

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-024744**Date Inspected:** 11-Jun-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:

Blast shop #4, Segments 13AW, 13BW and 13CW

Caltrans and ABF have agreed to conduct visual and magnetic particle inspections of segment 13AW welds as part of a special reinspection program. This QA Inspector observed ABF performing MT inspections of welds SEG3013AA*-005, 019, 026, 040, 047, 089, 110, 124, 012, 075, 082 and ABF rejected welds SEG3013AA*-043, 044, 047, 048, 049, 052, 053, 054, 057, 058, 059, 060, 062, 063, 064, 065, 067, 068, 069, 070 were MT rejectable. This QA Inspector performed random magnetic particle inspection of the following welds: SEG3013AA*-012, 075, 082 and items observed by this QA Inspector appeared to comply with AWS D1.5 MT requirements. For additional information on these inspections see this QA Inspector's TL6028 Magnetic Particle Test Report.

ABF informed this QA Inspector they have visually rejected welds SEG3013J-040~057 and SEG3013B-039~064 and that they would not be performing magnetic particle inspections of these welds.

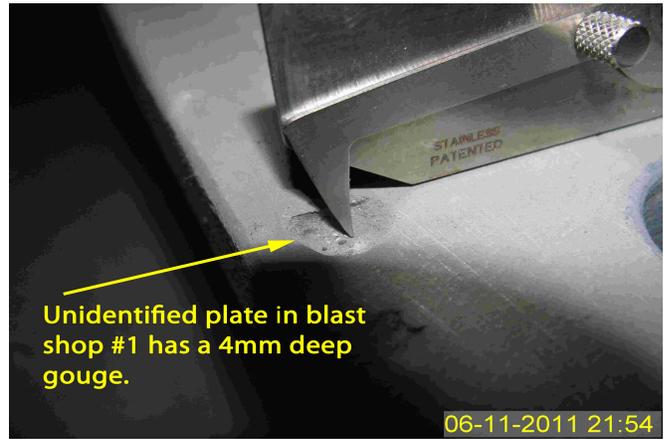
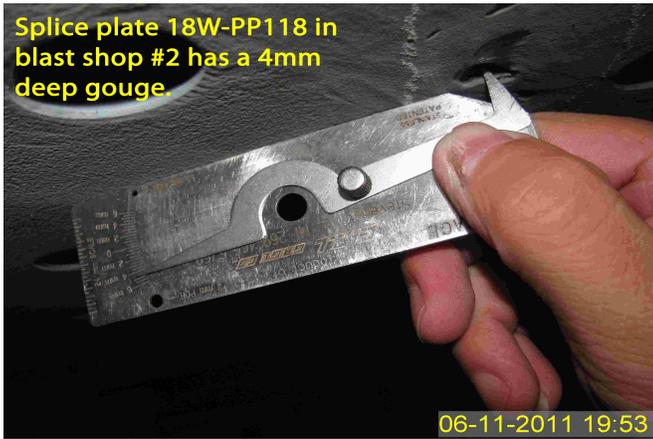
This QA Inspector observed ABF performing MT inspections of welds SEG3013L-045, 046, 050, 051, 055, 056, 066, 070 and ABF informed this QA Inspector that welds SEG3013L-043, 044, 047, 048, 049, 052, 053, 054, 057, 058, 059, 060, 062, 063, 064, 065, 067, 068, 069 and 070 were visually rejectable and were not MT inspected.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

This QA Inspector performed random magnetic particle inspection of the following welds: SEG3013L-045, 046 and items observed by this QA Inspector appeared to comply with AWS D1.5 MT requirements. For additional information on these inspections see this QA Inspector's TL6028 Magnetic Particle Test Report.

Caltrans Coating Inspector Mr. Kenneth Cason identified two splice plates that have gouges in the plates. One of these plates, identification number not available, is located in blast shop #1 and the second plate identified as #18W-PP118 is in blast shop #2. The gouges in each of the two plates have a maximum depth of approximately 4 millimeters. This QA Inspector took digital photographs of these gouges and forwarded the photographs and other information to dayshift personnel for resolution of these problems. See the photographs below for additional information.



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