

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-025102**Date Inspected:** 18-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:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Kelly Leavitt, was present during the times noted above for random observations relative to the work being performed.

Blast Bay

This Quality Assurance (QA) inspector performed Visual Testing (VT) of an area that has been previously tested by American Bridge Fluor (ABF) QA personnel using the Magnetic Particle (MT) and VT method. This QA Inspector provided a turnover to dayshift personal for tracking of these welds. The member was identified as OBG 13E. The weld designations reviewed are as follows:

SEG3019AA-028,031,032,034~054

SEG3019A-019~025

SP3121A-001-017~021,080~123

SEG3019AW-104,103,111~116,103,104,111~116

SEG3019J-027~031,203~205,198~200,193~195,188~190,183~185,178~180,173~175,168~170,163~165,202,197,192,187,182,177,172,167,162,132,136,134,135,097~126,152~156,131,147~151,146,137

SEG3019M-027,029,031,032,038,084,089,094,099,104,109,114,119,124,129,134,139,144,149,155,161,167

SEG3019G-083,217

SEG3019AJ-141~155,139,140

SEG3019AY-121,128~137

DP3164-001-224,226,259

DP3161-001-021

DP3161-002-346

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DP3162-002-394,359
SP3121A-001-017~021,080~123

This QA inspector performed MT of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date. The member was identified as OBG 13E. The weld designations reviewed are as follows:

SEG3019AA-028,031,032,035~040
SP3121A-017~021,080,081,098,100~103,090~094
SEG3019AW-111~116
DP3164-001-224,226,259
DP3161-001-021
DP3161-002-346,394,359

(see photos below for visual defects)

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



Summary of Conversations:

“No relevant conversations.”

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 1500026784, who represents the Office of Structural Materials for your project.

Inspected By: Leavitt, Kelly

Quality Assurance Inspector

Reviewed By: Riley, Ken

QA Reviewer