

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-006393**Date Inspected:** 09-Apr-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	

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.

Bay 12-

This QA Inspector performed Phased Array Ultrasonic Testing (PAUT) of OBG deck panel u-rib Partial Joint Penetration (PJP) welds at tack weld locations. Caltrans NDT personnel performed conventional ultrasonic testing of tack welds. Tack weld locations that exhibited crack like indications in the area of interest were marked and recorded prior to PAUT. PAUT was performed in accordance with Caltrans UT procedure "Phased Array Testing for detection of planar discontinuities (cracks) in PJP welds. Results of Deck Panels evaluated are as follows:

DP390-001 (8BE) : 35 locations tested with 26 locations rejected.

This QA Inspector performed Phased Array Ultrasonic Testing (PAUT) of OBG deck panel u-rib Partial Joint Penetration (PJP) welds at tack weld locations after weld repair. Testing was performed in accordance with Caltrans UT procedure "Phased Array Testing for detection of planar discontinuities (cracks) in PJP welds. Results of Deck Panels evaluated are as follows:

DP359-001 (7CE): 1 locations tested with 1 rejected (R4).

DP386-001 (7CE): 4 locations tested with 3 rejected (R3 & R4).

DP384-001 (7AE): 1 location tested with 1 rejected (R7).

DP467-001 (7CE): 1 location tested with 1 rejected (R6).

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

This QA inspector performed Magnetic Particle Testing (MT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member is identified as BK004A6-002, BK004A5-002, BK004A4-002, BK004A7-002, BK004A8-002 and BK004A3-002. The weld identification numbers are BK004A6-002-030, 064, BK004-A5-002-016, 017, 022, 023, 037, 042, 043, BK004A4-002-003, BK004A7-002-183, 198, BK004A8-002-041, 042, 047 and BK004A3-002-026, 051, 052.

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

Summary of Conversations:

Only general conversations between QC and QA 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 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
---------------------	----------------	-------------