

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025143**Date Inspected:** 09-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**CWI Name:****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**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector R. Hernandez was present during the time noted above and conducted observations relative to the work being performed.

The QA Inspector randomly observed the following work in progress:

Trial Assembly 13E

This QA Inspector witnessed the in-process high strength bolt installation on bolts connecting the Rib stiffeners to rib stiffeners at the transverse splice between Panel Points (PP) 124 and (PP) 124.5, for Segment 13E. The QA Inspector verified installation of the high strength bolts on a random basis and the results appeared to be in general compliance.

The bolt sizes used were M27-3.0 x 95 RC Lot # DHGM270035.

Trial Assembly CB18

This inspector conducted continuous observation of AB/F QA personnel performing Magnetic Particle Testing (MT) on the following areas as detailed on the report "QA- Post Blast Weld Repair Report" dated 6-18-2011 & 6-19-2011 by D. Sukanthan:

Bottom Plate – Gouge at 5300mm from north end on (BP3055A) and 400 mm from west side plate (SP3066A) of

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CB18.

Bottom Plate – Gouge at 4700mm from south end on (BP3055A) and 480 mm from west side plate (SP3066A) of CB18.

Bottom Plate – Gouge at 1620mm from south end on (BP3055A) and 800 mm from PP118.7of CB18.

Deck Plate – Arc Strike at 3900mm from east end on (DP3113A) of CB18.

CB3002A-018-029

Bottom Plate – Gouge at (BP9001A) between diaphragm-2 (CB3002J) and Diaphragm-3 (CB3002J)

The following items were not inspected:

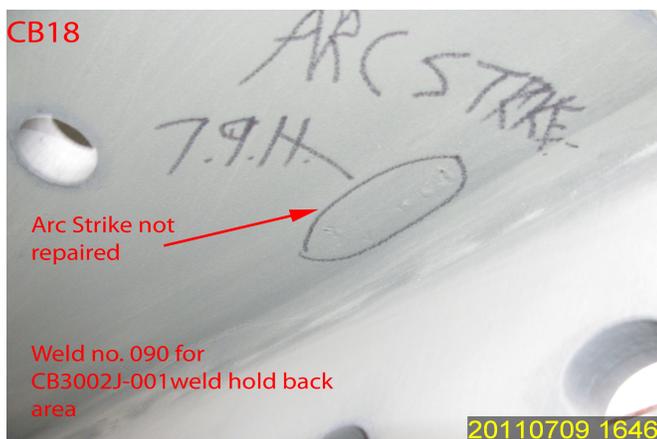
Deck Plate – Gouge at 500mm from south end on (DP3115A) 50mm from west side plate of CB18.

West side plate – Porosity at rib stiffener fillet welds 090 & 092 on weld map CB3002J-001, 6th and 7th rib stiffeners from bottom plate. These welds were not repaired at this time and still require repair and re-inspection.

Deck plate – Porosity at rib stiffener fillet welds 110 & 116 on weld map CB3002J-001, 3rd and 6th rib stiffeners from Side plate. These welds were not repaired at this time and still require repair and re-inspection.

West side plate- Arc Strike at weld 089 on weld map CB3002J-001, 6th rib stiffener from bottom plate. Arc strike was discovered, this arc strike must be repaired and re-inspected by Magnetic Particle testing (MT).

Unless otherwise noted above all items observed on this day appeared to be in general compliance with the applicable contract documents



Summary of Conversations:

Pertinent conversations are included in the body of the report.

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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 Eric Tsang 1500-0042-02372, who represents the Office of Structural Materials for your project.

Inspected By:	Hernandez,Rene	Quality Assurance Inspector
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Reviewed By:	Hall,Steven	QA Reviewer
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