

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:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018034**Date Inspected:** 19-Oct-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	

Summary of Items Observed:

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

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 OBG Segment 12AE. The weld designation reviewed is as follows:

SEG3001F-001,002,003,004
SEG3001G-001,002,003,004.
SEG3001H-001,002,003,004
SEG3001AL-002,003,013,014
SEG3001A-002,003
SEG3001R-001,002,003,006
SEG3001P-001,002,003,004

During the Quality Assurance Ultrasonic Testing (UT) review of weld located on Orthotropic Box Girder (OBG) segment 12AE, this Quality Assurance Inspector (QA) discovered the following issue:

-One (1) longitudinal linear indication measuring approximately 10mm in length.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

- The indication dB rating is a +7.
- The Material thickness is 16mm.
- The depth of the indication is approximately 7mm.
- The Y distance for this indication is 1470 mm from east side of the Panel point 111.
- The weld is identified as SEG3001AL-006 at Cross Beam Side, Panel Point PP111.
- This weld is Butt weld joining between Side Panel Plate (SP3004D) to Side Panel Plate (SP3003D).
- This weld joint is designated as Seismic performance critical (SPCM).
- The indication is clearly marked on or near the weld.
- The Segment 12AE is located at near trial assembly Yard.

The Notice of Witness Inspection (NWIT) No. is 006956. The indication is located Within an area previously tested and accepted by ZPMC Quality Control (QC) personnel.

The above mentioned discrepancy was informed to Lead Inspector for further action.

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

Summary of Conversations:

No Relevant Conversation.

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:	Pillai,Pandaram	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
