

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-002104**Date Inspected:** 25-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 ultrasonic testing (UT) for depth of penetration on deck panel DP020-001 welds 001 through 006 after the Zhenhua Port Machinery Company (ZPMC) UT Technicians. Coverage was 15% of each weld length broken up in three separate areas, one at the beginning of the weld, one approximated mid weld and the final at the end of the weld. In DP020-001 a few lack of penetration (LOP) indication were observed showing penetration less than 80%. This QAI also completed Deck Panel DP016-001 finding several areas with depth of penetration less than 80% but greater than 70% in each of the 6 welds.

ZPMC QC ultrasonically tested deck plate DP405-001 with multiple findings of penetration less than 70%. On weld 001 there was a lack of penetration found measuring 5.26 millimeters. There were several indication measuring in excess of 4 millimeters and more measuring in excess of 3 millimeters. While most of these indication were found at the beginning of the welds there were some indications found at the far end of the weld as well. The center section of the welds exhibited a number of LOP indication in excess of 3.0 millimeters. This QAI ultrasonically tested several of the ZPMC indication and found them to appear to be in compliance with the ultrasonic testing procedure. QA did not UT test the welds further due to the severity of the LOP indication found by ZPMC. These observations were reported verbally to both the Task Leader and the Structural Materials Representative (SMR) Mr. Pat Lowery and Assistant SMR Mr. Ady Valesco.

This QAI took a rough quick count of the status of deck plates out in the yard. There are approximately 25 which Quality Control (QC) has performed ultrasonic testing for depth of penetration of which only two appear to have been tested by QA. There are approximately another 45 in the yard which do not appear to have been tested or prepared for ultrasonic testing.

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This QAI performed ultrasonic testing for depth of penetration on the Production Monitoring Test (PMT) PMT-1 DP245-001/DP050-001. The overall testing passed with limited acceptable findings in weld joints 4 & 6. There was one area in each weld less than 25 millimeters in length that had penetration between 70% and 80%.



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
