

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-010731**Date Inspected:** 05-Dec-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:** Li Yang**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(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 numbers are

DP-3004-001(12AE)

DP-3048-001(12AW)

Trial Assembly area In process Inspection

SMAW in the 4G position of the OBG segment 4AW at bottom plate to side plate corner joint, weld No. SEG-017A-007. The welder is identified as #054467. ZPMC QC is identified as Mr. Shen Jian Bo. The welding variables recorded by QC appear to comply with WPS- 345-SMAW-4G(4F)-REPAIR-1 and repair procedure B-CWR904-Rev.4.

SMAW in the 1G position of the splice joint between OBG segment 5AE to 5BE at deck plate to deck plate, weld

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No. OBE5-004. The welder is identified as #037743. ZPMC QC is identified as Mr.Zhang Xiao Ming. The welding variables recorded by QC appear to comply with WPS- 345-SMAW-1G(1F)-REPAIR-1 and repair procedure B-WR8585.

SMAW in the 1G position of the splice joint between OBG segment 5CE to 5BE at deck plate to deck plate, weld No. OBE5-009. The welder is identified as #037743. ZPMC QC is identified as Mr.Zhang Xiao Ming. The welding variables recorded by QC appear to comply with WPS- 345-SMAW-1G(1F)-REPAIR-1 and repair procedure B-WR8821.

SMAW in the 3G position of the splice joint between OBG segment 5CE to 5BE at side plate to side plate, weld No. OBE5A-009. The welder is identified as #037743. ZPMC QC is identified as Mr.Zhang Xiao Ming. The welding variables recorded by QC appear to comply with WPS- 345-SMAW-3G(3F)-REPAIR-1 and repair procedure B-WR8817.

The Quality Assurance Inspector observed during random visual inspection the ZPMC personnel cut the drip plate length 1600mm at OBG Segment 1BW (both side at Y =1000mm from splice joint 1AW to 1BW).

For details please see the attached photo.

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

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Reviewed By: Patterson,Rodney

QA Reviewer