

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024134**Date Inspected:** 28-May-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) Chanxing Island**Location:** Shanghai, China**CWI Name:** Xie Gen Lin**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 13AW**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Dennis Combs, was present during the times noted above for the observations relative to the work being performed.

This Quality Assurance (QA) Inspector has performed documentation review of the Green Tag system utilized by American Bridge/Flour (ABF) and Caltrans METS. This QA Inspector has Identified Complete Joint penetration (CJP), Partial Joint Penetration (PJP), and Fillet Welds in Lift 13BE. He has also verified the Non-Destructive Testing requirements for each weldment that includes the NDT process (UT, MT, and RT) and the percentage required by the contractor to perform. These items are within the Contract special provision, CCO 22 and within compliant of CCO 77. This information has been documented and compiled in a Green Tagging spread sheet that is located on the Caltrans Team China Z; drive.

TRIAL ASSEMBLY YARD

This Caltrans QA inspector received ZPMC non-destructive test (NDT) notification number 09289 from ZPMC for Trial Assembly Yard. This QA inspector performed magnetic particle testing (MT) verification of welds after ZPMC had performed their MT inspection. The segment is identified as OBG 13AW. The weld designations reviewed are as follows.

SEG3013K-003, 026, 051, 052, 054, 055, 056, 059, 060, 062~064, 066~068, 070~072, 074~076, 078~080, 082~084, 086~088, 090~093, 096, 097, 099, 100, 103, 123, 125, 127~129, 133.

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This Caltrans QA inspector received ZPMC non-destructive test (NDT) notification number 09290 from ZPMC for Trial Assembly Yard. This QA inspector performed magnetic particle testing (MT) verification of welds after ZPMC had performed their MT inspection. The segment is identified as OBG 13AW. The weld designations reviewed are as follows.

SEG3013K-021, 022, 025

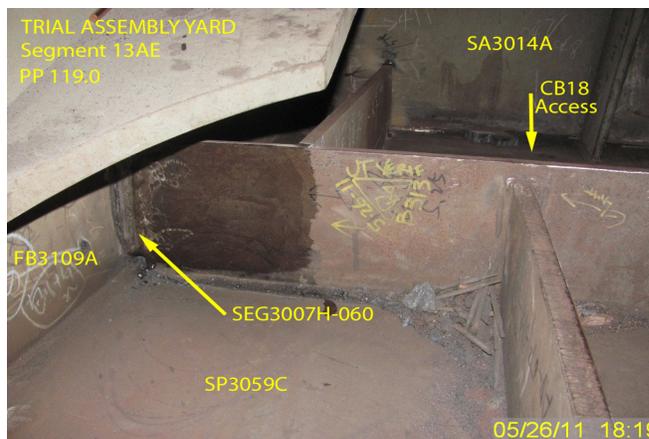
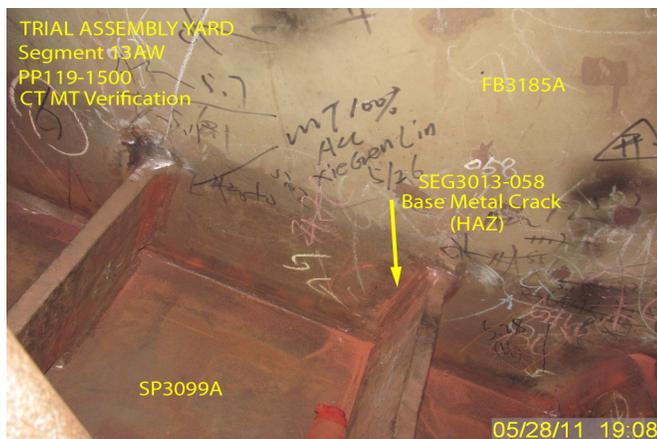
SEG3013M-012, 016, 017, 018

SEG3013P-002, 003, 004, 005

SEG3013R-002, 003, 004, 005

This Quality Assurance (QA) Inspector, responding to NDT notification 09289, performed 100% Visual Inspection (VT) and approximately 15% Magnetic Particle Testing (MT) of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. The component OBG 13AW at SEG3013K weld number 058 was found to have an indication 200mm long, 6mm from RS3438A. This QA informed ZPMC QC Inspector Xie Gen Lin and AB Flour QA Inspector Huang Zheng Chao of the problem. A TL-015 Incident Report, and a TL6028 MT report, will be documented for the accordance.

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



Summary of Conversations:

Spoke with ZPMC Xie Gen Lin, and AB/F Huang Zheng Chao concerning MT indication found at SEG3013K-058 at 1930.

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.

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Inspected By: Combs,Dennis

Quality Assurance Inspector

Reviewed By: Riley,Ken

QA Reviewer