

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-024808**Date Inspected:** 25-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 number 9592. This QA Inspector observed ABF Inspectors completed and accepted MT inspections of the following repaired welds: SEG3020J-048, 067, 072, 078, 079, 080, 081 and 082. This QA Inspector performed random magnetic particle inspection of welds: SEG3020J-048, 067, 072, 078, 079, 080, 081 and 082 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.

Blast bay #1, OBG segment 14E

ABF issued "Inspection Notification Sheet" (NWIT) number 06242011-1 informing Caltrans QA that ABF is requesting ultrasonic (UT) and magnetic particle (MT) inspections of OBG segment 14E complete joint penetration weld SEG3019*-010 on June 25, 2011 at 0200 hours in blast bay #1. This QA Inspector arrived in

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blast bay #1 at approximately 01:30 hours and accompanied ABF inspection personnel to top deck weld SEG3019*-010. This QA Inspector observed this weld has a layer of primer paint on the weld and adjacent surfaces. ABF Inspector Mr. Liu Ching Yang informed this QA Inspector that no ZPMC personnel were available to remove the paint and that he is cancelling this inspection request.

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
