

**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-006009**Date Inspected:** 30-Mar-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**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 OSM Quality Assurance (QA) Inspector Erik Prue 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 Inspector observed and/or found the following:

Caltrans 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 Deck Panel DP273-001. Welds 1 through 6 were UT tested and Eighteen (18) tack weld areas were found non-compliant. Areas are marked for ZPMC repair. Please see U-rib to deck panel tack weld assessment sheet dated 30 March, 2009 for specific information on PAUT inspection.

Caltrans QA Inspector performed PAUT of weld repaired tack welds on following deck panels:  
DP411-001 Ten (10) tack weld locations found compliant and Four (4) tack weld locations found non-compliant.  
DP111-002 One (1) tack weld location found non-compliant.  
Tack weld locations found non-compliant are marked on U-rib and deck plate for ZPMC's reference for repair. See Caltrans U-rib to Deck Panel- Tack Weld Assessment sheets dated 30 March, 2009 for further information on PAUT inspections.

Unless otherwise noted, all work observed on this date appears to be in general compliance with the applicable contract documents.

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# WELDING INSPECTION REPORT

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**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 Eric Tsang, 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Prue,Erik	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer

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