

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-024047**Date Inspected:** 27-May-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:	N/A	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:

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 of the San Francisco / Oakland Bay Bridge (SFOBB) components. This QA Inspector observed the following:

OBG Trial Assembly

ZPMC issued "Inspection Notification Sheet" (NWIT) number 09278 informing Caltrans QA that ZPMC is requesting ultrasonic inspections (UT) of various OBG segment complete joint penetration welds in the trial assembly area. This QA Inspector performed random visual and ultrasonic inspections of the following welds: SEG3020T-143 visual rejection

Item #1 welds: SEG3009C-315, 316, 317

Item #2 welds: SEG3009G-306, 307, 309

Item #3 welds: SEG3009G-314, 315, 316

Item #4 welds: SEG3009J-314, 315, 316

Item #5 welds: SEG3011L-239, 240 (note: ZPMC QC changed weld number on NWIT from SEG3009L-239, 241 to SEG3011L-239 and 240.)

Item #21 welds: SEG3020T-128, 133, 148, 153 See below for information concerning weld SEG3020T-143 which was visually rejected.

Item #22 welds: SEG3020T-129, 134, 139, 144, 149, 154, 130, 140, 145, 150, 155

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Item #23 welds: SEG3020AL-064, 066, 068, 070, 072, 074, 076, 078, 080, 082, 084, 086, 088, 090, 092, 094

Item #24 welds: SEG3020R-101, 106, 111, 116, 121, 126

Item #25 welds: SEG3020R-099, 104, 109, 114, 119, 124

Item #34 welds: SEG3013AH-036, 083

This QA Inspector performed random visual and ultrasonic inspections of approximately 15% length of areas previously tested by ZPMC / ABF personnel and items observed by this QA Inspector appear to comply with AWS D1.5 UT requirements. This QA Inspector visually observed weld SEG3020T-143 had was visually rejectable due to having a sharp overlap near the top of the weld. ZPMC QC personnel agreed this weld was visually rejected and no ZPMC personnel were available to grind this weld. Dayshift QA personnel informed this QA Inspector that the weld was ground by day shift personnel and dayshift QA Inspectors visually and ultrasonically accepted this weld. For additional information on these inspections see this QA Inspector's TL6027 Ultrasonic Test Report and the photographs below.



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
