-001-001 (Y=11550mm). ZPMC QC “Zhang Qiao” agreed to get Critical Weld repair (CWR) report for repair.

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
