

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-004128**Date Inspected:** 01-Oct-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 630**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:** OBG Deck Panel**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mike Hasler was present to observe the fitup, welding and related activities associated with the fabricating of Caltrans Orthotropic Box Girder (OBG) and Tower, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Item	Description	WBS	Dwg No.	Status
1	Deck Panel	NA	NA	QAUT

OBG

Assembly Building: Caltrans Quality Assurance (QA) inspector received notification from 2nd shift Task Leader to perform conventional ultrasonic test (UT), gate to gate inspection of tack welds joining u-rib to deck plate. The deck panel is identified as DP324-002. The UT inspection performed by the Caltrans QA inspector was preliminary UT inspection prior to using the phased array UT system to verify indications found by the conventional ultrasonic test. Caltrans QA inspector inspected deck panel DP324-002, welds 001, 002, 003, 004, 006, 007 and 008. With each weld consisted of twenty-six (26) tack welds. Caltrans QA inspector recorded Y-locations for indications found in the weld during the UT inspection for the following:

Deck Panel DP324-002

Weld 001; Observed weld indication at Y-location, 3080, 4300, 6770 and 12,880 millimeter mark.

Weld 002; Observed weld indication at Y-location, 660, 1270, 4900, and 8500 millimeter mark.

Weld 003; Observed weld indication at Y-location, 1900 and 6640 millimeter mark.

Weld 004; Observed weld indication at Y-location, 2515, 3645, 3670, 3700 and 9110 millimeter mark.

Weld 005; Observed weld indication at Y-location, 700 and 1905 millimeter mark.

Weld 006; Observed weld indication at Y-location, 90, 105, 740, 1240, 1830, 7925 and 9700 millimeter mark.

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Weld 007; Observed weld indication at Y-location, 1240, 1295, 1840, 1890 and 3050 millimeter mark.

Weld 008; Observed weld indications at Y-location, 80, 1255 and 1870 millimeter mark.

Caltrans QA inspector was informed by the task leader that a TL-6027 was not required at this time.

Caltrans QA inspectors, Larry Viars and Erik Prue assisted in the UT inspection of deck panel DP324-002. See Caltrans U-rib to Deck Panel-Tack Weld Assessment Record, dated 10-01-2008 for additional information. The following digital picture illustrates DP324-001 and Y-locations at weld 002 .



2	Deck Panel Deck Panel DP407-001	NA	NA	QAUT
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Caltrans QA inspector recorded Y-locations where indications were observed for deck panel DP407-001 welds, 001, 002, 003, 004, 005, 006, 007, 008, 009 and 010 for the following:

Weld 001; No indications observed.

Weld 002; No indications observed.

Weld 003; No indications observed.

Weld 004; No indications observed.

Weld 005; Observed weld indication at Y-location, 9365 millimeter mark.

Weld 006; Observed weld indication at Y-location, 9875 millimeter mark.

Weld 007; Observed weld indication at Y-location, 9320 millimeter mark.

Weld 008; No indications observed.

Weld 009; No indications observed.

Weld 010; Observed weld indication at Y-location, 4900, 6060, 6680 and 9890 millimeter mark.

Caltrans QA inspector Larry Viars performed the UT inspection of deck panel DP407-002. Caltrans QA inspector recorded the Y-locations for Mr. Viars. See Caltrans U-rib to Deck Panel-Tack Weld Assessment Record, dated 10-01-2008 for additional information.

Summary of Conversations:

As identified within the contents of this report.

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 Ady Velasco 138-1694-2685, who represents the Office of Structural Materials for your project.

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Inspected By:	Hasler, Mike	Quality Assurance Inspector
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Reviewed By:	Cuellar, Robert	QA Reviewer
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