

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-021985**Date Inspected:** 14-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: Mr. Lv Li Qing
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: Yes No N/A
Verified Joint Fit-up: Yes No N/A
Approved WPS: Yes No N/A
Delayed / Cancelled: Yes No N/A

Bridge No: 34-0006**Component:** BAY14 OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Robert A. DeArmond was present during the time noted above and conducted observations relative to the work being performed.

BAY 14

Magnetic Particle Testing (MT)

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. All components were as listed on NWIT notification no. 08545. The member(s) is/are identified as Floor Beam Diaphragm to Deck Plate and U-Rib. The weld designations reviewed are as follows:

DP3174-001-166~175, 178~181, 186~189, 194~197,

202~205, 395~396, 397~399, 120~129, 132~135, 140~143,

148~151, 156~159, 074~083, 086~089, 094~097, 102~105,

110~113, 040~043, 048~051, 056~059, 064~067

DP3173-001-108~151, 156~159, 209~212, 217~220

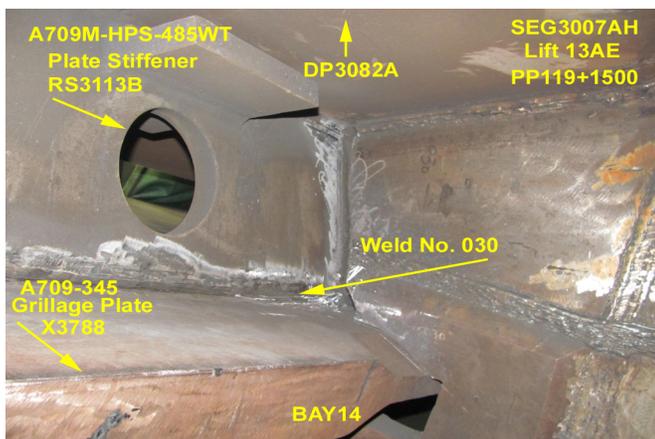
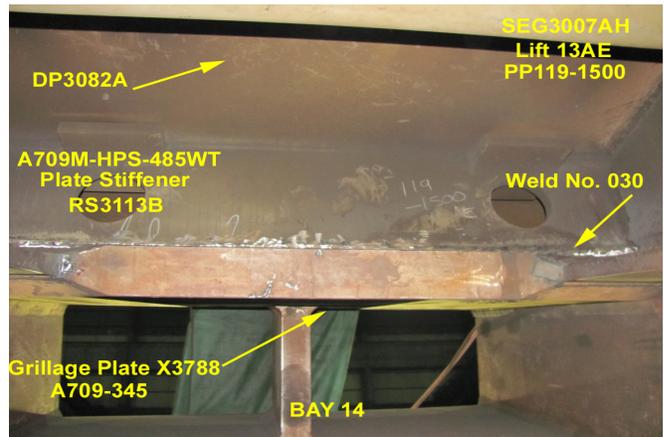
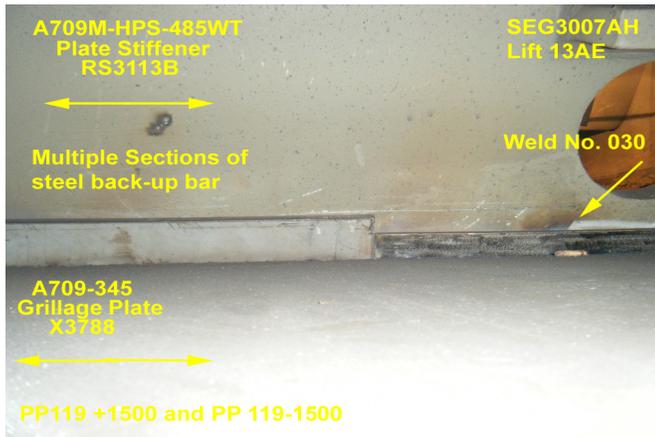
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During a random in process inspection of Orthotropic Box Girder (OBG) Grillage and Plate Stiffener, this Caltrans Quality Assurance (QA) Inspector observed ZPMC welding personnel perform Flux Cored Arc Welding (FCAW) using a WPS that is not approved for the joint being welded as well as utilizing multiple sections of un-welded spliced steel back-up bar. The welding was being performed to WPS-B-T-2132-ESAB which specifies A709-345 to A709-345 material using filler metal brand ESAB Dual Shield 70 Ultra Plus with classification E71T-1M/T-9M. The material being welded was A709-345 to A709-HPS-485. The welds are Complete Joint Penetration T-joint welds, joining Seismic Performance Critical Material (SPCM) Grillage Plate identified as X3788 to plate Stiffener identified as RS3113B. The weld joints are identified as SEG3007AH-030. The segment and Panel Point is 13 AE, PP119 +1500 through PP119-1500. The thickness of the material is 35 mm and 100mm.

This QA Inspector generated an incident report on this date for the above issue, for further information see the incident report and attached photos.

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



Summary of Conversations:

As mentioned above 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 Jim Devy 150-002-6784, who represents the Office of Structural Materials for your project.

Inspected By:	DeArmond,Robert	Quality Assurance Inspector
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Reviewed By:	Riley,Ken	QA Reviewer
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