

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-023157**Date Inspected:** 28-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:	NA	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 and testing relative to the work being performed.

Blast Shop 2

This QA inspector performed pre-blast visual inspection on external welds/ surfaces East Tower, Lift 6 Head Cover. Defects requiring grinding, welding and magnetic particle test (MT) were identified and reported to ZPMC/ ABF inspectors for rework.

The following digital picture illustrates East Tower Lift 6 Head Cover in Blast Shop 2.

Bay 8**MT Inspection**

This Caltrans QA inspector received ZPMC non-destructive test (NDT) Inspection Notification, Doc. #08972 from ZPMC for Bay Trial Assembly segment 13AE. This QA inspector performed visual and magnetic particle test (MT) verification for Item 1, 5 & 7 after ZPMC had performed their MT inspection of the following locations;

Item 1

SEG3007B-155, 153, 151, 149, 145, 143

Item 5

SEG3007F-070, 071, 073, 074, 076, 077, 079, 080, 022, 016, 010, 020, 012

WELDING INSPECTION REPORT

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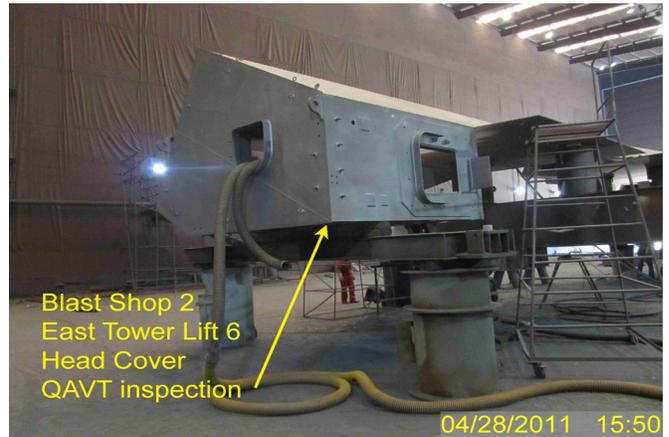
Item 7

SEG3007V-484, 485, 486, 487, 488, 489

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 04-28-2011 for additional information.

The following digital pictures illustrate SEG3007F-079, 080 inspected welds.

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

Inspected By: Hasler, Mike

Quality Assurance Inspector

Reviewed By: Riley, Ken

QA Reviewer