

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-017867**Date Inspected:** 20-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:	Orthotropic Box Girder (OBG)	

Summary of Items Observed:

On this day CALTRANS OSM Quality Assurance (QA) Inspector Manoj Prabhune 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. QA observed and/or found the following:

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD

This QA performed Visual Testing (VT) and dimensional inspection on cope and weld access holes inside Orthotropic Box Girder (OBG) lift 12AE. A number of the cope holes did not appear to comply with the contract documents. American Bridge Fluor (ABF) QA inspectors have previously inspected and accepted these cope holes and recorded their findings on ABF document CWAHIR-12AE-01 date 13/10/10.

Those locations flush grinding and sharp edges removal. After rectification that ZPMC has fixed the issue. All these details noted and forwarded to team leader for further action.

Location E3 - Panel point 109(Facing West) - Floor beam to bottom panel cope hole

Location E3 - Panel point 111(Facing West) - Floor beam to side panel cope hole

Location E4 - Panel point 111(Facing East) - Floor beam to bottom panel cope hole

Location E4 - Panel point 115.5(Facing West) - Floor beam to side panel cope hole

Location E4 - Panel point 112.5(Facing West) - Floor beam to bottom panel cope hole

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Location E3 - Panel point 112.5(Facing West) - Floor beam to side panel cope hole

Segment # CB 13

This QA inspector performed Magnetic Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT reports for this date. The members are identified as Orthotropic Box Girder (OBG) Components. The weld designations reviewed are as follows.

SP206A-013-052, 053

SP204A-013-027, 028

SP205A-013-024, 025

BP203A-013-015 to 018.

CB202A-013-012, 013, 022.

DP203A-013-037, 038.

DP201A-013-021, 022.

Nondestructive testing (NDT) notification No. 07038

Segment # 10CE/FL3 Partial Diaphragm

This QA inspector performed Magnetic Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT reports for this date. The members are identified as Orthotropic Box Girder (OBG) Components. The weld designations reviewed are as follows.

SSD27-PP93-221, 021, 022, 023, 024, 030, 031, 033 to 036, 039, 044, 053, 054.

Nondestructive testing (NDT) notification No. 07040

Segment # 10AW/FL3 Partial Diaphragm

This QA inspector performed Magnetic Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT reports for this date. The members are identified as Orthotropic Box Girder (OBG) Components. The weld designations reviewed are as follows.

SSD25-PP087-055, 056, 057, 058, 059, 060, 061, 062, 101, 102.

Nondestructive testing (NDT) notification No. 07043

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

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Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

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: 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Prabhune,Manoj	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
