

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-019865**Date Inspected:** 05-Jan-2011**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:** OBG**Summary of Items Observed:**

CWI Inspector: Mr. Yu Jiao

On this date CALTRANS OSM Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai China, for the purpose of monitoring welding and fabrication.

OBG Bay 2

Segment 14 West

ZPMC presented QA personnel with "Notification of Witness Inspection" document number 8050 item 1 that stated ZPMC was requesting Caltrans to perform visual and magnetic particle (MT) inspections of OBG segment 14W Anchor Plate welds in Bay 2.

This QA Inspector performed random visual and magnetic particle (MT) inspections of the following anchor plate welds:

AP3032-001-142~161, 282, 303~306, 327, 348~351, 372, 393~395, 417, 383, 439, 1030, 441, 462, 483~486, 507, 528~531, 552, 573~576, 597, 618~621, 643, 666~669, 691, 714~717, 739, 762~765, 787, 810~813, 835, 858~861, 883, 906~909, 931, 954~957, 979, and welds 1002~1005.

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Other Caltrans QA Inspectors performed MT inspections of similar welds on segment 14W Anchor Plate welds. This QA Inspector observed many of the weld terminations and cope holes were visually rejectable due to weld overlap, rough surfaces and underfill. Items observed by this QA Inspector appeared to comply with AWS D1.5 MT requirements. For additional information on these inspections see this QA Inspector's TL6028 Magnetic Particle Test Report and the photograph below.

OBG Bay 14

Segment 13 West

ZPMC presented QA personnel with "Notification of Witness Inspection" document number 8058 item 1 that stated ZPMC was requesting Caltrans to perform visual and magnetic particle (MT) inspections of OBG segment 13W longitudinal diaphragm to deck plates DP3149-001, DP3150-001, DP3151-001, DP3152-001 and DP3153-001 welds in Bay 14.

This QA Inspector performed random visual and magnetic particle (MT) inspections of the following welds:

DP3149-001-008,009, 014, 018, 019, 022, 025, 026, 027, 030, 033, 036, 037, 040, 043, 044, 045, 048, 051, 052, 056, 057

DP3150-001-008,009, 014, 018, 019, 022, 025, 026, 027, 030, 033, 036, 037, 040, 043, 044, 045, 048, 051, 052, 056, 057

DP3151-001-008,009, 014, 018, 019, 022, 025, 026, 027, 030, 033, 036, 037, 040, 043, 044, 045, 048, 051, 052, 056, 057

DP3152-001-008,009, 014, 018, 019, 022, 025, 026, 027, 030, 033, 036, 037, 040, 043, 044, 045, 048, 051, 052, 056, 057

Other Caltrans QA Inspectors performed MT inspections of similar welds on these and other deck plates. Items observed by this QA Inspector appeared to comply with AWS D1.5 MT and VT requirements. For additional information on these inspections see this QA Inspector's TL6028 Magnetic Particle Test Report and the photographs below.

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Summary of Conversations:

See 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 James Devey +8615000026784, who represents the Office of Structural Materials for your project.

Inspected By: Dawson,Paul

Quality Assurance Inspector

Reviewed By: Riley,Ken

QA Reviewer