

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-007978**Date Inspected:** 05-Jul-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:** SUN BO**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 COMPONENT**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance(QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

Ultrasonic Testing(Gate To Gate)

The QA Inspector performed, gate to gate Ultrasonic Testing (UT) on Orthotropic Box Girder deck plates to closed rib welds at the tack weld locations. The QA Inspector generated a field inspection UT report on this date designating areas of rejectable indications. Panel identification number are DP-129-002 and DP-453-001.

The Y locations of indication for the panel were marked and recorded as:

DP-129-002(10CW)

Total Number of Ribs -04

Total Number of Tack Welds -224

Total Number of Tack Welds Scanned -224

Weld 01: Tack Welds Scanned - 28, Indication Observed - 01

Weld 02: Tack Welds Scanned - 28, Indication Observed - 04

Weld 03: Tack Welds Scanned - 28, Indication Observed - 03

Weld 04: Tack Welds Scanned - 28, Indication Observed - 02

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Weld 05: No Indication
Weld 06: Tack Welds Scanned - 28, Indication Observed - 02
Weld 07: Tack Welds Scanned - 28, Indication Observed - 02
Weld 08: Tack Welds Scanned - 28, Indication Observed - 03

DP-453-001(10CE)

Total Number of Ribs -05
Total Number of Tack Welds -280
Total Number of Tack Welds Scanned -280

Weld 01: Tack Welds Scanned - 28, Indication Observed - 06
Weld 02: Tack Welds Scanned - 28, Indication Observed - 02
Weld 03: Tack Welds Scanned - 28, Indication Observed - 02
Weld 04: Tack Welds Scanned - 28, Indication Observed - 01
Weld 05: Tack Welds Scanned - 28, Indication Observed - 01
Weld 06: Tack Welds Scanned - 28, Indication Observed - 02
Weld 07: Tack Welds Scanned - 28, Indication Observed - 03
Weld 08: No Indication
Weld 09: Tack Welds Scanned - 28, Indication Observed - 02
Weld 10: Tack Welds Scanned - 28, Indication Observed - 14

Ultrasonic Testing(Phased Array)

The QA Inspector performed Phased Array Ultrasonic Testing (UT) on Orthotropic Box Girder deck plates to closed rib welds at the tack weld locations (marked for crack confirmation) which one previously tested by Caltrans QA personnel. The QA Inspector generated a field inspection UT report on this date designating areas of rejectable indications.

Panel identification number is

DP-129-002(10CW)
DP-453-001(10CE)

Magnetic Particle Testing

This Quality Assurance Inspector (QA) performed 15% verification Magnetic Particle Testing (MT) for Deck Panel. This QA Inspector generated a MT report for this date. This weld was previously tested and accepted by ZPMC QC MT technicians.

The weld designations reviewed are as follows:

Deck Panel No. Weld No.

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DP-372-001	W1,W2,W3
DP-153-001	W2,W3,W4
DP-399-001	W1,W2,W3
DP-262-001	W2,W3,W4
DP-424-001	W1,W2,W3
DP-478-001	W4,W5,W6
DP-154-001	W1,W2,W3
DP-397-001	W3,W4,W5
DP-176-001	W1,W3,W4

Visual Inspection For Green Tagging

This QA inspector performed a random Visual Inspection of the OBG deck panel U-rib welds that were previously accepted by ZPMC Quality Control personnel and ABF QA personnel.

The member(s) are identified as

Deck Panel No.	Green Tagging No.
DP-372-001	9235
DP-153-001	9232
DP-399-001	9726
DP-262-001	9727
DP-424-001	9234
DP-478-001	9237
DP-154-001	9236
DP-397-001	9233
DP-176-001	9725

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

Summary of Conversations:

No relevant conversations

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:	Bera,Subhasis	Quality Assurance Inspector
Reviewed By:	Prue,Erik	QA Reviewer
