

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-005592**Date Inspected:** 25-Feb-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**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 & Tower	

Summary of Items Observed:

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector Larry Viars was present during the times noted above for observations relative to the work being performed.

OBG Blast and Paint Station-

Caltrans QA performed final visual inspection of Orthotropis Box Girder section 3BE upper section (deck panel and top of side plates) along with ZPMC and ABF QC personnel. Several areas of nonconformance were noted to include but not limited to porosity, overlap, weld spatter and cold lap. ZPMC attempted to grind areas that could be repaired without welding. After the third repair attempt ZPMC requested that QA inspector place tape on areas that required repair so they could proceed with painting.

Bay 10-

This QA inspector performed Ultrasonic Testing (UT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as Double Diaphragm welds. The weld identification numbers are as follows, SD1-SA183-33M-2-1A/B and ND1-SA183-43M-4-1A/B.

Bay 12-

This QA inspector performed Ultrasonic Testing (UT) of approximately 15% of the area previously tested and

WELDING INSPECTION REPORT

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accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as Deck Panel welds. The weld identification numbers are as follows, DP545-001-020, 021, 022, DP590-001-060, 078 and 087.

QA inspector observed the backing bar had been removed from U-rib weld and repair was performed from the interior of the U-rib on DP545-001-019. The interior of the weld was visually unacceptable with excessive reinforcement and cold lap observed. ZPMC did not have a posted welding procedure for this repair. The above mentioned information was passed on to day shift. Please see the attached photo below of DP545-001-019. No ZPMC certified welding inspector was present as there were no welding being performed. This information was passed on to ZPMC QC Lei Tao.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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 Eric Tsang 150 0042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
