

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-025063**Date Inspected:** 05-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 today morning after Blast Inspection of 14 West:

- At PP128.3 (W) near SEG3020D-233, 237 welds, two locations base metal deep gouge was visibly observed on the Bottom Plate (BP3091A) to Floor Beam (FB3343A).

- At PP127.5 (W) near SEG3020H-045 weld, three (3) porosity observed on Longitudinal Diaphragm (LD30050A) to Floor Beam (FB3334C). Areas were taped prior to blast and paint.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

- At PP127 (E)-SEG3020H-031, near to cope hole location base metal deep gouge was visibly observed on Floor Beam (FB3330A) to Longitudinal Diaphragm (LD3051A).

- In between PP127.5 to 127, base metal deep gouge was visibly observed on Bottom Plate (BP3092A). Areas were taped prior to blast and paint.

- At PP127 (W) near SEG3020L-094 weld, base metal deep gouge was visibly observed on Bottom Plate (BP3091A)

- At PP127 (W) near SEG3020L-106 weld, base metal deep gouge was visibly observed on SA8502A.

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

NDT:

Segment 13AE

This QA Inspector performed Magnetic Particle Testing (MPT) Verification Inspection of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report on this date. The members are identified as Orthotropic Box Girder (OBG) components. The weld designations Verified are as follows.

SEG3007AH-086

SEG3007Z-03

SEG3007G-012, 213

SEG3007S-052, 053

SEG3007L-048, 049, 119

SEG3007C-235, 261, 310

265, 267, 269, 173, 437

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

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.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By: Prabhune,Manoj

Quality Assurance Inspector

Reviewed By: Peterson,Art

QA Reviewer