

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-013660**Date Inspected:** 21-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:	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.

Magnetic Particle Testing (MPT)

This Quality Assurance (QA) Inspector performed Visual inspection and verification of Magnetic Particle Testing (MT) 15% for Tower 13M Exterior Diaphragm. This QA inspector generated a (MT) report for this date. This weld was previously tested and accepted by ZPMC QC MT technicians.

The weld designations reviewed are as follows:

WD1-A1-4, 5, 54, 55

Green Tagging

This QA inspector performed Visual Inspection for Green Tagging which were previously tested and accepted by ZPMC Quality Control personnel and ABF QA personnel. The members are identified as Tower 13M Exterior Diaphragm.

The Exterior Diaphragms welds are WD1-A1-4, 5, 54, 55.

The green Tag number is identified as 12501.

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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 U-ribs diaphragm weld.

The Weld Designations are as follows

DP3137-001-193,194,201,202

DP3138-001-187,188

DP3145-001-231,232,233,234

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel after repair. This QA inspector generated a (UT) report for this date. The members are identified as Segment 9DE weld.

The Weld Designations are as follows

EP148-022

SEG056*-045,046

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 weld.

The Weld Designations are as follows

SEG056D-013,031

SEG056E-065,019,155,042,128,092

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 one (1) longitudinal linear indication measuring approximately 15mm in length. The indication dbS rating is +7. Material thickness is 25mm. The depth of the indications is approximately 12.2mm. The weld is identified as SEG056D-031 located between Panel Point (PP) 80 to PP81. The weld is designated as Seismic Performance Critical Members (SPCM). The indication is clearly marked on or near the weld. The Y location is 30mm, measured from the inside of Deck Plate (DP699) down. The weld SEG056D-031 is a Complete Joint Penetration (CJP) "T" joint, joining the Edge Plate (PL1336C SPCM) to "I" Stiffener X8E (Non SPCM). Segment 9DE is located outside of the Paint Shop. The Notice of Witness Inspection (NWIT) No. is 005564. 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.

The QA inspector generated an incident report for this date.

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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
Reviewed By:	Patterson,Rodney	QA Reviewer
