

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017960**Date Inspected:** 17-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) Chanxing 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 Segment 12AE	

Summary of Items Observed:

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

Ultrasonic Testing (UT) – NWIT Document No: 006956

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Segment 12AE. The weld designations reviewed are as follows:

1. SEG3001A-008, 012, 013
2. SEG3001AL-010, 011, 012, 017, 018, 019
3. SEG3001L- 001, 002, 003, 004, 005
4. SEG3001J-002, 014, 016
5. CA3001-003, 004
6. SP3013-001-079, 080, 081
7. SP3014-001-075, 076, 077
8. SP3015-001- 081, 083, 084

Description of Incident: During the Quality Assurance Ultrasonic Testing (UT) verification of weld located on OBG Segment 12AE, this Quality Assurance Inspector (QA) discovered that one (1) Class “A” indication measuring approximately 20mm in length. The Indication rating is +9dB and length approximately 20mm. The

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nominal thickness of the plate is 14mm and depth of the indication approximately 5mm. The indication is located on the weld joint identified as SEG3001J-002. The “Y” location for this indication is approximately 280mm from deck panel. The weld is a Complete Joint Penetration (CJP) butt joint joining deck panel diaphragm (X3021E) to deck panel diaphragm (X3021G). The ZPMC QC is identified as Mr. Li Ping. The indication is clearly marked by QA on/near the weld. This weld is designated as Non Seismic Performance Critical Member (Non SPCM). OBG Segment 12AE is located in outside yard (west side of Blast Shop 1). The indication is located within the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. As per the contract documents, ZPMC’s QC personnel are required to perform 100% UT inspection of this weld.

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

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

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:	Kumar,Vibin	Quality Assurance Inspector
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Reviewed By:	McClendon,Timothy	QA Reviewer
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