

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-004399**Date Inspected:** 28-Oct-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**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:

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

OBG Assembly:

QA UT Inspector performed initial Phased Array Ultrasonic Testing (PAUT) in the marked tack weld areas of the u-rib to deck plate Partial Joint Penetration (PJP) welds after the conventional Ultrasonic Testing (UT) of tack welds. QA UT inspector performed PAUT on the following deck panels:

DP-459-001

Weld# 5 – 4 tacks PAUT'ed – 1 indication non-compliant.

Weld# 6 – 4 tacks PAUT'ed – 2 indications non-compliant.

Weld# 7 – 8 tacks PAUT'ed – 4 indications non-compliant.

Weld# 8 – 5 tacks PAUT'ed – 2 indications non-compliant.

Weld# 9 – 1 tacks PAUT'ed – 0 indications non-compliant.

Weld# 10 – 2 tacks PAUT'ed – 0 indications non-compliant.

MPI PAUT personnel inspected welds 1, 2, 3, 4, and a portion of weld 5. Please see U-rib to deck panel tack weld assessment sheet dated 28 October, 2008 for specific information on PAUT inspection.

DP-556-001

Weld# 1 – 1 tacks PAUT'ed – 0 indications non-compliant.

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Weld# 2 – 0 tacks PAUT’ed – 0 indications non-compliant.

Weld# 3 – 3 tacks PAUT’ed – 2 indications non-compliant.

Weld# 4 – 3 tacks PAUT’ed – 1 indication non-compliant.

Weld# 5 – 2 tacks PAUT’ed – 0 indications non-compliant.

Weld# 6 – 1 tacks PAUT’ed – 1 indication non-compliant.

Weld# 7 – 2 tacks PAUT’ed – 1 indication non-compliant.

Weld# 8 – 4 tacks PAUT’ed – 0 indications non-compliant.

Weld# 9 – 3 tacks PAUT’ed – 0 indications non-compliant.

Weld# 10 – 2 tacks PAUT’ed – 1 indication non-compliant.

MPI PAUT personnel inspected welds portions of welds 6 through 10. Please see U-rib to deck panel tack weld assessment sheet dated 28 October, 2008 for specific information on PAUT inspection.

No other activities observed.

Summary of Conversations:

No significant conversations this day.

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 Dauterman, 15002199593, who represents the Office of Structural Materials for your project.

Inspected By:	Prue,Erik	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
