

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-019070**Date Inspected:** 28-Dec-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:** Xu Xian Ping**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 Office of Structural Material (OSM) Quality Assurance (QA) Inspector, D.Sukanthan was present during the time noted above for observations relative to the work being performed.

OBG # CROSSBEAM CB19

This QA inspector received ZPMC Non Destructive Testing (NDT) notification 07933 to perform Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated a Ultrasonic Test report for this date. The member is identified as Crossbeam CB19.

During the Quality Assurance Ultrasonic Testing (UT) verification of weld located on OBG Crossbeam CB19, this Quality Assurance Inspector (QA) discovered the following issue. One Class "A" indication measuring approximately 20mm in length. The Indication rating is +9dB. The thickness of the plate is 20mm. Depth is approximately 15mm. The weld joint is identified as FB3244-002-051. The "Y" location for this indication is approximately 100mm from south end of the weld joint. The weld is a Complete Joint Penetration (CJP) butt joint joining floor beam corner diaphragm to floor beam diaphragm sub assembly (FB3244A).

One Class "A" indication measuring approximately 20mm in length. The Indication rating is +5dB. The thickness of the plate is 25mm. Depth is approximately 20mm. The weld joint is identified as DP3182-1-001-009. The "Y" location for this indication is approximately 130mm from top of the stiffener. The weld is a Complete Joint Penetration (CJP) T- joint joining deck panel Stiffener (DP3182A-2) to Diaphragm sub

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assembly (FB3246A). This QA notified ZPMC QA identified as Mr. Huang Min of this issue and that an incident report would be generated. ABF personnel cancel the notification 07933 and appear to ZPMC personnel will perform 100% UT and MT again. See attached pictures.

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



Summary of Conversations:

As mention above

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 150-00422372, who represents the Office of Structural Materials for your project.

Inspected By: Sukanthan,Dhanasingh

Quality Assurance Inspector

Reviewed By: Hall,Steven

QA Reviewer