

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-017764**Date Inspected:** 24-Oct-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 date Caltrans OSM Quality Assurance (QA) Inspector, Nagalingam Pandaram Pillai was present during the times noted above for observations relative to the work being performed.

Magnetic Particle Testing:-

BAY#16

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an MT report for this date. The member is identified as OBG Segment Steel Barriers. The weld designation reviewed is as follows:

WS-SB1-029-82,95,126,129

W5-SB12-001-95,126,127,77,82,128

W5-SB1-028-128,131,56,24,95,87

W5-SB2-002-21,115,126,129,52,129,20

W5-SB1A-001-004

During random Quality Assurance visual verification of welds located on OBG Component steel barrier, Caltrans (CT) Quality Assurance Inspectors (QA) discovered the following issues:

- Four (4) Longitudinal Linear Indications with each measuring approximately 20 to 25mm in length.

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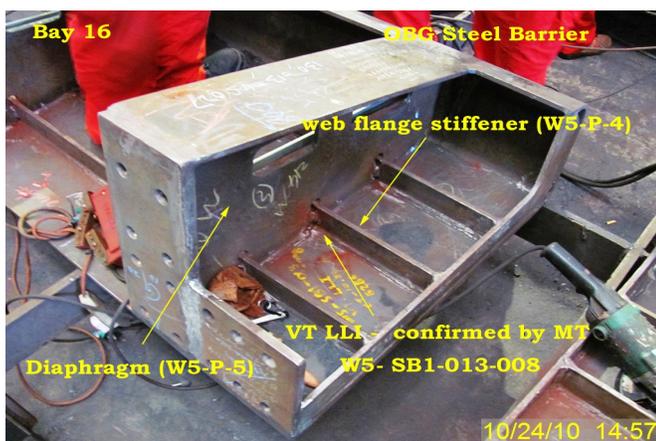
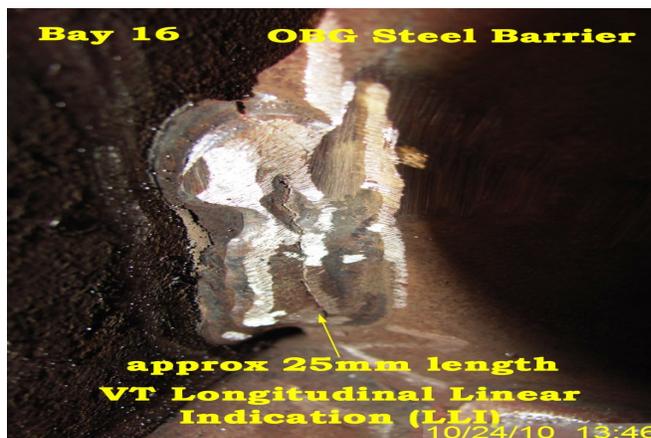
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- The indications were found on barriers identified as W5- SB1-013-008, W5- SB1-032-002, W5- SB1-029-042, and W5- SB2-002-033.
- These welds are fillet weld joints, joining the diaphragm (W5-P-5) to web flange stiffener (W5-P-4).
- The diaphragm to web flange stiffener is identified as non Seismic Performance Critical Member (non SPCM).
- The indications are clearly marked on the material near the weld.
- OBG Component Steel barriers are located in Bay#16.
- The indications were discovered visually and confirmed by Magnetic particle Testing (MT) by Caltrans QA

The Notice of Witness Inspection Number (NWIT) is 007081. The Longitudinal Linear Indications are located within an area that had been previously inspected by ZPMC Quality Control (QC) personnel. As per contract documents ZPMC is required to perform 100% Visual Testing (VT) of these welds.

For further information, see the attached pictures below.

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



Summary of Conversations:

No Relevant Conversation.

Comments

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

Inspected By:	Pillai,Pandaram	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
