

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-006447**Date Inspected:** 24-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:	NA	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 Deck Panel	

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector, D.Sukanthan and Stefen Holmes was present during the time noted above for observations relative to the work being performed.

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 DP512-001, 3 ribs, 06 welds, 114 total tack welds inspected.

Weld 1 scanned 19 locations with 6 indications.

Weld 2 scanned 19 locations with 2 indications.

Weld 3 scanned 19 locations with 1 indication.

Weld 4 scanned 19 locations with 8 indications.

Weld 5 scanned 19 locations with 4 indications.

Weld 6 scanned 19 locations with 6 indications.

QA inspector performed conventional Ultrasonic (UT) Inspection on deck panel tack weld areas. The inspection is

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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 DP394-001, 5 ribs, 10 welds, 280 total tack welds inspected.

Weld 1 scanned 28 locations with 1 indication.

Weld 2 scanned 28 locations with 6 indications.

Weld 3 scanned 28 locations with 7 indications.

Weld 4 scanned 28 locations with 8 indications.

Weld 5 scanned 28 locations with 1 indication.

Weld 6 scanned 28 locations with 0 indications.

Weld 7 scanned 28 locations with 2 indications.

Weld 8 scanned 28 locations with 3 indications.

Weld 9 scanned 28 locations with 8 indications.

Weld 10 scanned 28 locations with 3 indications.

All indications for further inspection by PAUT are marked on top of u-ribs. Please see U-rib Deck Panel Tack Weld Assessment sheet dated 24 April, 2009 for specific locations of indications.

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

Summary of Conversations:

No Relevant Conversation

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:	Sukanthan,Dhanasingh	Quality Assurance Inspector
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Reviewed By:	Clifford,William	QA Reviewer
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