

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-016309**Date Inspected:** 20-Aug-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:****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:** Deck Panels, Floor beams**Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Christopher D'souza was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China. QA Inspector observed and/or found the following:

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This QA Inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested by ZPMC MT personnel. This QA Inspector generated a TL-6028 MT report on this date. The weld designation numbers is as follows:

FB3124 – 001 – 035~038

FB3166 – 001 – 041, 42, 43, 029, 030, 65, 66, 67, 68, 73, 74, 75, 76, 61, 62, 63, 64

Bay 9

This QA Inspector performed Ultrasonic Testing (UT) on approximately 10% of previously accepted by ZPMC ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3. The QA Inspector observed no rejectable indications at the time of testing. The QA Inspector generated a TL-6027 UT report on this date. Weld identification numbers were

DP 3162 – 001 – 258, 255, 210, 207, 052, 049, 060, 057, 114, 111, 106, 103, 076, 073, 186, 183, 178, 175, 234,

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DP 3176 – 001 – 059, 056, 051, 048, 101, 098, 093, 090, 151, 148, 159, 156, 210, 198, 235, 232

DP 3157 – 001 – 213, 210, 197, 194

QA inspector performed conventional Ultrasonic (UT) Inspection on deck panel tack weld areas. The inspection is preliminary prior to using the phased array (PAUT) testing system to verify indications found with conventional Ultrasonic testing. QA inspector performed UT on deck panel DP3171-001 having 10 ribs, 20 welds, and 320 total tack welds.

Weld 12 scanned 10 locations with 0 indications.

Weld 13 scanned 10 locations with 1 indication.

Weld 14 scanned 10 locations with 0 indications.

Weld 15 scanned 10 locations with 1 indication.

Weld 16 scanned 10 locations with 0 indications.

Weld 17 scanned 10 locations with 0 indications.

Weld 18 scanned 10 locations with 0 indications.

Weld 19 scanned 10 locations with 0 indications.

Weld 20 scanned 10 locations with 0 indications.

Tack weld locations found non-compliant are marked on U-rib and deck plate for ZPMC's reference for repair. See Caltrans U-rib to Deck Panel- Tack Weld Assessment sheets dated 20th August, 2010 for further information on PAUT inspections.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the 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 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Dsouza,Christopher	Quality Assurance Inspector
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Reviewed By:	Carreon,Albert	QA Reviewer
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