

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 #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024807**Date Inspected:** 26-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:** 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:**

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:

Bay 14, OBG segment 14W

Caltrans and ABF have agreed to conduct visual and magnetic particle inspections (MT) of segment 14W welds as part of a special reinspection program reference NWIT 9605. This QA Inspector observed ABF Inspectors completed and accepted MT inspections of welds: SEG3020AQ-002, 003, 004, 006, 007, 008, 010, 011, 012, 014, 015 and 016. This QA Inspector performed random visual and magnetic particle inspection of welds: SEG3020AQ-002, 004, 010, 011, 014, 015, 016 and these welds appear to comply with AWS D1.5 MT and visual requirements. For additional information on these inspections see this QA Inspector's TL6028 Magnetic Particle Test Report.

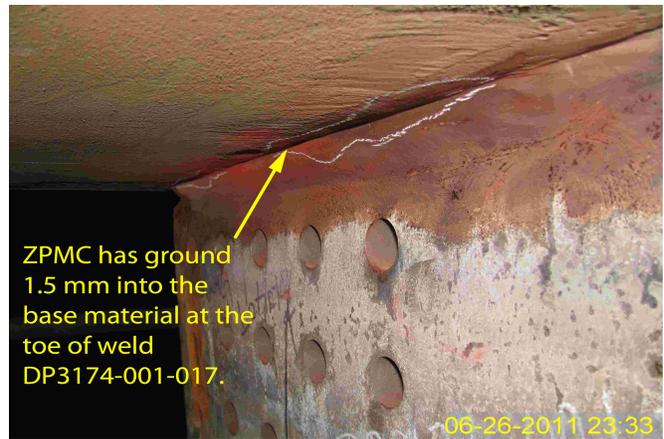
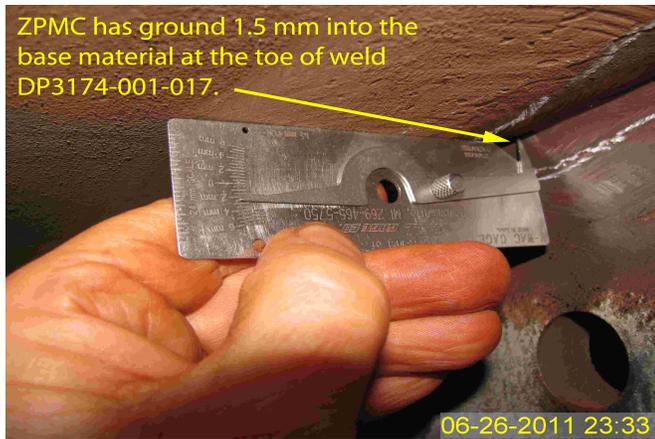
Caltrans and ZPMC have agreed to conduct visual and magnetic particle inspections (MT) of segment 14W welds as part of a special reinspection program reference NWIT 9605. This QA Inspector observed ZPMC Inspectors had completed and accepted MT inspections of welds: SEG3020AP-002, SEG3020AB-028 and SEG3020AV-008. This QA Inspector performed random visual and magnetic particle inspection of welds: SEG3020AP-002, SEG3020AB-028, SEG3020AV-008 and these welds appear to comply with AWS D1.5 MT and visual requirements. For additional information on these inspections see this QA Inspector's TL6028 Magnetic Particle

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Test Report.

ZPMC QC Inspector Mr. Testino requested that Caltrans QA perform magnetic particle (MT) inspections of OBG segment 14W welds SEG3020X-010, SEG3020Z-077, DP3172-001-017 and DP3174-001-017. Mr. Testino said "Inspection Notification Sheet" (NWIT) number 09597 item 2 will be issued for this inspection. This QA Inspector performed random visual and MT inspections of welds SEG3020X-010 and SEG3020Z-077 and these welds appear to comply with project specifications. This QA Inspector visually observed welds DP3172-001-017 and DP3174-001-017 both appear to have grinding gouges at the toe of the welds and that the depth of the gouges appear to exceed 1mm in depth. This QA Inspector informed ZPMC QC Inspector Mr. Testino that both of the welds appear to be visually rejectable and ZPMC performed welding and grinding of both of these welds. This QA Inspector asked several ZPMC inspection personnel if ZPMC QC has visually and MT accepted both of these welds and it appears that no ZPMC CWI is available to visually inspect these welds. For additional information on these inspections see this QA Inspector's TL6028 magnetic particle test report and the photograph 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
