

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017962**Date Inspected:** 19-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) Chanxing 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 Segment 12AE	

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance Inspector (QA), Vibin Kumar Selvanayaham, was present during the times noted above for observations relative to the work being performed.

Ultrasonic Testing (UT) – NWIT Document No: 006956

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Segment 12AE. The weld designations reviewed are as follows:

1. SEG3001AL-022, 023, 024, 025, 027, 028, 029, 030, 031, 007
2. SEG3001H- 001, 002, 003, 004, 005
3. SEG3001J-002, 014, 016
4. CA3007-003, 004
5. SEG3001Y- 004, 011, 046, 053
6. SEG3001Z- 004, 011, 046, 053

Description of Incident: During the Quality Assurance Ultrasonic Testing (UT) verification of weld located on OBG Segment 12AE, this Quality Assurance Inspector (QA) discovered that one (1) Class “A” indication measuring approximately 20mm in length. The Indication rating is +7dB and length approximately 20mm. The nominal thickness of the plate is 16mm and depth of the indication approximately 13mm. The indication is located on the weld joint identified as SEG3001AL-007. The “Y” location for this indication is approximately 1770mm

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from panel point 110 east side. The weld is a Complete Joint Penetration (CJP) butt joint joining side plate (SP3001B) to corner assembly side plate (SP3002B). The ZPMC QC is identified as Mr. Wang Wei Ming. The indication is clearly marked by QA on/near the weld. This weld is designated as Seismic Performance Critical Member (SPCM). OBG Segment 12AE is located in outside yard (west side of Blast Shop 1). The indication is located within the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. As per the contract documents, ZPMC's QC personnel are required to perform 100% UT inspection of this weld.

Ultrasonic Testing (UT) – NWIT Document No: 007029

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Suspender Bracket. The weld designations reviewed are as follows:

1. BK4ASD1-011-001,002,003,004,022,023,024,027

Magnetic Particle Testing (MT) – NWIT Document No's: 007029

This QA inspector performed 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 members are identified as OBG Bike Path. The weld designations reviewed are as follows:

1. BK004A8-011-001,002,007,130
2. BK004A1-011-016,019,020,023,026
3. BK004A6-011-001,002,007,165

Magnetic Particle Testing (MT) – NWIT Document No's: 006859

This QA inspector performed 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 members are identified as OBG Bike Path. The weld designations reviewed are as follows:

1. BK004A3-006-002,019,030,031,046,057,059,060
2. BK004A4-006-005,020,033,045,046,050,056,057,060,072,074
3. BK004A8-006-023,200,212,072,073,033,205,160,207,073,121,127,038
4. BK004A4-006-080,100,083,102,082,101,085,103,086,104,087,105
5. BK004A8-006-004,006,009,011,025,027,037,039

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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

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remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Vibin	Quality Assurance Inspector
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Reviewed By:	McClendon,Timothy	QA Reviewer
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