

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-013023**Date Inspected:** 09-Apr-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:	NA	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, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. This QA Inspector observed the following:

OBG Segment 9CW located in yard North of Bay 15

Earlier in the day ZPMC presented QA personnel with "Notification of Witness Inspection" document #005376 item 1 that states ZPMC is requesting Caltrans to perform magnetic particle and ultrasonic inspections of OBG segment 9CW as listed on Tag #1, Tag #2, Tag #3, Tag #4 and Tag #5. This QA Inspector performed random magnetic particle (MT) inspections of the welds that are listed below and these welds appear to comply with AWS D1.5 MT requirements. For additional information on these inspections see this QA Inspector's TL6028 Magnetic Particle Test Report.

Tag 3

SEG053B-017, 018, 019, 020

SEG053C-017, 018, 019, 020

SSD29-PP77.5-215, 216, 217, 218, 219, 220, 221, 222, 223, 224, 176, 177, 178, 197, 180, 181, 182, 183, 184, 155, 156, 157, 158, 159, 160, 161, 162

Tag 4

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

SSD13-PP78-38, 39, 40, 41, 42, 43, 90, 92, 98, 100, 114, 116, 118, 120, 124, 125, 128

SSD13-PP78-51, 53, 55, 57, 59, 63, 65, 09, 02

SSD13A-PP78-43, 124, 35, 27, 29, 31, 33, 84, 86, 88, 90, 07, 03, 02

Tag 5

CA061-53, 54, 65, 66

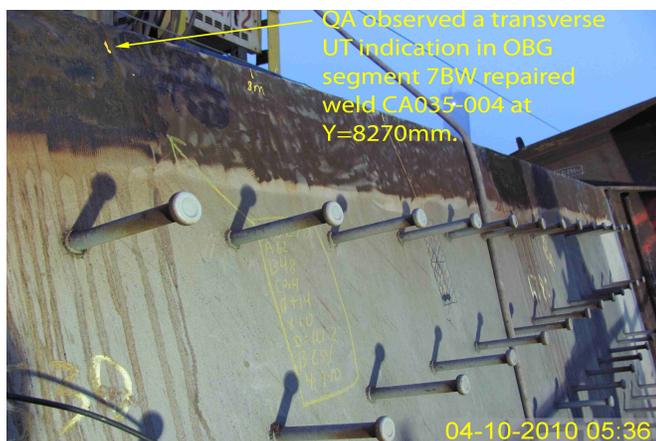
CSD3-PP78-23, 25, 27, 29, 43, 45, 49, 50, 51, 52, 53, 57, 58

CSD3-PP78-85, 87, 91, 142, 110, 112, 132, 134

CSD2-PP77.5-93, 94, 97, 98, 99, 100, 101, 102, 105, 106, 121, 122, 123, 124

Segment Assembly

ABF issued "Inspection Notification Sheet" number 04082010-2 item #1 informing QA that on 4-09-2010 at 19:30 hours ABF Inspectors will be performing ultrasonic (UT) inspections of repaired weld CA035-004 which joins the deck plate and edge plate on the counterweight side of OBG segment 7BW. This weld is located in the OBG Segment Assembly yard. Caltrans QA Inspector Mr. Mike Hasler was informed by ABF/Sense UT Inspectors that ABF had located four UT rejections and the remainder of the weld repairs are UT acceptable. Mr. Mike Hasler performed ultrasonic inspections of weld repair locations #1 through #6 and this QA Inspector performed ultrasonic inspections from weld locations # 7 (Y=8125) through location #14 (Y=12110) as listed on the UT report data sheets for detection of longitudinal and planar transverse indications utilizing scanning patterns A, B, C and D (AWS D1.5 Fig 6.7). This QA Inspector observed ABF personnel have indicated locations Y=8530 and Y=9260 as being UT rejections and the remainder of these repair locations are UT acceptable. This QA Inspector observed a +14 transverse indication at Y=8270 and ABF had not marked this indication as being rejectable. The remainder of the repair locations appears to comply with project specifications. Note: These inspections are being documented and tracked on "Verification Witness Request" documents and no TL-6027 UT report or incident report was issued for these inspections. See the photograph below for additional information.



Summary of Conversations:

See 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 phone: 150-0042-2372 , who represents the Office of Structural

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Materials for your project.

Inspected By:	Dawson,Paul	Quality Assurance Inspector
----------------------	-------------	-----------------------------

Reviewed By:	Carreon,Albert	QA Reviewer
---------------------	----------------	-------------