

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-020172**Date Inspected:** 08-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**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:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Mike Hasler was present during the times noted above for observations relative to the work being performed.

OBG Segment Name: 5BW-5CW / Trial Assembly Area

This Caltrans QA inspector performed American Bridge / Fluor (ABF) Ultrasonic Testing (UT) Verification Witness Request #01082010-1; Item #1 weld repair areas previously tested and accepted by ABF. QA performed VT & UT inspection of the following weld identified as OBWSA-007, side plate segment component, 5BW-5CW transverse weld seam using conventional and "D" scan pattern. No QAMT performed, due to the surface of the plated having couplant on it. The repaired weld was found to be in conformance with contract requirements. See Caltrans Ultrasonic Test Report (TL6027), date 01-08-2010 for additional information.

OBG Segment Name: 6AE-6BE / Trial Assembly Area

This Caltrans QA inspector performed American Bridge / Fluor (ABF) Ultrasonic Testing (UT) Verification Witness Request #01072010-1; Item #1 weld repair areas previously tested and accepted by ABF. QA performed VT & UT inspection of the following weld identified as OBE6-001, edge panel segment component, 6AE-6BE transverse weld seam using conventional and "D" scan pattern. No QAMT performed, due to the surface of the plated having couplant on it. The repaired weld was found to be in conformance with contract requirements. See Caltrans Ultrasonic Test Report (TL6027), date 01-08-2010 for additional information.

OBG Segment Name: 7CW / Blast Shop

This QA Inspector performed ZPMC Notification of Inspection Request #2472. QA performed preliminary

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random visual inspection after the grit blast of interior surfaces. Areas with visual weld defects that will require welding were taped, and will be repaired prior to painting. ZPMC QC personnel were present during the inspection and were informed of the findings at the conclusion of the inspection.

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

Summary of Conversations:

“As noted within the contents of this report.”

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

Inspected By:	Hasler, Mike	Quality Assurance Inspector
Reviewed By:	Riley, Ken	QA Reviewer
