

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-002103**Date Inspected:** 24-Mar-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**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	

Summary of Items Observed:

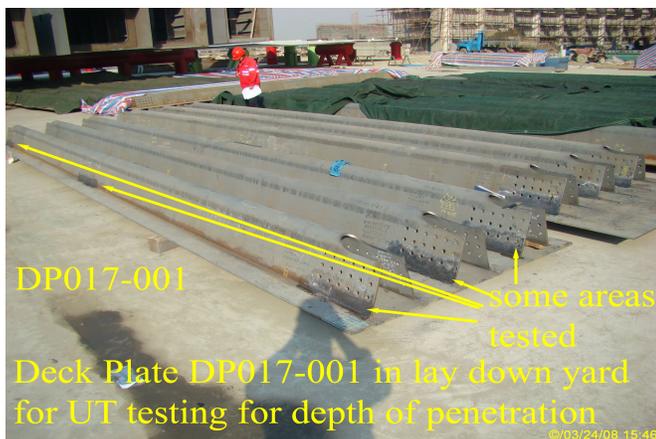
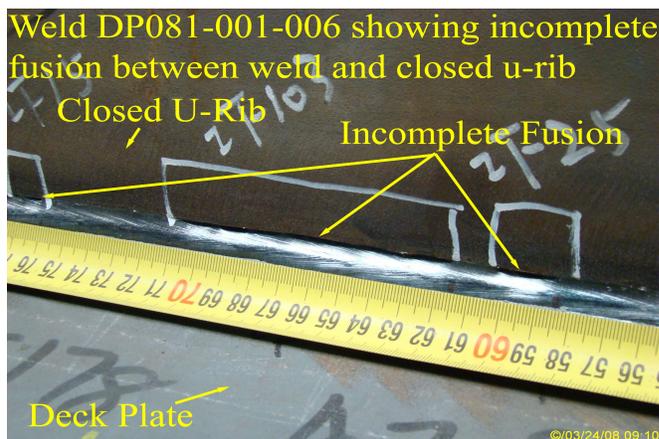
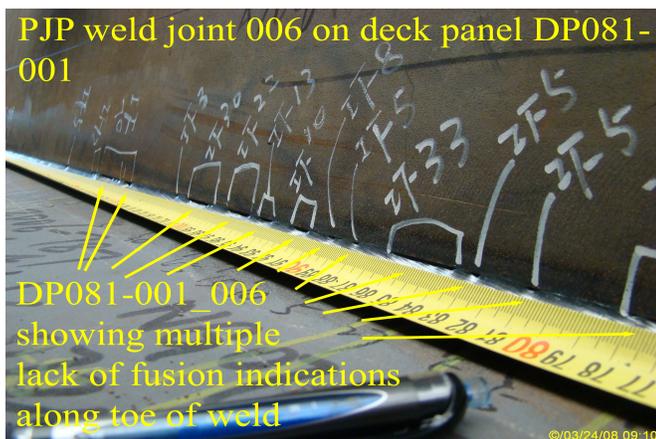
This Quality Assurance Inspector (QAI) performed visual testing (VT) of deck panel DP081-001 weld joints 004, 005 & 006 on u-ribs U89 & U27. The welds were 14970 millimeter long and weld 004 weld over lap (OL), under fill (UF) and lack of fusion (LOF). Weld joint 005 had OL, UF & LOF and weld 006 had UF & LOF. Results were reported on the Caltrans QA Visual Weld Inspection Report for the OBG Deck Panels with a copy being submitted to the Assistant Structural Materials Representative (ASMR) Ady Velasco.

The Production Monitoring Tests (PMT); PMT-1 on gantry 1 for deck plates DP079-001 & DP055-001 failed VT as did PMT-1 on gantry 2 for deck plates DP432-001 & DP054-001. This QAI performed ultrasonic testing for depth of penetration on the Production Monitoring Test (PMT) PMT-2 Gantry 1 DP079-001/DP055-001 and PMT-2 Gantry 2 DP432-001 & DP054-001. All welds appeared to be in compliance with the special provisions and agreement 602 received on March 21, 2008. For details of lack of fusion areas where less than 80% penetration was maintained see ultrasonic testing report TL-6027 modified dated March 24, 2008.

This QAI performed ultrasonic testing for depth of penetration on the deck panel DP017-001 welds 001 through 006 after the ZPMC Ultrasonic Testing Technicians completed testing. Coverage was 15% of each weld length which was 8556 millimeters in length. The 15% sections were broken into three separate areas along the weld lengths. Section one was 0 millimeter through 500 millimeters of Y and the second area was in the middle starting at Y location 4000 millimeters and finishing at 4600 millimeters. The third and final section concluded with starting at 8000 millimeters and ending at 8556 millimeters of the weld length. The 15% length of the entire weld equates out to 1283 millimeters. For details of lack of fusion areas where less than 80% penetration was maintained see ultrasonic testing report TL-6027 modified dated March 24, 2008.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)



Summary of Conversations:

No conversations held today.

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 Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Berger, Bruce

Quality Assurance Inspector

Reviewed By: Hager, Craig

QA Reviewer