

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-016727**Date Inspected:** 24-Aug-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:** Deck Panels**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

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 DP3167 (PL3436B)-001 having 4 ribs, 8 welds, and 64 total tack welds.

Weld 11 scanned 8 locations with 2 indications.

Weld 12 scanned 8 locations with 1 indication.

Weld 13 scanned 8 locations with 0 indications.

Weld 14 scanned 8 locations with 0 indications.

Weld 15 scanned 8 locations with 0 indications.

Weld 16 scanned 8 locations with 2 indications.

Weld 17 scanned 8 locations with 0 indications.

Weld 18 scanned 8 locations with 1 indication.

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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 DP3163 (PL3439B)-001 having 4 ribs, 8 welds, and 64 total tack welds.

Weld 09 scanned 8 locations with 0 indications.

Weld 10 scanned 8 locations with 0 indications.

Weld 11 scanned 8 locations with 0 indications.

Weld 12 scanned 8 locations with 1 indication.

Weld 13 scanned 8 locations with 1 indication.

Weld 14 scanned 8 locations with 0 indications.

Weld 15 scanned 8 locations with 0 indications.

Weld 16 scanned 8 locations with 1 indication.

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 24th August, 2010 for further information on PAUT inspections.

Bay 4

This QA Inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested by ZPMC MT personnel. This QA Inspector generated a TL-6028 MT report on this date. The weld designation numbers is as follows:

DP 3103 (PL3199A) – 001 – 001 ~ 010

DP 3103 (PL3199B) – 001 – 181 ~ 190

DP 3103 (PL3199C) – 001 – 291 ~ 300

DP 3087 (PL3183A) – 001 – 001 ~ 008

DP 3087 (PL3183B) – 001 – 145 ~ 152

QA Inspector performed Final Visual Inspection following the guide lines of AWS-D1.5 on Deck Panel assemblies including Partial Penetration (PJP) welds joining U-ribs to deck plate. The deck panels examined are as follows:

DP 3103-001: Final VT appears to comply with code and contract requirements.

DP 3087-001: Final VT appears to comply with code and contract requirements.

QA Inspector performed Green Tagging activities following the green tagging procedure. The deck panels green tagged are as follows:

DP 3103 (PL3199A) – 001: Green Tag Number 14276

DP 3103 (PL3199B) – 001: Green Tag Number 14277

DP 3103 (PL3199C) – 001: Green Tag Number 14278

DP 3087 (PL3183A) – 001: Green Tag Number 14279

DP 3087 (PL3183B) – 001: Green Tag Number 14280

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

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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 your project.

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