

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-021809**Date Inspected:** 02-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Hua Jie**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, Dennis Combs, was present during the times noted above for the observations relative to the work being performed.

BAY 14

This Caltrans QA inspector received ZPMC non-destructive test (NDT) notification number 08430 from ZPMC for Bay 14. This QA inspector performed ultrasonic testing (UT) verification of welds after ZPMC had performed their UT inspection. The segment is identified as OBG. The weld designations reviewed are as follows.

SEG3019BB-047, 157, 169

During the Quality Assurance Ultrasonic Testing (UT) review of weld located on Segment 14AE, this Quality Assurance Inspector (QA) discovered two class "A" rejectable indications located in weld number SEG3019BB-157.

The weld is a Complete Joint Penetration (CJP) T Joint weld joining the vertical shear plate (SA3359A) to the anchor plate (AP3031A). The indication is clearly marked by the QA near the weld, and this incident was reported.

BAY 16

This QA Inspector observed the following work in progress for Bay 16.

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ZPMC was using the Shielded Metal Arc Welding (SMAW) processes.

ZPMC QC is identified as Guo Xing Hui.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Component: Steel Barrier

PCMK: E5-SB27-001

Weld Number: 063~074

Welder: 201905

WPS-B-T-2113

Component: Steel Barrier

PCMK: E5-SB24-001

Weld Number: 126~131

Welder: 222396

WPS-B-T-2132

Component: Steel Barrier

PCMK: W2-SB29-001

Weld Number: 048, 049

Welder: 201889

WPS-B-T-2113

TRIAL ASSEMBLY

This Caltrans QA inspector received ZPMC non-destructive test (NDT) notification number 08430 from ZPMC for Bay 14. This QA inspector performed ultrasonic testing (UT) verification of welds after ZPMC had performed their UT inspection. The segment is identified as OBG Hold Back Welds. The weld designations reviewed are as follows.

CA3003-006

CA3005-002

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

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Summary of Conversations:

Informed ZPMC QC Zhan Hai Feng, and AB/F Jiang Zi Wen of UT indications found during QA UT verification.

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:	Combs,Dennis	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
