

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-011033**Date Inspected:** 08-Nov-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:****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 day Caltrans OSM Quality Assurance (QA) Inspector Daniel Barrentine was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China. QA Inspector observed and/or found the following:

QA Inspector performed Phased Array Ultrasonic Testing (PAUT) following the guide lines of UT procedure titled "Phased Array Ultrasonic Testing for the Detection and Sizing of Suspected Planar Discontinuities (Cracks) in PJP Welds, # UT 04-0120F4 PJP Rib Weld" after ZPMC welding personnel performed weld repairs of tacked areas of the Partial Joint Penetration (PJP) welds joining u-ribs to deck plate. The deck panels examined are as follows:

DP3054-001- 1 tack weld location found compliant and 0 tack weld locations found non-compliant.
DP3017-001- 1 tack weld location found compliant and 0 tack weld locations found non-compliant.
DP3026-001- 0 tack weld locations found compliant and 1 tack weld location found non-compliant.
DP3029-001- 0 tack weld locations found compliant and 1 tack weld location found non-compliant.
DP3030-001- 1 tack weld location found compliant and 0 tack weld locations found non-compliant.
DP3055-001- 2 tack weld locations found compliant and 0 tack weld locations found non-compliant.
DP3066-001- 2 tack weld locations found compliant and 0 tack weld locations found non-compliant.
DP3068-001- 1 tack weld location found compliant and 0 tack weld locations found non-compliant.

Tack weld locations found non-compliant are marked on U-Rib and Deck Plate for ZPMC's reference for repair.

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See Caltrans U-rib to Deck Panel- Tack Weld Assessment sheets dated 8th November, 2009 for further information on PAUT inspections.

On this date QA Inspector Daniel Barrentine was given ZPMC NDT Inspection Notification Sheet, Document Nos. 004545. This QA Inspector performed required Final Magnetic Particle and Visual Testing (MT/ VT) of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel, on the following items listed for final acceptance, (green tag), of the OBG sub-assemblies in trial assembly yard:

DP 214-001- 10% Final MT/ VT Acceptable, Green Tag # 009497

DP 377-001- 10% Final MT/ VT Acceptable, Green Tag # 009499

DP 269-001- 10% Final MT/ VT Acceptable, Green Tag # 009498

On this date QA Inspector Daniel Barrentine performed in-process inspections on the repair/welding of U-Rib to Deck Panel welds in the OBG trial assembly yard, in accordance with WPS-B-T-2233-TC-U4b-F.

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 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Barrentine,Daniel	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
