

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-015395**Date Inspected:** 01-Jul-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:****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:** Bay 9**Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Christopher D'souza 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 observed and/or found the following:

Bay 9

DP3103-001 (PL3199A, PL3199B, PL3199C)

QA inspector performed conventional Ultrasonic (UT) Inspection on deck panel tack weld areas. The inspection is preliminary prior to using the phased array (PAUT) testing system to verify indications found with conventional Ultrasonic testing. QA inspector performed UT on deck panel DP3103-001 having 15 ribs, 30 welds, 230 total tack welds.

Weld 1 scanned 9 locations with 0 indications.

Weld 2 scanned 9 locations with 0 indications.

Weld 3 scanned 9 locations with 0 indications.

Weld 4 scanned 9 locations with 0 indications.

Weld 5 scanned 9 locations with 1 indication.

Weld 6 scanned 9 locations with 0 indications.

Weld 7 scanned 9 locations with 0 indications.

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Weld 8 scanned 9 locations with 3 indications.
Weld 9 scanned 9 locations with 1 indication.
Weld 10 scanned 9 locations with 0 indications.
Weld 181 scanned 9 locations with 0 indications.
Weld 182 scanned 9 locations with 0 indications.
Weld 183 scanned 9 locations with 0 indications.
Weld 184 scanned 9 locations with 0 indications.
Weld 185 scanned 9 locations with 0 indications.
Weld 186 scanned 9 locations with 0 indications.
Weld 187 scanned 9 locations with 0 indications.
Weld 188 scanned 9 locations with 1 indication.
Weld 189 scanned 9 locations with 1 indication.
Weld 190 scanned 9 locations with 1 indication.
Weld 291 scanned 5 locations with 0 indications.
Weld 292 scanned 5 locations with 0 indications.
Weld 293 scanned 5 locations with 0 indications.
Weld 294 scanned 5 locations with 0 indications.
Weld 295 scanned 5 locations with 1 indication.
Weld 296 scanned 5 locations with 0 indications.
Weld 297 scanned 5 locations with 0 indications.
Weld 298 scanned 5 locations with 0 indications.
Weld 299 scanned 5 locations with 0 indications.
Weld 300 scanned 5 locations with 0 indications.

Tack weld locations found non-compliant are marked on U-rib and deck plate for ZPMC's reference for repair. See Caltrans U-rib to Deck Panel- Tack Weld Assessment sheets dated 1st July, 2010 for further information on PAUT inspections.

Updated Deck Panel Summary Log.
Updated Tack Weld Assessment sheets,

This QA Inspector was involved in PAUT (Phased Array Ultrasonic Testing) training for detection of cracked tacks in Deck Panels as per the following procedure "UT 04-0120F4 PJP Rib Weld Phased Array Ultrasonic Testing for the Detection and Sizing of Suspected Planar Discontinuities (Cracks) in PJP Welds"

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 Eric Tsang 15000422372, who represents the Office of Structural Materials for

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your project.

Inspected By:	Dsouza,Christopher	Quality Assurance Inspector
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Reviewed By:	Carreon,Albert	QA Reviewer
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