

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-025178**Date Inspected:** 30-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**CWI Name:** See Below**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:

Paint Bay #2

ZPMC Coating preparation inspections, inspection time: 20:00 hours

Notice of Inspection 7228: QA witnessed ZPMC performing random primer dry film thickness measurements of item #1: 91 each "L" splices and item #1: 58 each splice plates and items appear to comply with project specifications and items appear to comply with project specifications.

SPMC Blast Bay C

ZPMC Coating preparation inspections, inspection time: 19:00 hours

Notice of Inspection 7229 Item #1: QA performed random visual inspections of 13E internal west section floor and vertical of floor beam from PP118 to PP119-1.5M prior to initial paint application and items appear to comply with project specifications.

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Item #2: ZPMC rejected 13E internal east section floor and vertical of floor beam from PP118 to PP119-1.5M prior to initial paint application. ABF representative Mr. Don Walton informed this QA Inspector that this area will be reblasted and reinspected at a later time.

ZPMC Coating preparation inspections, inspection times: 19:15 hours and 21:30 hours

Notice of Inspection 7230 item #1: ZPMC initially rejected then accepted 13E internal west section floor and vertical of floor beam from PP119+1.5M to PP120 prior to initial paint application and items appear to comply with project specifications.

Notice of Inspection 7230 item #2: ZPMC initially rejected then accepted 13E internal middle section floor and vertical of floor beam from PP119+1.5M to PP120 prior to initial paint application and items appear to comply with project specifications.

Notice of Inspection 7230 item #3: ZPMC initially rejected then accepted 13E internal west section floor and vertical of floor beam from PP119+1.5M to PP120 prior to initial paint application. ABF Inspector Mr. Don Walton informed this QA Inspector that ZPMC is masking off 'minor areas' and the end of the segment, including stiffeners due to inadequate preparation (rusty surfaces) and that these areas would be prepared and painted at a later time.

ZPMC Blast Bay #4

ZPMC Coating preparation inspections, inspection time 22:15 hours

Notice of Inspection 7232 Item #1: ZPMC accepted 13W internal middle section floor beam and vertical of floor beam from PP122.5 to the end of the weld seam, blast surface prior to application of paint and items appear to comply with project specifications.

Blast bay #1, OBG segment 14E

ZPMC requested Caltrans personnel to perform visual inspections of OBG segment 14East bottom plate between the anchor plate at and the weld seam near panel point PP127.5 up to a height of approximately two meters following the initial pre-blast cleaning of the steel surfaces. This QA Inspector along with one other QA Inspector performed random visual inspections of these areas and observed multiple areas that require grinding to remove arc strikes, sharp edges, minor gouges and two areas that require weld repairs. Caltrans QA Inspectors issued a "Blast Inspection" incident report to document the weld repairs. This QA Inspector did not observe any workers performing grinding to blend the areas that had been marked by ABF and QA Inspectors.

Blast bay #4, OBG segment 13AW

ZPMC requested Caltrans personnel to perform visual inspections of OBG segment 13AW interior upper surfaces and adjacent vertical surfaces for a distance of approximately 1.5 meters from the top plate between PP119+1.5m and PP120 following the initial pre-blast cleaning of the steel surfaces. This QA Inspector along with one other QA Inspector performed random visual inspections of these areas and observed multiple areas that require

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grinding to remove arc strikes, sharp edges, minor gouges and observed ABF Inspectors had previously marked two areas at PP120 deck plates DP3124A and DP3123A, reference drawing SEG3013D, that require weld repairs. Dayshift QA Inspectors were provided with photographs of the weld repairs and were informed of the locations of the weld repairs and this information will be added to a tracking database for additional inspections following initial application of paint. See the photographs below for additional information.



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