

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-024734**Date Inspected:** 23-Jun-2011**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:** See Below**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:**

CWI Inspector: Mr. Li Ping

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:

Bay 14, OBG segment 14West

Caltrans and ABF have agreed to conduct visual and magnetic particle inspections (MT) of segment 14W welds as part of a special reinspection program. ZPMC personnel have performed repairs of the following welds and ABF performed MT and visual inspections of the following repaired welds, reference NWIT 9579.

Location #1, PP125 North side plate: SEG3020AL-031, 039, 043, 053, 057 and 063. ABF initially rejected weld SEG3020AL-041 and ZPMC welder 044772 used the SMAW process to perform weld repairs of this weld. AWS D1.5 requires that the final MT inspections shall be performed after a minimum of 24 hour period. Weld SEG3020AL-041 was MT accepted during initial MT inspections and the final MT inspections will be performed following the 24 hour time requirements. This QA Inspector performed random magnetic particle inspection of welds: SEG3020AL-031, 039, 043, 053, 057 and 063.

Location #2, FL3 Cross Beam side: SEG3020AT-006, 016, 017, 021, 028, 042, 047, 069, 080, 085, 108, 120, 129,

WELDING INSPECTION REPORT

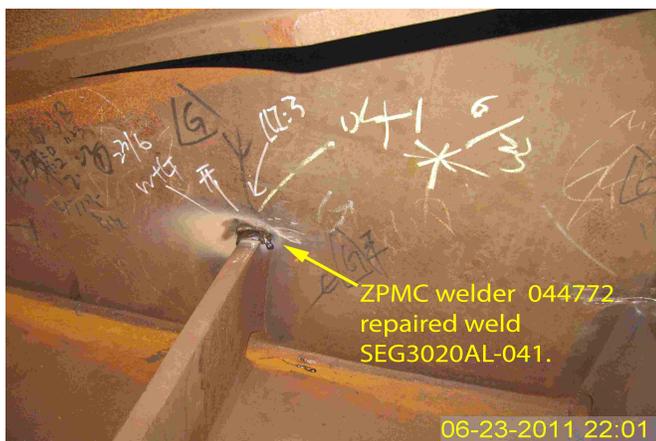
(Continued Page 2 of 2)

133, 135, 137, 145 and 146. ABF initially rejected weld SEG3020AT-038, 059 and 146 and ZPMC welder Mr. Fang Jia Hong, stencil 054016 used the SMAW process to performed weld repairs of these welds. AWS D1.5 requires that the final MT inspections shall be performed after a minimum of 24 hour period. Welds SEG3020AT-038, 059 and 146 were initially MT accepted during initial MT inspections and the final MT inspections will be performed following the 24 hour time requirements. This QA Inspector performed random magnetic particle inspection of welds: SEG3020AT-006, 016, 017, 021, 028, 042, 047, 069, 080, 085, 108, 120, 129, 133, 135, 137, 145 and 146.

Location #3, PP125: SEG3020V-039, 046, 047, 050, SEG3020W-025 and 027.

This QA Inspector performed random magnetic particle inspection of welds: SEG3020V-039, 046, 047, 050, SEG3020W-025 and 027 and these welds appear to comply with AWS D1.5 MT and visual requirements.

For additional information on these MT inspections see this QA Inspector's TL6028 Magnetic Particle Test Report.



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 James Devey +8615000026784, who represents the Office of Structural Materials for your project.

Inspected By:	Dawson,Paul	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
