

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-013653**Date Inspected:** 15-Apr-2010**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:** Gang Wai**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) for 9DE

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 Segment 9DE.

The Weld Designations are as follows

SEG056*-045,007,073

SEG056A-017,016,018,025,019,038,041,037

SEG056B-004,034,055

SSD17-PP81-146,138,004,010,013,008

SSD18-PP82-005,140,150

SEG056E-070,073,079,082,124,127,133,136

CA066-003,004

SP586-083,084,085

SP587-039,040,041

EP148-021,022

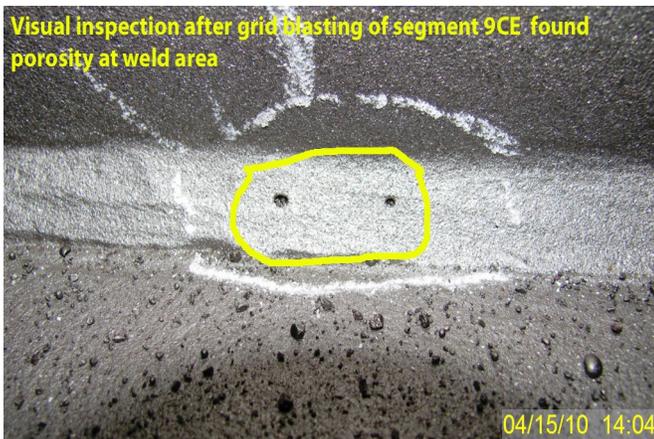
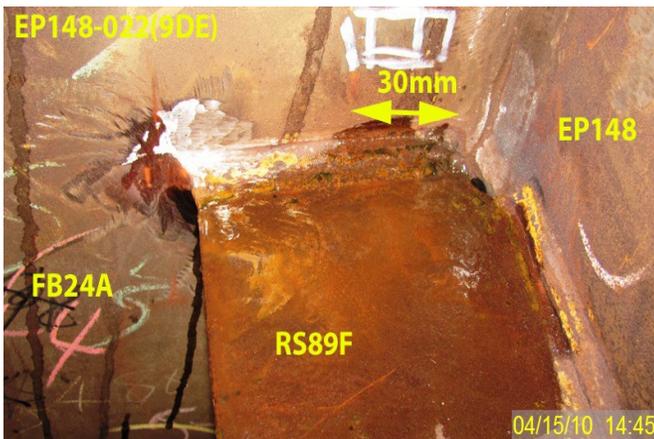
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During the Quality Assurance Ultrasonic Testing (UT) review of welds located on Orthotropic Box Girder (OBG) segment 9DE, this Quality Assurance Inspector (QA) discovered the following issues that two (2) longitudinal linear indications measuring approximately 310mm and 30mm in length. The indications dbb rating are +6 and +4. Material thickness is 18mm. The depths of the indications are approximately 11mm and 13mm. The welds are identified as SEG056*-045 at Panel Point PP81.5 and EP148-022 at PP 81. The welds are designated as Seismic Performance Critical Material (SPCM). The indication is clearly marked on or near the weld. The Y distance for the indications are 50 mm from PPP81.5 and 0 mm from EP148A. The weld SEG056*-045 is a Complete Joint Penetration (CJP) Corner joint joining Edge Plate PL1336C (SPCM) to Deck Plate PL1314A (Non SPCM). And the weld EP148-022 is a Complete Joint Penetration (CJP) "T" joint joining Edge Plate stiffener RS89F (Non SPCM) to FB24A plate PLX24D (SPCM). Segment 9DE is located at outside of paint Shop. The Notice of Witness Inspection (NWIT) No. is 005523. The indication is located in an area previously tested and accepted by ZPMC Quality Control (QC) personnel. As per the contract documents, ZPMC's QC personnel are required to perform hundred (100%) percent UT inspection of this weld.

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.



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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
