

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-016387**Date Inspected:** 24-Aug-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:** Tian Lei**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 14E-DP3167(PL3436A)-001.

This QA inspector performed conventional Ultrasonic Testing (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 DP3167(PL3436A)-001, 5 ribs, 10 welds, 208 total tack welds inspected.

Weld 1 scanned 23 locations with 2 indication.

Weld 2 scanned 23 locations with no indications.

Weld 3 scanned 23 locations with 3 indications.

Weld 4 scanned 23 locations with no indication.

Weld 5 scanned 12 locations with 1 indications.

Weld 6 scanned 12 locations with no indications.

Weld 7 scanned 23 locations with 2 indication.

Weld 8 scanned 23 locations with 1 indications.

Weld 9 scanned 23 locations with 1 indications.

Weld 10 scanned 23 locations with no indications.

Subassembly, Bay 04, Deck Panel 13BW-DP3137-001.

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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 second time 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:

DP3137-001: 2 tack weld location found compliant and no tack weld location found non-compliant.

Subassembly, Bay 04, 14E, Bottom Panel.

FCAW welding of weld joint BP3082-001-037; located at subassembly, Bay 04, 14E. Welder is identified as 214945; ZPMC Quality Control Inspector (QC) is identified as Tian Lei. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2231-B-U2-F.

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
