

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-016806**Date Inspected:** 19-Sep-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **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 day CALTRANS OSM Quality Assurance(QA) Inspector Mr. Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. The QA Inspector observed and/or found the following:

TRIAL ASSEMBLY YARD

ULTRASONIC TESTING

OBG SEGMENT 10BW-10CW

ABF Report No: UT-10W-038R1

This QA Inspector performed verification Ultrasonic Testing in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a separate data sheet that Caltrans QA generates after performing a joint inspection with ABF ultrasonic testing personnel. The location of the inspection was identified as the edge panel splice weld between OBG segments 10BW and 10CW on cross beam side. The weld designations were as follows:

OBW10A-005 (OBG 10BW-10CW, EP, C.B side)

OBG SEGMENT 10BE

ABF Request No: 09172010-2

WELDING INSPECTION REPORT

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This QA Inspector performed verification Ultrasonic Testing in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a separate data sheet that Caltrans QA generates after performing a joint inspection with ABF ultrasonic testing personnel. The location of the inspection was identified as the hold back welds between bottom panel and side panel of OBG segment 10BE at intersection of OBG segment 10AE on bike path side. The weld designations were as follows:

SEG062A-014 (OBG 10BE, SP to BP, BK side @ 10AE)

OBG SEGMENT 10AE

ABF Request No: 09172010-2

This QA Inspector performed verification Ultrasonic Testing in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a separate data sheet that Caltrans QA generates after performing a joint inspection with ABF ultrasonic testing personnel. The location of the inspection was identified as the hold back welds between bottom panel and side panel of OBG segment 10AE at intersection of OBG segment 10BE on bike path side. The weld designations were as follows:

SEG060A-040 (OBG 10AE, SP to BP, BK side @ 10BE)

OBG SEGMENT 12BE

ABF Request No: 09192010-1

This QA Inspector performed verification Ultrasonic Testing in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a separate data sheet that Caltrans QA generates after performing a joint inspection with ABF ultrasonic testing personnel. The location of the inspection was identified as the weld between edge panel and deck panel of OBG segment 12BE on bike path side. Inspection was carried out on repair areas only. The weld designations were as follows:

CA3003-004 (OBG 12BE, EP to DP, BK side)

MAGNETIC PARTICLE TESTING

OBG SEGMENT 10BE

ABF Request No: 09172010-2

This QA Inspector witnessed ABF personal performing Magnetic Particle Testing the hold back welds between bottom panel and side panel of OBG segment 10BE at intersection of OBG segment 10AE on bike path side. Inspection was carried out on repair areas only. The weld identification numbers were.

SEG062A-014 (OBG 10BE, SP to BP, BK side @ 10AE)

No relevant indications were observed by this QA Inspector on this date.

OBG SEGMENT 10AE

ABF Request No: 09172010-2

This QA Inspector witnessed ABF personal performing Magnetic Particle Testing the hold back welds between bottom panel and side panel of OBG segment 10AE at intersection of OBG segment 10BE on bike path side.

WELDING INSPECTION REPORT

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Inspection was carried out on repair areas only. The weld identification numbers were.

SEG060A-040 (OBG 10AE, SP to BP, BK side @ 10BE)

No relevant indications were observed by this QA Inspector on this date.

OBG SEGMENT 12BE

ABF Request No: 09192010-1

This QA Inspector witnessed ABF personal performing Magnetic Particle Testing the weld between deck panel and edge panel of OBG segment 12BE on bike path side. Inspection was carried out on repair areas only. The weld identification numbers were.

CA3003-004 (OBG 12BE, EP to DP, BK side)

No relevant indications were observed by this QA Inspector on this date.

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

Summary of Conversations:

No significant conversations were reported on this date.

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, +(86) 1500 042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Utekar,Shrikant	Quality Assurance Inspector
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Reviewed By:	Peterson,Art	QA Reviewer
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