

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-006350**Date Inspected:** 09-Apr-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

CWI Name:	Li Jia			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:

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:

Bay 9: QA Inspector observed welding utilizing the dual process Flux Core Arc Welding (FCAW) and Submerged Arc Welding (SAW) WPS-B-T-2342-U1 (U-rib)-4 welding procedure specification for welding of the Deck Panel 132-001 on closed U-rib Partial Joint Penetration (PJP) welds. ZPMC welding personnel performed Gantry Machine GMAW for the root pass and SAW for the cover/final pass on deck panel. QA Inspector observed the QC CWI Inspector Li Jia verifying welding parameters and pre-heat were in accordance with the Welding Procedure Specification (WPS). QA Inspector with QC Inspector observed parameters taken utilizing the SAW process for welders # 059443, 059421, 059378, 062265, 059416, 059403 as follows: preheat temperature to be at 24°C and measured the welding parameters to be 690 amps, 25.6 volts, a travel speed of 512 mm/min. Welding parameters verified by QA Inspector appear to be in general compliance with the approved WPS.

QA inspector performed conventional Ultrasonic (UT) Inspection on deck panel tack weld areas. The inspection is preliminary prior to using the phased array (PAUT) testing system to verify indications found with conventional Ultrasonic testing. QA inspector performed UT on deck panel DP349-001, 4 ribs, 8 welds, 224 total tack welds inspected.

Weld 1 scanned 28 locations with 0 indications.

Weld 2 scanned 28 locations with 0 indications.

Weld 3 scanned 28 locations with 0 indications.

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Weld 4 scanned 28 locations with 0 indications.

Weld 5 scanned 28 locations with 0 indications.

Weld 6 scanned 28 locations with 7 indications.

Weld 7 scanned 28 locations with 0 indications.

Weld 8 scanned 28 locations with 0 indications.

All indications are marked on top of u-ribs for further inspection by PAUT. Please see U-rib Deck Panel Tack Weld Assessment sheet dated 09 April, 2009 for specific locations of indications.

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

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.

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