

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-025176**Date Inspected:** 01-Jul-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

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:	OBG	

Summary of Items Observed:

On this date CALTRANS OSM Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. This QA Inspector observed the following:

Caltrans Office

This QA Inspector performed ultrasonic machine "Horizontal Linearity" and "Decibel Accuracy" verifications as specified by AWS D1.5 paragraphs 6.22.1 and 6.22.2. The following Krautkramer ultrasonic machines, models USN58L and USN60 serial numbers 01XD6V, 01X483, 01X846, 01X1P3 and 01WHB1 were calibrated. Note: AWS D1.5 requires these calibration verifications be performed at a time span of every two months. A calibration sticker was completed and attached to each of the ultrasonic machines and a calibration form was completed, signed and filed in the NDE binder, located in the Caltrans office for each of these machines.

Coating of OBG Segments

ZPMC, Coating preparation inspections Blast Bay #4 inspection time 22:30 hours

Notice of Inspection Request number 7255 Item #1: This QA Inspector performed random visual inspections of segment 13W internal west section floor and floor beam vertical surfaces up to approximately one meter from

WELDING INSPECTION REPORT

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PP122.5 to the end of the weld seam prior to application of paint. This QA Inspector along with other QA Inspectors and observed ZPMC has not removed all of the abrasive from the areas to be painted and several areas have not been adequately blasted and they do not appear to comply with project specifications. ABF and ZPMC QC agreed the surfaces require additional blast preparations prior to painting.

OBG segment 14E Coating preparation inspections, Blast bay #1 inspection time 23:00 hours

Notice of Inspection Request number 7255A Item #1: This QA Inspector performed random visual inspections of segment 14E internal east anchor plate ceiling and vertical floor beam surfaces between the anchor plate and the end weld seam. This QA Inspector along with other QA Inspectors observed ZPMC appears to have completed blast preparation of these surfaces and they appear to comply with project specifications. This QA Inspector observed ZPMC QC performing salt tests and profile tests and the results of these test appear to comply with project specifications.

Summary of Conversations:

See 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 Eric Tsang phone: 150-0042-2372 , who represents the Office of Structural Materials for your project.

Inspected By:	Dawson,Paul	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
