

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-015479**Date Inspected:** 07-Jul-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:** Li Bai Qang.**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:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

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

Subassembly, Bay 04, Deck Panel 13CE-DP3107-001.

This QA inspector performed conventional Ultrasonic Testing (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 DP3107-001, 09 ribs, 18 welds, 138 total tack welds inspected.

Weld 1 scanned 9 locations with 2 indication.

Weld 2 scanned 9 locations with 1 indications.

Weld 3 scanned 9 locations with 4 indications.

Weld 4 scanned 9 locations with no indication.

Weld 5 scanned 9 locations with 3 indications.

Weld 6 scanned 9 locations with no indications.

Weld 138 scanned 9 locations with 2 indication.

Weld 139 scanned 9 locations with no indications.

Weld 173 scanned 9 locations with 2 indications.

Weld 174 scanned 9 locations with no indication.

Weld 140 scanned 9 locations with no indications.

Weld 141 scanned 9 locations with 1 indications.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Weld 176 scanned 5 locations with no indications.

Weld 177 scanned 5 locations with no indications.

Weld 178 scanned 5 locations with 1 indications.

Weld 180 scanned 5 locations with 1 indications.

Weld 179 scanned 5 locations with 1 indications.

Weld 181 scanned 5 locations with 2 indications.

Subassembly, Bay 04, 13AE, Deck panel to U-rib.

FCAW Second time Repair welding of partial penetration weld joints DP3077(PL3173)-001-003, 010; located on subassembly, Bay 04, 13AE. Welder is identified as 068596; ZPMC Quality Control Inspector (QC) is identified as Li Bai Qang. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-345-FCAW-2G(2F)-FCM-REPAIR.

Y-location of repairs were

003 - 8850.

010 – 2250.

The attached photographs provide additional detail.

Subassembly, Bay 04, 13AW, Deck panel to U-rib.

FCAW Second time Repair welding of partial penetration weld joints DP3119-001-002, 004, 007; located on subassembly, Bay 04, 13AW. Welder is identified as 203805; ZPMC Quality Control Inspector (QC) is identified as Li Bai Qang. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-345-FCAW-2G(2F)-FCM-REPAIR.

Y-location of repairs were

002 - 12150.

004 – 12650.

007 – 10550.

Subassembly, Bay 04, 13AW, Deck panel to U-rib.

FCAW Repair welding of partial penetration weld joints DP3119-001-001(Y-location 10050); located on subassembly, Bay 04, 13AW. Welder is identified as 203805; ZPMC Quality Control Inspector (QC) is identified as Li Bai Qang. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-345-FCAW-2G(2F)-FCM-REPAIR.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



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, 1500.042.2372, who represents the Office of Structural Materials for your project.

Inspected By:	Juvekar,Amit	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
