

**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-004381**Date Inspected:** 24-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

<b>CWI Name:</b>	N/A	<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes No N/A	<b>Rod Oven in Use:</b>	Yes No N/A	
<b>Electrode to specification:</b>	Yes No N/A	<b>Weld Procedures Followed:</b>	Yes No N/A	
<b>Qualified Welders:</b>	Yes No N/A	<b>Verified Joint Fit-up:</b>	Yes No N/A	
<b>Approved Drawings:</b>	Yes No N/A	<b>Approved WPS:</b>	Yes No N/A	
		<b>Delayed / Cancelled:</b>	Yes No N/A	
<b>Bridge No:</b>	34-0006	<b>Component:</b>	OBG	

**Summary of Items Observed:**

On this day CALTRANS Quality Assurance Inspector (QA) Larry Viars was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

OBG bay1

QA performed Phased Array Ultrasonic Testing (PAUT) after ZPMC performed repairs of Deck panel U-rib repairs in the tacked areas of the Partial Joint Penetration (PJP) welds joining u-ribs to deck plates. This QA inspector performed 100 % PAUT in the areas of repair. This QA inspector recorded the following results after PAUT Testing

DP405-001: Repair (PAUT)

Weld# 3 – 1 tack PAUT'ed – 0 indications verified

Weld# 5– 1 tack PAUT'ed – 0 indications verified

DP042-002: Repair (PAUT)

Weld# 1 – 4 tacks PAUT'ed – 1 indications verified @ Y location 6310 (R1)

Weld# 2 – 4 tacks PAUT'ed – 0 indications verified

Weld# 3 – 1 tack PAUT'ed – 0 indications verified

Weld# 5 – 1 tack PAUT'ed – 0 indications verified

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Weld# 6 – 2 tacks PAUT’ed – 1 indications verified

Weld# 7 – 2 tacks PAUT’ed – 0 indications verified

Weld# 8 – 2 tacks PAUT’ed – 0 indications verified

DP378-001: Repair (PAUT)

Weld# 2 – 1 tacks PAUT’ed – I indications verified @ Y location 11420 (R2)

Weld# 4 – 2 tacks PAUT’ed – 0 indications verified

Weld# 5 – 2 tacks PAUT’ed – 0 indications verified

Weld# 6 – 1 tack PAUT’ed – 0 indications verified

Weld# 7 – 3 tack PAUT’ed – 0 indications verified

Weld# 8 – 2 tack PAUT’ed – 0 indications verified

NOTE: 2 Deck Panels were purchased by Caltrans for testing and initial UT and PAUT procedural development purposes. At this time no written PAUT procedure has been issued. However, all the test samples identified with the PAUT method as crack indications were confirmed after macro-etching and magnetic particle testing.

No other observations were made in this bay tonight.

**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.

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<b>Inspected By:</b>	Viars,Larry	Quality Assurance Inspector
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<b>Reviewed By:</b>	Wright,Mark	QA Reviewer
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