

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-015980**Date Inspected:** 22-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**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 segment 11BE.

The welds designation reviewed are as follows:

SEG068*-007,008,009,010,011,012,019,020,021,022,023,024,035,036,039,040

SSD18A-PP100-002,003,009

CSD4-PP100-132,134,081,083,085,089,093,106

CSD2-PP100.5-049,053

CSD2-PP099.5-049,050

Visual Inspection after Blast at 10BE

This Quality Assurance (QA) Inspector performed random visual inspection of OBG segment 10BE external side panel, deck panel and bottom panel surfaces after grit blasting. Areas that marked for repair were recorded for future repair. Areas requiring additional grinding were marked by QA and repaired by ZPMC personnel.

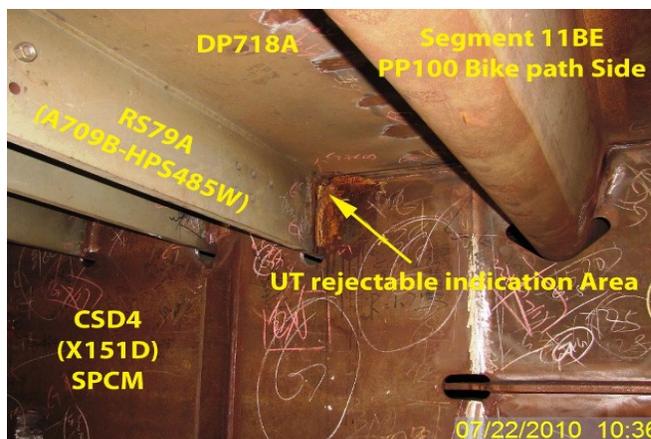
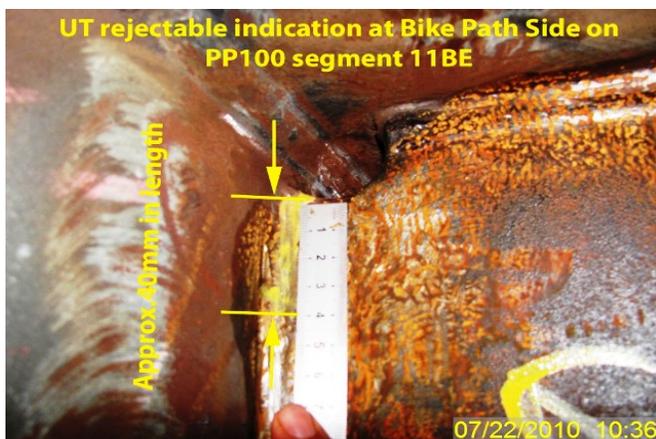
WELDING INSPECTION REPORT

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During the Quality Assurance Ultrasonic Testing (UT) review of welds located on Orthotropic Box Girder (OBG) segment 11BE, this Quality Assurance Inspector (QA) discovered the following issues that One (1) longitudinal linear indication measuring approximately 40mm in length. The indication dbS rating is a +6. Material thickness is 22mm. The depth of the indication is approximately 12mm. The weld is identified as CSD4-PP100-130 at Bike Path Side, Panel Point PP100. The weld is fillet weld according to approved shop drawing but due to excessive root gap ZPMC changed to Complete Joint Penetration (CJP) "T" joint. The joint joining between Corner Assembly Diaphragm (X151D) to Deck Plate Stiffener (RS79A). The weld is designated as Seismic Performance Critical Material (SPCM). The indication is clearly marked on or near the weld. The Y distance for this indication is 5 mm from top Cope hole. Segment 11BE is located at near trial assembly Yard. The Notice of Witness Inspection (NWIT) No. is 006235. The indication is located Within an area previously tested and accepted by ZPMC Quality Control (QC) personnel. As per the contract documents, ZPMC's QC personnel are required to perform hundred (100%) percent UT inspection of this weld.

The QA Inspector generated an incident report on 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