DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-025652
Date Inspected: 22-Jul-2011

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 1900
OSM Departure Time: 700
Location: Shanghai, China

CWI Name:	N/A	**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, 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:

Caltrans and ABF have agreed to conduct visual and magnetic particle inspections (MT) of segment 13West welds as part of a special inspection program,reference NWIT 9803. This QA Inspector observed ABF Inspectors had completed and accepted MT inspections of welds: SEG3013J-064, SEG3013J-067 and SEG3013G-090. ABF Inspectors rejected welds: SEG3013J-065 (visual reject), SEG3013J-066 (MT reject) and SEG3013G-094 (visual reject). This QA Inspector performed random visual and magnetic particle inspection of welds: SEG3013J-064, SEG3013J-067 and SEG3013G-090 and these welds appear to comply with AWS D1.5 MT and visual requirements. For additional information on these inspections see this QA Inspector's TL6028 Magnetic Particle Test Report. See the photographs below for additional information.

WELDING INSPECTION REPORT

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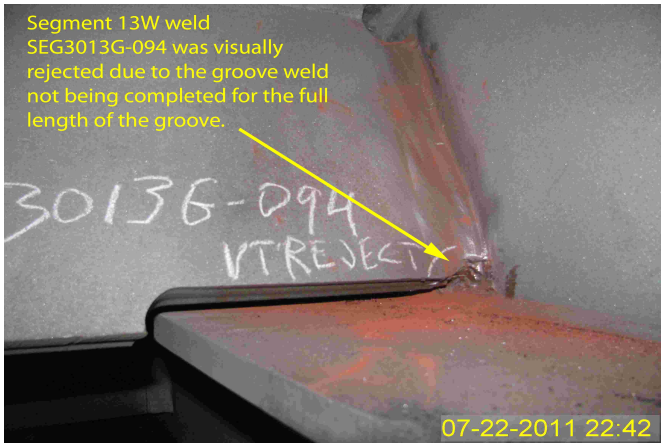

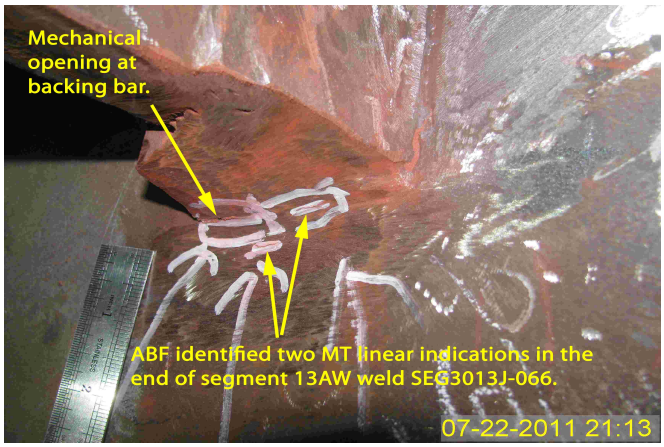

Summary of Conversations:

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 Eric Tsang phone: 150-0042-2372 , who represents the Office of Structural Materials for your project.

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