

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-021408**Date Inspected:** 15-Jan-2011**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:** Geng Wei**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 Larry Viars was present during the times noted above for observations relative to the work being performed.

Bay 14-

This QA Inspector observed the following work in progress: Flux Cored Arc Welding (FCAW) of OBG Segment 14E weld, SEG3019E-2-158. ZPMC welder was identified as 068501. ZPMC QC was identified as Wang Xu. ZPMC CWI was identified as Geng Wei. The welding appeared to be in conformance with ZPMC welding procedure specification, WPS-B-T-2231-ESAB.

Flux Cored Arc Welding (FCAW) of OBG Segment 14E weld, SEG3019E-2-165. ZPMC welder was identified as 044830. ZPMC QC was identified as Wang Xu. ZPMC CWI was identified as Geng Wei. The welding appeared to be in conformance with ZPMC welding procedure specification, WPS-B-T-2231-ESAB.

Flux Cored Arc Welding (FCAW) of OBG Segment 14E bottom panel stiffener weld, SEG3019Q-2-188. ZPMC welder was identified as 066471. ZPMC QC was identified as Wang Xu. ZPMC CWI was identified as Geng Wei. The welding appeared to be in conformance with ZPMC welding procedure specification, WPS-B-T-2132-ESAB.

This QA Inspector performed Magnetic Particle Testing (MT) verification of welds previously tested and accepted by ABF QC for OBG segment 13AE stiffener welds. See MT report TL-6028 generated this date for additional information. The following welds were tested:

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RS3096-001-010, 012
RS3077-001-004
RS3100-001-007, 008
SEG3007AV-075, 077
SEG3007E-151, 152, 156
SEG3007U-079~082, 092, 093, 085, 086, 095, 097, 106A, 108A

Caltrans QA issued an Incident report for non compliant cope holes on OBG segment 13AE Rib stiffeners. The above mentioned cope holes were visually inspected by ABF QC. See attached photos for additional information.



Summary of Conversations:

Caltrans QA notified ZPMC and ABF QC that an incident report would be issued for the above mentioned MT indication.

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 0042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
