

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013915**Date Inspected:** 06-May-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) Chanxing 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 Segment 10AE	

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance Inspector (QA), Vibin Kumar Selvanayaham, was present during the times noted above for observations relative to the work being performed.

Ultrasonic Testing (UT) - Document: 005666

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Segment 10AE. The weld designations reviewed are as follows:

1. SEG060*-025, 026, 033, 037, 038, 039
2. SEG060A-012, 013, 014, 016, 017, 018
3. SEG060A-024, 025, 026, 027, 028, 029
4. SEG060A-035, 036, 037, 038
5. SEG060B-001, 002, 003, 004, 005, 009, 010, 011, 012
6. SEG060B-017, 018, 019, 020, 023, 025
7. SEG060B-031, 033, 035, 038, 039, 037, 040, 041
8. SEG060C-001, 002, 003, 004, 005, 010, 012
9. SEG060C-017, 018, 019, 020, 032, 033, 034, 039, 040, 041, 042

Description of Incident: During the Quality Assurance Ultrasonic Testing (UT) review of weld located on Segment 10AE, this Quality Assurance Inspector (QA) discovered one (1) Class "A" indication measuring approximately

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20mm in lengths. The indication D-rating is +3dB. The weld joint is identified as SEG060A-013. The weld is a Complete Joint Penetration (CJP) butt weld joining the side plate SP549B (PL1072B) to side plate SP589B (PL1074B). The thickness of the side plates are 16mm and depth of the indication approximately 10mm. The indication is clearly marked by QA on/near the weld. This weld joint is designated as Seismic performance critical weld member (SPCM). The indication is located inside the area that has been previously 100% tested and accepted by ZPMC Quality Control (QC) personnel.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

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.

Inspected By:	Kumar,Vibin	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
