

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-011629**Date Inspected:** 12-Jan-2010**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 (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 OBG Segment 8CW.

The Weld Designations are as follows

SEG047H-142 and 145
SEG047H-151 and 154
SEG047H-160 and 163
SEG047H-169 and 172
SSD22-PP69.5-131

During the Quality Assurance Ultrasonic Testing (UT) review of welds located on Orthotropic Box Girder (OBG) segment 8CW, this Quality Assurance Inspector (QA) discovered that One (1) longitudinal linear indication measuring approximately 12mm in length. The indication dbS rating is a +8. Material thickness is 12mm. The depth of the indication is approximately 8mm. The weld is identified as SSD22-PP69.5-129. The weld is

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designated as Non Seismic Performance Critical Material. The indication is clearly marked on or near the weld. The Y distance for this indication is '0'. The weld is a Complete Joint Penetration (CJP) "T" joint joining Corner Assembly Web Plate X36D (Non SPCM) to Deck Plate "I" stiffener (Non SPCM).

This QA Inspector generated an incident report for this date.

Magnetic Particle Testing(MPT)

This Quality Insurance Inspector (QA) performed 15% verification Magnetic Particle Testing (MT) for OBG segment 8BE after repair ,welds area. This weld was previously tested and accepted by ZPMC QC MT technicians.

The weld designations reviewed are as follows:

SEG047D-039 and 038
SEG047D-002 and 003
SEG047D-021 and 016
SEG047D-014 and 019
SSD10-PP68-098,100 and 102
SSD10-PP68-040,042 and 044
SSD22-PP68.5-039,041 and 043
SSD11-PP69-097,099 and 101
SSD11-PP69-039,041 and 043

During the Quality Assurance Magnetic Particle Testing (MT) review of welds located on Segment 8CW, this Quality Assurance Inspector (QA) discovered that One (1) Longitudinal linear indication measuring approximately 18mm in length. The Y location is 0mm from the Panel Point PP68.The indication is clearly marked on the material near the weld. The weld is identified as: SEG047D-001. The weld is located at PP68 (Counter Weight Side). This weld is a Complete Joint Penetration (CJP) Weld joining the Longitudinal Diaphragm (LD13A) to Floor Beam (FB11C). The plate number for LD13A is identified as X43N (Non SPCM). And the plate number for FB11C is Identified as X47C(SPCM). This weld is designated as Seismic Performance Critical Member (SPCM). OBG segment 8CW is located outside in west of Blast Shop area.

This QA Inspector generated an incident report for this date.

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.

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Inspected By:	Bera,Subhasis	Quality Assurance Inspector
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Reviewed By:	Patterson,Rodney	QA Reviewer
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