

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-022989**Date Inspected:** 22-Apr-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:** 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:**

Bay 8

MT Inspection

This Caltrans QA inspector received ZPMC non-destructive test (NDT) Inspection Notification, Doc. #08902 from ZPMC for Bay 8. This QA inspector performed visual and magnetic particle test (MT) verification for Item 1, 2, 3, 4 after ZPMC had performed their MT inspection of the following locations;

Item 1

LB3100-001-037, 051, 061, 042, 043, 056, 057

Item 2

LB3001-001-037, 051, 061, 042, 043, 056, 057

Item 3

LB3001A-001-001

Item 4

LB3100A-001-001

At the time of the verification it was noted that the above component appeared to be within compliance of the contract documents. See Caltrans Magnetic Particle Test Report (TL6028), dated 04-22-2011 for additional information.

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The following digital pictures illustrate MT inspected subassemblies.

Bay 14 (14E)

UT Inspection

This Caltrans QA inspector received ZPMC non-destructive test (NDT) Inspection Notification, Doc. #08905 from ZPMC for QAUT verification for segment 14E. This QA inspector performed ultrasonic test (UT) verification, after ZPMC had performed their UT inspection of the following locations.

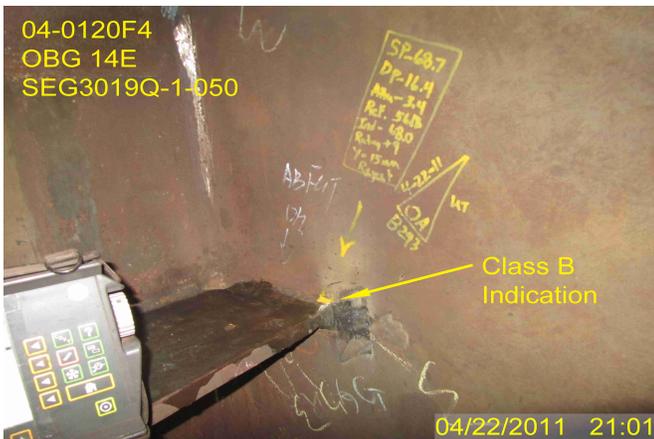
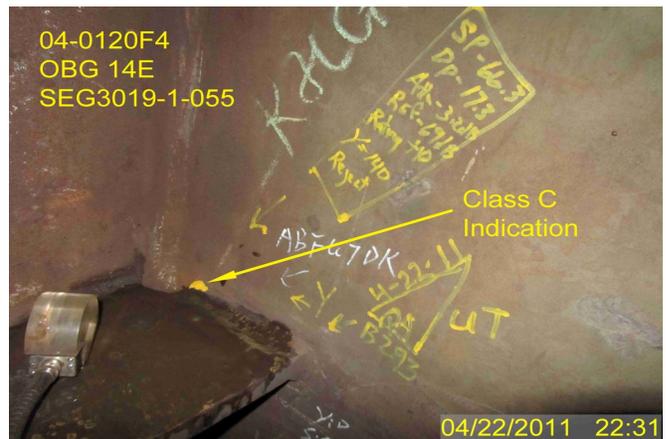
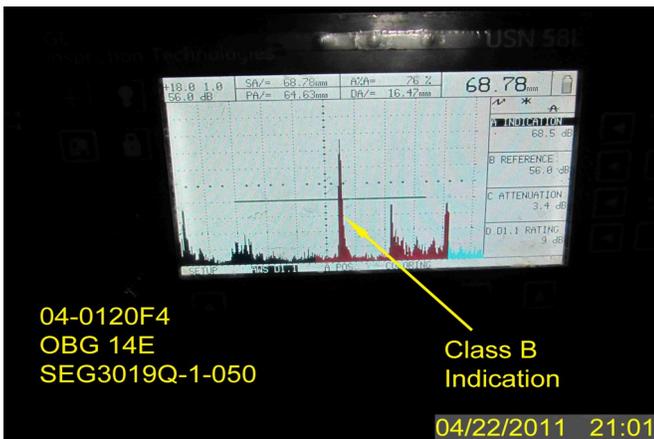
Item 1

SEG3019Q-056, 059, 042, 044, 046, 050, 055, 057, 060, 247, 248, 250, 251, 252, 253

At the time of the verification it was noted that the above component welds SEG3019Q-050 and 055 were found unacceptable in accordance with AWS D1.5 UT Acceptance-Rejection Criteria, Table 6.3. This QA inspector generated an Incident Report (IR) non-compliance welds. See Caltrans Ultrasonic Test Report (TL6027) and Caltrans Incident Report, dated 04-22-2011 for additional information.

The following digital pictures illustrate SEG3019Q-050, 055, QAUT verification.

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



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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 15000026784, who represents the Office of Structural Materials for your project.

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