

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

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-016088**Date Inspected:** 29-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:** Chen Shigang.**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.

Subassembly, Bay 04, Deck Panel 13CE-DP3106B-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:

DP3106B-001: 09 tack weld location found compliant and no tack weld location found non-compliant.

Subassembly, Bay 04, Deck Panel 13CE-DP3105-001.

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:

DP3105-001: 08 tack weld location found compliant and 01 tack weld location found non-compliant.

# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

Subassembly, Bay 09, 14W, Continuity Stiffener inside U-Rib.

FCAW welding of weld complete penetration joint DP3177-001-226, 229; located on subassembly, Bay 09, 14W. Welder is identified as 059401; ZPMC Quality Control Inspector (QC) is identified as Chen Shigang. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2233-TC-U4B-F. The attached photographs provide additional detail.

Subassembly, Bay 09, 14W, Continuity Stiffener inside U-Rib.

FCAW welding of Fillet weld Partial Penetration joint DP3177-001-227; located on subassembly, Bay 09, 14W. Welder is identified as 059401; ZPMC Quality Control Inspector (QC) is identified as Chen Shigang. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2133.

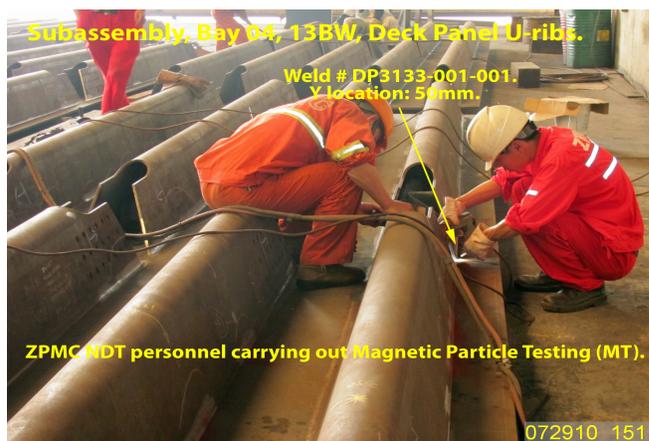
Subassembly, Bay 04, 13BW, Deck Panel U-ribs.

During Random Visual in process Inspection, this QA inspector observed ZPMC NDT personnel “Liu Zhang Min” carrying out Magnetic Particle Testing (MT) on Deck panel to U-rib welds. Deck Panel identified as DP3133-001. The attached photographs provide additional detail.

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

During Random Visual in process Inspection, this QA inspector observed ZPMC personnel carrying out Weld repairs after visual testing on Deck panel to U-rib welds of Deck Panel DP3132(PL3328B)-001. Repair carried out with Flux core arc welding (FCAW). Weld identified as DP3132(PL3328B)-001-178. Approximate Y-location of repair identified as 4150mm. Welder is identified as 203805; ZPMC Quality Control Inspector (QC) is identified as Guo Yan Fei. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-345-FCAW-2G(2F)-FCM-REPAIR.

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



## Summary of Conversations:

No relevant conversations.

---

---

# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

---

## 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.

---

<b>Inspected By:</b>	Juvekar,Amit	Quality Assurance Inspector
----------------------	--------------	-----------------------------

---

<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer
---------------------	----------------	-------------