

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-025229**Date Inspected:** 23-Jun-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island**Location:** Shanghai, China**CWI Name:** Li Yang**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 13BE, 14W**Summary of Items Observed:**

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

This Quality Assurance (QA) Inspector has performed documentation review of the Green Tag system utilized by American Bridge/Flour (ABF) and Caltrans METS. This QA Inspector has Identified Complete Joint penetration (CJP), Partial Joint Penetration (PJP), and Fillet Welds in Lift 13BE. He has also verified the Non-Destructive Testing requirements for each weldment that includes the NDT process (UT, MT, and RT) and the percentage required by the contractor to perform. These items are within the Contract special provision, CCO 22 and within compliant of CCO 77. This information has been documented and compiled in a Green Tagging spread sheet that is located on the Caltrans Team China Z; drive.

This Caltrans QA inspector received ZPMC non-destructive test (NDT) notification number 09568 from ZPMC for Bay 14. This QA inspector performed ultrasonic testing (UT) verification of welds after ZPMC had performed their UT inspection. The segment is identified as OBG 14W. The weld designations reviewed are as follows.

-SEG3020AZ-136, 141, 146, 151, 161, 166, 171, 176, 181, 186, 191, 196, 201, 206, 211, 216, 221, 226, 231, 236, 241, 246, 251, 256

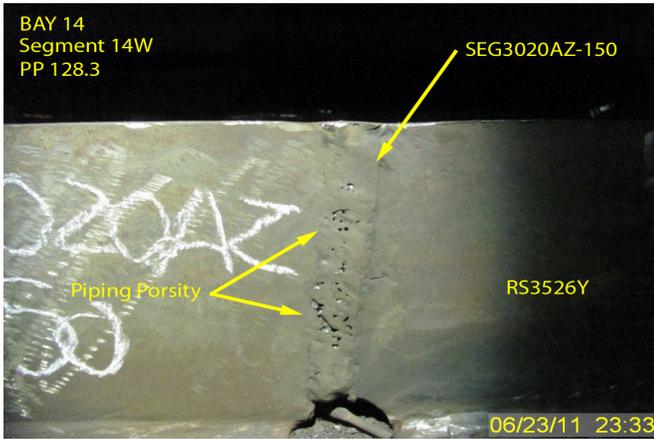
-SEG3020AY-158, 163, 168, 173, 178, 183, 188, 193, 198, 203, 208, 213, 218, 223, 228, 243, 248, 253, 258, 263

-SEG3020AZ-135, 140, 145, 155, 160, 165, 170, 175, 180, 185, 190, 195, 200, 205, 210, 215, 220, 225, 230, 235, 240, 245, 250, 255

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This Quality Assurance (QA) Inspector, responding to NDT notification 09568, performed 100% Visual Inspection (VT) and approximately 10% Ultrasonic Testing (UT) of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. The component OBG 14W at SEG3020AZ weld number 150 was found to have piping porosity throughout the entire I Rib splice CJP cap on one side only. This QA informed AB Flour lead QA Inspector Kit Man of the problem. A TL-015 Incident Report will be documented for the accordance.



Summary of Conversations:

No relevant conversations.

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 150-0042-2372, who represents the Office of Structural Materials for your project.

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| Inspected By: | Combs,Dennis | Quality Assurance Inspector |
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| Reviewed By: | Riley,Ken | QA Reviewer |
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