

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-024814**Date Inspected:** 27-Jun-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), 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:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Mike Hasler was present during the times noted above for observations and testing relative to the work being performed.

Bay 10

This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of grinding exterior welds and surfaces on bike path assembly BK11A and BK12A. ZPMC CWI inspector Yu Dong Ping was present at this time of this observation and informed this QA inspector of the work that is in process. It was stated that ZPMC would not be performing welding in Bay 10 during this work shift.

Bay 14**MT Inspection**

This Caltrans QA inspector received ZPMC non-destructive test (NDT) NWIT #09606 Item 5 for fabricated splice plate assemblies, Bay 14. This QA Inspector performed Visual Testing (VT) and verification Magnetic Particle Testing (MT) inspection after ZPMC had performed their MT inspection of the following locations;

Item 5: SA3020-005-001, 003, 005, 006; SA3020-004-001, 003, 005, 006; SA3020-006-001, 003, 005, 006

At the time of the verification it was noted that the above component appeared to be within compliance of the contract documents. See Caltrans Magnetic Particle Test Report (TL6028), dated 06-27-2011 for additional information.

WELDING INSPECTION REPORT

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UT Inspection

This Caltrans QA inspector received ABF UT inspection report UT-14W-010R1, dated 6-27-11 for QA verification. The OBG assembly is identified as OBG segment 14W, Blast Shop 1. This QA inspector performed ultrasonic test (UT) using “D” scan pattern, after ABF had performed their UT inspection of the following locations.

Bottom Plate to Side Plate (W4)
SEG3020A-002

At the time of the verification it was noted that the above component appeared to be within compliance of the contract documents. See Caltrans Ultrasonic Test Report (TL6027), dated 06-27-2011 for additional information. The following digital picture illustrates UT inspection of the weld.

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



Summary of Conversations:

“As noted within the contents of this report.”

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.

Inspected By: Hasler, Mike

Quality Assurance Inspector

Reviewed By: Riley, Ken

QA Reviewer