

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-020878**Date Inspected:** 01-Feb-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:** OBG & Tower**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Mike Hasler was present during the times noted above for observations relative to the work being performed.

Facility / Fabrication Surveillance Inspection: Bay 9, 13, 14 and Lift 1 Tower @ Heavy Loading Dock

This Caltrans QA inspector performed walk through inspection at the above mentioned locations. To assure that materials and workmanship conform to the requirements of the contact documents. This QA inspector observed no work being performed on the Caltrans Project.

Segment Name: OBG Cantilever Box Bracket Beams/ Bay 7

This Caltrans QA inspector observed Flux Cored Arc Welding (FCAW) in progress. Welder is identified as #053609 welding B-WR10545 repair weld in the 2G position using WPS-345-FCAW-2G(2F)-Repair-1. The weld is identified as 11TR3-025-014. ZPMC QC inspectors are identified as Mr. Wang Liang and CWI, Mr. Li Jia. The welding variables recorded by QC appeared to comply with the WPS.

OBG Segment Name: 6AE DP to EP-E5 / Trial Assembly

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. The welds tested were scanned with Pattern "D" only in locations where flush grinding was present. All rejectable Indications were recorded on a data sheet that ABF and Caltrans QA generated after performing a joint inspection. The members are identified as the Edge to deck plate splice welds at E5 for segment 6AE. The weld designations are as follows:

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This Caltrans QA inspector performed UT inspection using the conventional scan pattern A, B, C, and "D" per ABF Verification Witness Request #02012010-1 Item 1, weld repair, 6AE DP to EP-E5. QAMT/VT was not performed, due to the surface condition of the plate having coupling on it from ABF UT inspection. See Segment Splice NDT Tracking, dated 02-01-2010 and Caltrans Ultrasonic Test Report (TL6027), dated 02-01-10 for additional information.

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

Summary of Conversations:

“As noted within the contents of this report.”

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 1500026784, who represents the Office of Structural Materials for your project.

Inspected By:	Hasler, Mike	Quality Assurance Inspector
Reviewed By:	Riley, Ken	QA Reviewer
