

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-024811**Date Inspected:** 21-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 14West

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 9569.

This QA Inspector observed ABF Inspectors completed and accepted MT inspections of welds: SEG3020N-003, 005, 007, 008, 009, 010, 017, 021, 028, 029, 034, 035, 036, 037, 038, 039, 040, 041, 042, 045, 046, 047, 048, 049, 051, 052, 053, 055, 103, 104, 105, 124, 125, 139, 140, 141, 142, 177, 179, 180, 181, 183 and 184. ABF Inspectors visually or MT rejected welds SEG3020N-001, 002, 004, 011, 012, 013, 016, 019, 021, 022, 023, 024, 025, 026, 027, 030, 031, 032, 033, 043, 056, 102, 106, 107, 108, 109, 121, 126, 135, 136, 137, 139 and 173. Welds SEG3020N-122 and 123 had been partially welded and approximately 30% of the length of the welds had not been completed. Welds SEG3020N-171, 172, 175, 176 and 182 had ultrasonic couplant over part of the welds that inhibited magnetic particle inspections of the entire weld surfaces. This QA Inspector performed random magnetic particle inspection of welds: SEG3020N-003, 005, 018, 036, 037, 038, 039, 040, 041, 042, 139, 140, 141, 142, 183 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.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

This QA Inspector observed ABF Inspectors completed and accepted MT inspections of welds: SEG3020L-001, 003, 004, 005, 006, 033, 037, 039, 040, 041, 043, 044, 045, 046, 048, 049, 050, 051, 052, 053, 054, 055, 056, 057, 058, 059, 060, 061, 062, 063, 065, 067, 068, 071, 074, 075, 153, 155, 156, 158, 159 and 060. ABF Inspectors visually or MT rejected welds SEG3020L-002, 038, 042, 047, 064, 066, 069, 070, 072, 073, 076, 102, 154, 157 and 163. This QA Inspector performed random magnetic particle inspection of welds: SEG3020L-004, 033, 053, 054, 055, 056, 057, 061, 063, 067, 075, 158 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.

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
