

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024835**Date Inspected:** 23-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.

Magnetic Particle Testing (MT)

This QA inspector witnessed and performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as OBG Segment 14W.

The weld designations reviewed/witnessed are as follows:

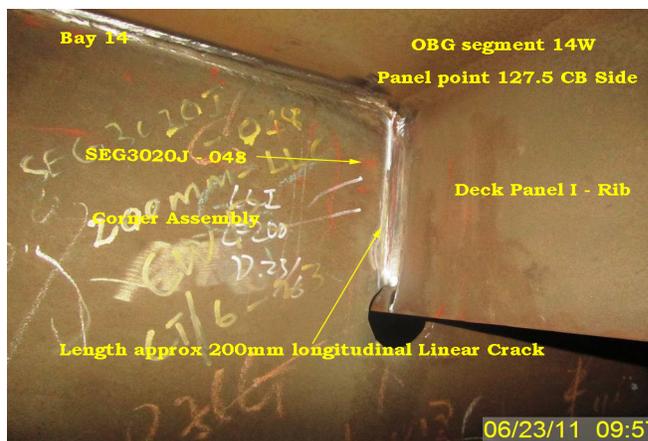
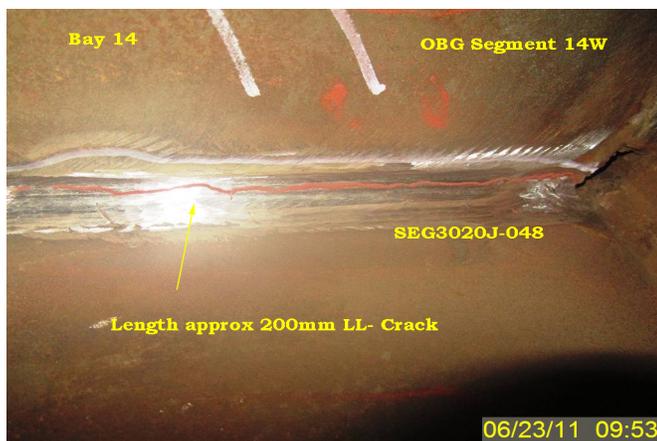
1. SEG3020J – 013, 018, 021, 022, 103, 014, 015, 019
2. SEG3020J – 023, 024, 043, 044, 049, 050, 025, 026
3. SEG3020J – 083, 084, 027, 028, 085, 086, 087, 088
4. SEG3020J – 039, 040, 041, 042, 045, 046, 047, 051
5. SEG3020J – 053, 054, 029, 031
6. SEG3020M – 014, 200, 201, 202, 203
7. SEG3020R – 035, 036, 037, 038
8. SEG3020L – 025, 170, 171, 172, 173
9. SEG3020L – 030, 179, 180, 181, 182
10. SEG3020M – 192, 193, 194, 195, 196, 197, 198, 199

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Description of Incident: During random Quality Assurance Visual review of welds located on segment 14W, this Quality Assurance Inspector (QA) discovered one (1) longitudinal linear indications measuring approximately 200mm in lengths. The indications were discovered visually and confirmed by Magnetic particle Testing (MT) by ABF and Caltrans QA. The indications are clearly marked on the material near the weld. The weld number is identified as SEG3020J-048. The panel point is identified as a PP127.5 cross beam side. This weld is a Fillet weld joining the Floor beam/corner assembly to deck panel I-rib. The Floor beam/corner assembly to deck panel I-rib weld is identified as Non SPCM. The ZPMC QC is identified as Mr. Zhu Lin. Caltrans QA requested to ZPMMC QC, perform the repair weld with comply proper documents. For further information, please see the attached pictures

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



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
