

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024830**Date Inspected:** 30-Jun-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. Shi Lei**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 Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA), Vibin Kumar Selvanayaham, was present during the times noted above for observations relative to the work being performed.

Visual Inspection after Blast

OBG Segment 14W

This QA Inspector performed a preliminary random visual inspection on OBG Segment , after the grit blast of the exterior components of the deck panel, Deck Panel Diaphragm, SA3416A , SA3416C, floor beams and side plate of this OBG Segment 14W. Areas of visual weld defects that will require welding were taped and will be repaired after the coating is applied. ZPMC QC personnel are aware of these areas and were present during the inspection.

OBG Segment 14W

Visual inspection after the blasting: During random Quality Assurance Visual review of welds located on OBG Segment 14W, this Quality Assurance Inspector (QA) observed following details:

- At PP 128.3 cross beam side near SA3416C, base metal repair need to be done on Deck Panel Diaphragm.
- At PP128.3 cross beam side, two base metal gouge was visibly observed on the SA3416C.
- At PP128.7 middle, temporary attachment was not yet removed on SA3416A.
- In between PP125 and PP127 cross beam side, total four (4) areas temporary attachment area need to be repair on

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

the Deck Plate (DP3183A).

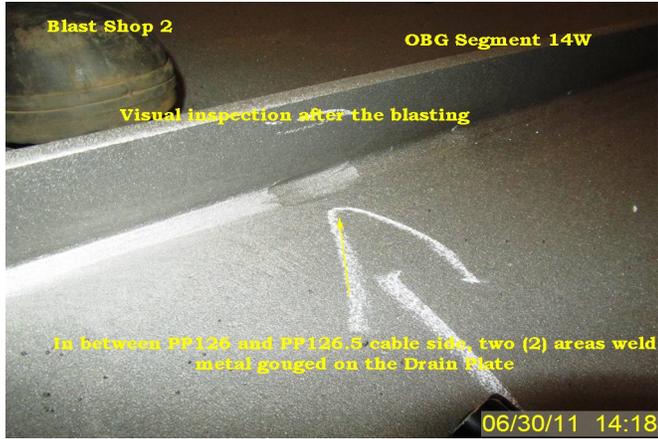
- In between PP126.5 and PP127.5 cross beam side, one base metal gouge and one temporary attachment was not removed on the Deck Plate (DP3177A). Areas were taped prior to blast and paint.
- In between PP127.5 and PP128.3 cross beam side, three (3) foreign metal inclusion observed on the Deck Plate (DP3176A). Areas were taped prior to blast and paint.
- In between PP126 and PP126.5, one base metal gouge was visibly observed on the Deck Plate (DP3174A).
- In between PP125 and PP126, one (1) area temporary attachment area need to be repair on the Deck Plate (DP3173A).
- In between PP126 and PP126.5, one base metal gouge was visibly observed on the Deck Plate (DP3172A).
- In between PP125 and PP125.5 cross beam side, one (1) foreign metal inclusion observed on the Deck Plate (DP3171A) between W3 and W20 locations. Areas were taped prior to blast and paint.
- At PP 125, one base metal gouge was visibly observed on the Deck Plate (DP3170A).
- In between PP124.5 and PP126, two (2) base metal gouge was visibly observed on the Deck Plate (DP3169A).
- At PP 125, one (1) area temporary attachment area need to be repair on the Deck Plate ((DP3169A).
- In between PP126 and PP126.5 cable side, two (2) areas weld metal gouged on the Drain Plate.
- In between PP127 and PP128 cross beam side, four (4) areas temporary attachment area need to be repair on the side plate (SP3143A and SP3142E).
- In between PP127 and PP128 cross beam side, one base metal gouge was visibly observed on side plate (SP3142E).
- In between PP127 and PP128 cross beam side, scattered porosity observed on side plate (SP3143A). Areas were taped prior to blast and paint.
- At PP 127 cross beam side, scattered porosity observed on floor beam outside 2rd stiffener to floor beam (FL3). Areas were taped prior to blast and paint.
- In between PP127 and PP128 cable Side, four (4) areas temporary attachment area need to be repair on the side plate (SP3133A and SP3134A).
- At PP 128.7 middle, one base metal gouge was visibly observed on floor beam.
- At PP 128.7 cross beam side, one (1) area need to be welded on side plate to edge plate.
- For further information, please see the attached picture

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

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 , who represents the Office of Structural Materials for your project.

Inspected By: Kumar,Vibin

Quality Assurance Inspector

Reviewed By: Patel,Hiranch

QA Reviewer