

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-017810
Date Inspected: 23-Oct-2010

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:	Tower and OBG Components	

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance Inspector (QA Inspector) George Goulet was present during the times noted above for observations relative to the work being performed. Heavy rain was falling most of the night with moderate to heavy winds.

Bays 10 and 11

This QA Inspector randomly observed no welding related work in progress in Bay 10 and Bay 11. ZPMC QC Zhao Mao Mao confirmed to this QA Inspector that no work would be performed in Bay 10 or Bay 11 on this night.

OBG Trial Assembly Area

This QA Inspector randomly observed welding related work in progress in the OBG Trial Assembly Area. Streams of rainwater were pouring into OBG 11E and 11W at the open transverse joints and other openings in the deck. ZPMC CWI Liu Hua Jie confirmed to this QA Inspector that no work would be performed in the OBG Trial Assembly Area on this night.

Heavy Dock

This QA Inspector randomly observed the following on the Heavy Dock:

All 4 towers, lift 4 were positioned on a base separate pedestal at end of the Heavy Dock. No work was being performed on any of the tower components and no ZPMC floating cranes were moored to the Heavy Dock or in

WELDING INSPECTION REPORT

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the area.

Blast Shop 1

ZPMC requested Caltrans personnel to perform visual inspections of east tower, lift 3 from the top end at 114M elevation to the top of 99M double diaphragm. At approximately 0410 hours to 0505 hours, following the initial blast cleaning of the steel surfaces, several QA Inspectors, including this QA Inspector, performed random visual inspections of these areas. ABF and ZPMC Inspectors were present and performing visual inspections of the areas noted above. An ABF representative (BABF) and ZPMC QC Sun Zi Wang (BQC) informed this QA Inspector that they would be documenting all weld repairs and would provide this to the QA Inspectors with a copy of the documentation. This QA Inspector visually observed several areas that required grinding to resolve visual weld spatter, arc strikes, shallow nicks, scrapes, rough edges of unground welds, and sharp edges of ground welds. These areas were clearly marked with chalk as either “grind” or “grind and perform magnetic particle testing (MT)” using the letter G or the letters G+MT, respectively. This QA Inspector was notified that the above noted areas had been ground and MT had been performed. This QA Inspector randomly visually verified that the work had been performed. This QA Inspector observed 3 welds inside the 99M double diaphragm exhibiting porosity beyond that allowed by contract documents. The areas were clearly marked as needing weld repair, photographed, and documented. Other weld repairs were observed by other inspectors. All locations were documented by BQC and BABF. A copy of the documentation was presented to the QA Inspectors.

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

Summary of Conversations:

As noted 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 Micheal Ng, 159-2184-5703, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet,George	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
