

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-004350**Date Inspected:** 12-Oct-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1430**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2230**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Yang**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:**

Summary of Items Observed: Caltrans Quality Assurance (QA) Inspector, Larry Viars was present to perform Ultrasonic Testing (UT) of Orthotropic Box Girder (OBG) and Tower components, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

OBG Assembly Bay # 2

This Quality Assurance (QA) inspector arrived at ZPMC in Shanghai China for observation of Orthotropic Bridge Girders (OBG) and Self Anchored Suspension (SAS) Bridge. This QA inspector received notification from day shift task leader to perform conventional Ultrasonic (A scan) Inspection for tack welds on deck panels. The inspection is preliminary prior to using the phased array system to verify indications found with conventional Ultrasonic testing. This QA inspector performed UT on deck panel DP378-001, weld 1 scanned 26 locations with 6 indications, weld 2 scanned 26 locations with 8 indications, weld 3 scanned 26 locations with 5 indications, weld 4 scanned 26 locations with 6 indications, weld 5 scanned 26 locations with 9 indications, weld 6 scanned 26 locations with 8 indications, weld 7 scanned 26 locations with 7 indications. Total tack welds inspected were 182 with 49 indications located in the area of interest (26.9 %). This QA inspector was informed by the task leader that a TL-6027 was not required at this time.

Green Tagging: This QA inspector along with ZPMC and ABF personnel signed ABF green tag documentation for Tower Skin Plate to stiffener welds only for component SSD1-Skin B after Caltrans QA VT, MT and UT verification. The documentation was signed with a note that up to 1 mm of undercut was used for the visual

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

acceptance criteria as per AWS D1.5 (2002) 6.26.1.5.

Heavy Tower Bay 1:

Caltrans QA Inspector performed UT verification of ZPMC tested and accepted longitudinal stiffener weld SSD1-SA178 A/D 15. No relevant indications were noted.

No other activities observed.

Summary of Conversations:

Only general conversations between Caltrans QA and QC occurred this date.

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 Peter Dautermann 150 0219 9593, who represents the Office of Structural Materials for your project.

Inspected By:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	Wright,Mark	QA Reviewer
