

**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-025108**Date Inspected:** 15-Jun-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	N/A	<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes No N/A	<b>Rod Oven in Use:</b>	Yes No N/A	
<b>Electrode to specification:</b>	Yes No N/A	<b>Weld Procedures Followed:</b>	Yes No N/A	
<b>Qualified Welders:</b>	Yes No N/A	<b>Verified Joint Fit-up:</b>	Yes No N/A	
<b>Approved Drawings:</b>	Yes No N/A	<b>Approved WPS:</b>	Yes No N/A	
		<b>Delayed / Cancelled:</b>	Yes No N/A	
<b>Bridge No:</b>	34-0006	<b>Component:</b>	OBG Components	

**Summary of Items Observed:**

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

## Bay 14

Caltrans and ABF have agreed to conduct visual and magnetic particle (MT) inspections of welds as part of a special joint re-inspection program. In response to ZPMC NDT Inspection Notification Sheet (NWIT) #09479 for magnetic particle testing (MT) inspection of the following:

This QA Inspector performed random visual testing (VT) and then MT of approximately 15% of the area previously tested and accepted by ABF Quality Control personnel. This QA Inspector generated an MT report for this date and provided a turnover to dayshift personnel for tracking of these welds. The members were identified as follows:

OBG Segment 14W, SEG3020V. The weld designations reviewed was: 151, 157, 161, 091, 093. No apparent MT indications were observed.

Weld joints SEG3020V-146, 148, 150, 154, 156 were also listed on NWIT #9479, but were rejected by ABF inspectors due to fit lugs tack welded in place and no welds as shown on approved on plans. See photo below showing fit lug tacked in place, typical of the 5 above noted weld joints. Weld joint SEG3020V-095 was also listed on NWIT #09479, but was rejected by ABF inspectors due indications observed. Weld joints SEG3020V-146, 148, 150, 154, 156, 095 were not reviewed by this QA Inspector.

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# WELDING INSPECTION REPORT

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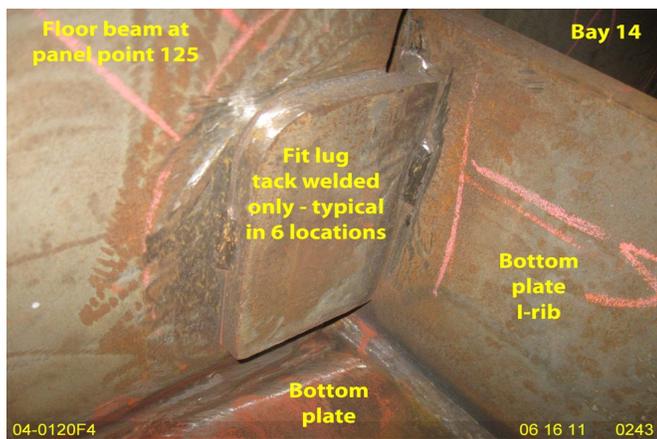
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Weld joints SEG3020W-040, 044, 046, 048, 050, 052, 062, 064, 066, 068, 070, 072, 074, 076 were also listed on NWIT #9479, and accepted by ABF inspectors. Weld joints SEG3020W-038, 042, 054 were also listed on NWIT #09479, but were rejected by ABF inspectors due indications observed. Weld joint SEG3020W-061 was also listed on NWIT #9479, but was rejected by ABF inspectors due to fit lug tack welded in place and no weld as shown on approved on plans. Weld joints SEG3020W-040, 044, 046, 048, 050, 052, 062, 064, 066, 068, 070, 072, 074, 076, 038, 042, 054, 061 were not reviewed by this QA Inspector.

Several arc strikes were observed in the area of the above noted welds. This QA Inspector marked the arc strikes for grinding and MT and informed ABF inspectors who also observed the arc strikes.

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



### Summary of Conversations:

As noted above.

### 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.

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<b>Inspected By:</b>	Goulet, George	Quality Assurance Inspector
<b>Reviewed By:</b>	Riley, Ken	QA Reviewer

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