

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-010337**Date Inspected:** 29-Oct-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:	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 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 is DP-3042-001.

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

DP-3042-001(12BW)

Total Number of Ribs -05

Total Number of Tack Welds -310

Total Number of Tack Welds Scanned -310

Weld 11: Tack Welds Scanned - 31, Indication Observed - 06

Weld 12: Tack Welds Scanned - 31, Indication Observed - 04

Weld 13: Tack Welds Scanned - 31, Indication Observed - 04

Weld 14: Tack Welds Scanned - 31, Indication Observed - 05

Weld 15: Tack Welds Scanned - 31, Indication Observed - 05

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Weld 16: Tack Welds Scanned - 31, Indication Observed – 04
Weld 17: Tack Welds Scanned – 31, Indication Observed – 10
Weld 18: Tack Welds Scanned – 31, Indication Observed – 01
Weld 19: No Indication
Weld 20: Tack Welds Scanned – 31, Indication Observed – 01

Ultrasonic Testing(Phased Array)

The QA Inspector performed Phased Array Ultrasonic Testing (PAUT) on Orthotropic Box Girder deck plates to closed rib welds at the tack weld locations (marked for crack confirmation) which were 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-404-001(11EE)
DP-269-001(11EW)
DP-377-001(11EE)
DP-215-001(11EW)
DP-242-001(11EW)
DP-134-001(11EW)

Trial Assembly Yard

Ultrasonic Testing(UT)

This QA Inspector performed 10% Ultrasonic testing Verification of the repair area previously tested and accepted by ZPMC and ABF Quality control personnel. This QA inspector generated a (UT) report for this date. The member is identified as OBG Segment OBG Segment 2AE to 2BE at Bottom Panel .

The Weld Designation is as follow

OBW2A-004

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:	Patterson,Rodney	QA Reviewer
