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 #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-016091
Date Inspected: 03-Aug-2010

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 645
OSM Departure Time: 1845
Location: Shanghai, China

CWI Name: Yang Bai Qian.

	Yes	No	N/A
Inspected CWI report:	☐	☑	☐
Electrode to specification:	☑	☐	☐
Qualified Welders:	☑	☐	☐
Approved Drawings:	☑	☐	☐

	Yes	No	N/A
CWI Present:	☑	☐	
Rod Oven in Use:	☐	☐	☑
Weld Procedures Followed:	☑	☐	☐
Verified Joint Fit-up:	☑	☐	☐
Approved WPS:	☑	☐	☐
Delayed / Cancelled:	☐	☑	☐

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 13BE-DP3090-001.

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:

DP3090-001: 21 tack weld location found compliant and 02 tack weld location found non-compliant.

Subassembly, Bay 04, 13CW, 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 DP3145-001. Repair carried out with Flux core arc welding (FCAW). Weld identified as DP3145-001-286. Approximate Y-locations of repair identified as 4250mm, 4850. 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.

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

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

FCAW Repair welding of partial penetration weld joints DP3100-001-234 (Y-Location 4650); located on subassembly, Bay 04, 13CE. Welder is identified as 062265; ZPMC Quality Control Inspector (QC) is identified as Yang Bai Qian. 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, 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 DP3132-001. The attached photographs provide additional detail.

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.

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