

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-024911**Date Inspected:** 16-Jun-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:****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:**

Trial Assembly

UT Inspection

This Caltrans QA inspector received ABF UT inspection report UT-CB18-006, dated 6-16-11 for QA verification. The OBG assembly is identified as CB18 in Bay 6. This QA inspector performed ultrasonic test (UT) using "D" scan pattern, after ABF had performed their UT inspection of the following locations.

Deck Plate to Side Plate (Hold Back Weld)

CB3002A-018-021, 023

At the time of the verification it was noted that the above component appeared to be within compliance of the contract documents. See Caltrans Ultrasonic Test Report (TL6027), dated 06-16-2011 for additional information.

MT Inspection/ Tracking

This Caltrans QA inspector witness and performed Visual Testing (VT) of an area that have been previously tested by American Bridge Fluor (ABF) QA personnel using the Magnetic Particle (MT) and VT method. This QA Inspector generated a MT tracking report for this date and indicated ABF accept or reject of the welds. The OBG segment is identified as 14W. The weld designation as follows:

SEG3020V-039, 041, 075; SEG3020W-001, 003, 004, 036; SEG3020*-005, 008; DP3174-022, 039

This Caltrans QA inspector performed MT of approximately 15% of an area that have been previously tested and accepted by ABF personnel. This QA inspector generated a Caltrans Magnetic Particle Test Report (TL6028), dated 06-16-2011 for the following welds:

WELDING INSPECTION REPORT

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SEG3020V-041, 075; SEG3020W-001, 004; SEG3020*-005, 008

At the time of the verification it was noted that the above component appeared to be within compliance of the contract documents. See Caltrans Magnetic Particle Test Report (TL6028), dated 06-16-2011 for additional information.

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

Summary of Conversations:

“As noted within the contents of this 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 James Devey 15000026784, who represents the Office of Structural Materials for your project.

Inspected By:	Hasler, Mike	Quality Assurance Inspector
Reviewed By:	Riley, Ken	QA Reviewer
