

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-024905**Date Inspected:** 02-Jul-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), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	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:	Orthotropic Box Girder (OBG)	

Summary of Items Observed:

On this day CALTRANS OSM Quality Assurance (QA) Inspector Manoj Prabhune was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector randomly observed the following work in progress:

Blast Shop – 2

14 West

This QA Inspector performed Blast inspection on base metal, fillet welds and complete joint penetration (CJP) welds from panel point (PP) 125 to PP128.7 on internal surface of vertical plate, side panel, edge panel and bottom panel, Bottom plate T-rib, Side plate I-rib. Following points were noted after Blast Inspection:

At PP128.7 (W) counter weight side, no welding on edge plate (EP3029A) to floor beam (FB3345A). See attached photo for further details.

At PP 128.7, cluster porosity on weld SP to 5th I-rib from W16 location.

Near PP128 west side, porosity observed at three locations on SP to I-rib (5th, 6th and 10th I-rib from W19

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location) weld.

At PP 127 East side, Weld joint number SEG3020AZ-422 slag and temporary attachment were not removed properly at underneath of weld.

At PP127.5 west side, weld joint number SEG3020AZ-418 welding incomplete.

At PP 127.5 west side, weld joint number SEG3020AZ-416 slag not removed properly at underneath of weld joint.

In between PP 128 to PP 128.3, splice plate X4962C base metal damaged in between 11th and 12th stiffener from W16 location.

At PP 128.3 east side, deep gouge on weld joint number SEG3020E-051 near 6th I-rib from W4 location.

At PP 128 west side, base metal gouged on FB3341A near W4 location.

At PP127 (E) cable side, deep gouges on FB3327A near W3 location.

At PP 127 (E) cross beam side, SP to I-rib (1st, 4th, 5th and 6th from W4 location) welding incomplete.

At PP126 (W) cross beam side, an incomplete welding on the Floor Beam (FB3321A) to side plate (SP3141C).

In between PP125 and PP125.5 cross beam side, a base metal gouge was visibly observed on the Side Plate (SP3141B).

At PP125.5 (E) cross beam side, a dent on the Side Plate (SP3140B)

In between PP125 and PP124.5 cross beam side, a base metal gouge was visibly observed on the Bottom Plate (BP3094A).

At PP125.5 (E) cross beam side, a base metal gouge was visibly observed on the Side Plate (SP3140A).

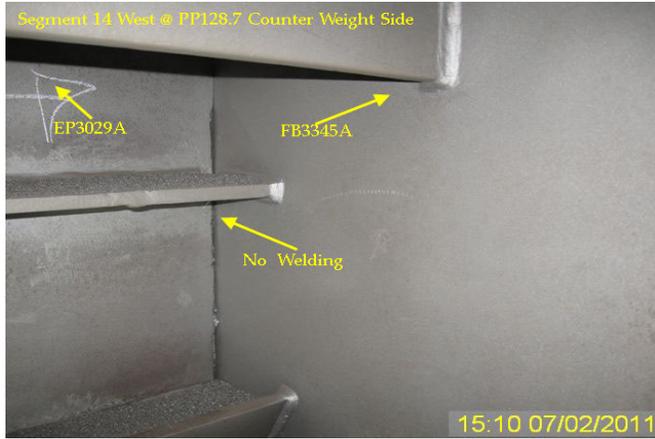
In between PP125 and PP124.5 cross beam side, four locations base metal gouge was visibly observed on the Edge Plate (EP3030A).

All information regarding this marked on weld map and submitted to Lead QA Inspector.

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

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Summary of Conversations:

No significant conversations were reported on this date.

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:	Prabhune,Manoj	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer
