

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-010341**Date Inspected:** 27-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.

Out Side Segment Yard Area

This QA inspector was instructed by task leaders to carry out Ultrasonic testing (UT) utilizing scanning pattern 'D' for detecting transverse Indications at corner joint between Edge Panel to Deck Panel for OBG Segment 6CW at work point W2. The indications found on this date were recorded onto a data sheet that Caltrans QA Inspector have filled out.

The Weld Designation is as follows

CA-029-004(6CW)

Ultrasonic Testing (UT)

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as Corner joint between side panel and bottom panel splice weld at segment 11AW.

The Weld Designation is as follows

SEG-065A-004

WELDING INSPECTION REPORT

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This Quality Assurance Inspector (QA) performed Ultrasonic Testing (UT) verification utilizing scanning pattern 'D' on weld joints identified as CA-0029-004 for OBG segment 6CW, of the Edge plate to Deck Plate corner joint at work point W2. This QA Inspector discovered One class "A" rejectable Transverse indication measuring approximately 13 mm in length.

This weld was previously tested and accepted by ZPMC QC UT technicians although scanning pattern 'D' was not utilized.

The Y locations of the one Class "A" rejectable Transverse indications at weld is as follow; Ind. #1 =1182 mm.

The Y locations was taken from PP-47 side to PP-44 longitudinal weld seam .

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
