

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-025147**Date Inspected:** 28-Nov-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**CWI Name:** Tian Lei**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 R. Hernandez was present during the time noted above and conducted observations relative to the work being performed.

The QA Inspector randomly observed the following work in progress: ,

Bay Number 1

Performed verification VT for the component(s) identified as OBG Barrier Rails for components listed as E2-SB1-021, E2-SB1-022, E2-SB1-023, E2-SB2-005, E2-SB2-014, E2-SB5-021, E2-SB5-022, E2-SB5-024, E2-SB5-025, E2-SB1C-011, E2-SB1D-042, & E2-SB4-003, This QA inspector signed green tag #15382.

Bay Number 2

This QA inspector assisted in the performance MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel, by the lot method testing procedure. This QA Inspector assisted in the generation an MT report for this date by inspector lot no. All components were as listed on NWIT notification no. 07534. The member(s) is/are identified as OBG Anchorage Plate & Longitudinal Diaphragm. The weld designations reviewed are as follows:

1. LD3051-001-017, 013, 033, 029.
2. AP3032-001-969, 971, 1017, 1019

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3. LD3049-001-410, 416, 417, 413.

This QA observed ZPMC QC MT technicians perform MT on the fillet welds joining the stiffeners to the anchor plate on OBG component identified as AP3032-001. This QA observed that ZPMC has marked numerous transverse cracks for repair. This QA counted approximately 433 locations marked for repairs.

The following is a list of welds that contain transverse cracks. The number in parenthesis is the number of transverse cracked marked by ZPMC technicians.

002(11) 004(4) 015(9) 278(1) 279(8) 280(8) 281(7)
282(5) 283(8) 284(6) 285(7) 286(1) 324(17) 325(18)
326(7) 327(5) 328(1) 329(5) 331(3) 369(18) 370(10)
371(11) 373(1) 374(5) 376(3) 413(1) 414(10) 416(1)
417(10) 419(4) 420(1) 421(2) 458(1) 459(1) 461(4)
462(5) 463(1) 464(10) 465(3) 466(1) 503(2) 504(3)
506(6) 507(11) 508(2) 509(6) 549(2) 550(2) 551(3)
552(5) 553(2) 554(3) 555(2) 556(2) 597(2) 598(2)
599(8) 600(6) 643(5) 644(2) 646(1) 647(5) 688(1)
690(5) 691(1) 692(3) 693(1) 738(1) 739(2) 741(2)
743(1) 786(3) 788(3) 790(2) 834(6) 835(1) 836(4)
837(4) 882(7) 884(3) 885(1) 886(4) 887(1) 930(7)
933(2) 975(2) 977(2) 978(15)* 979(15) 980(17) 981(1)

*Below are photographs of AP3032-001 weld no. 978

Unless otherwise noted above all items observed on this day appeared to be in general compliance with the applicable contract documents



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Summary of Conversations:

Pertinent conversations are included in the body of the 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 Eric Tsang 1500-0042-02372, who represents the Office of Structural Materials for your project.

Inspected By:	Hernandez,Rene	Quality Assurance Inspector
Reviewed By:	Hall,Steven	QA Reviewer
