

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-011200**Date Inspected:** 27-May-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

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|------------------------------------|---------|----|-----|----------------------------------|-----------------|----|-----|
| 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 Deck Panels | | |

Summary of Items Observed:

On this day Caltrans OSM Quality Assurance (QA) Inspector Stefan Holmes 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 performed conventional Ultrasonic Testing (UT) Inspection on deck panel tack weld areas. The inspection is preliminary prior to using the phased array ultrasonic (PAUT) testing system to verify indications found with conventional Ultrasonic testing. Deck Panels inspected and results are as follows:

DP149-001, 5 ribs, 10 welds, 190 total tack welds inspected.

Weld 1 scanned 19 locations with 4 indications.

Weld 2 scanned 19 locations with 4 indications.

Weld 3 scanned 19 locations with 1 indication.

Weld 4 scanned 19 locations with 1 indication.

Weld 5 scanned 19 locations with 1 indication.

Weld 6 scanned 19 locations with 4 indications.

Weld 7 scanned 19 locations with 14 indications.

Weld 8 scanned 19 locations with 12 indications.

Weld 9 scanned 19 locations with 12 indications.

Weld 10 scanned 19 locations with 10 indications.

DP122-001, 4 ribs, 8 welds, 152 total tack welds inspected.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Weld 1 scanned 19 locations with 3 indications.
Weld 2 scanned 19 locations with 3 indications.
Weld 3 scanned 19 locations with 4 indications.
Weld 4 scanned 19 locations with 6 indications.
Weld 5 scanned 19 locations with 3 indications.
Weld 6 scanned 19 locations with 4 indications.
Weld 7 scanned 19 locations with 3 indications.
Weld 8 scanned 19 locations with 11 indications.

DP176-001, 5 ribs, 10 welds, 190 total tack welds inspected.

Weld 1 scanned 19 locations with 0 indications.
Weld 2 scanned 19 locations with 1 indication.
Weld 3 scanned 19 locations with 0 indications.
Weld 4 scanned 19 locations with 0 indications.
Weld 5 scanned 19 locations with 1 indication.
Weld 6 scanned 19 locations with 3 indications.
Weld 7 scanned 19 locations with 1 indication.
Weld 8 scanned 19 locations with 1 indication.
Weld 9 scanned 19 locations with 3 indications.
Weld 10 scanned 19 locations with 3 indications.

All indications for further inspection by PAUT are marked on top of u-ribs. Please see U-rib Deck Panel Tack Weld Assessment sheet dated 09 April, 2009 for specific locations of indications.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the 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 , who represents the Office of Structural Materials for your project.

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| Inspected By: | Holmes,Stefan | Quality Assurance Inspector |
| Reviewed By: | Hall,Steven | QA Reviewer |
