

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-025236**Date Inspected:** 10-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:** Lv Li Qing**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, 13BW, 13BW**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.

BLAST BAY 4

The following Magnetic Particle Testing (MT) was performed by AB/F and witnessed by this QA inspector per ZPMC Non-Destructive Testing (NDT) notification document 09432:

SEG3013B-005, 011, 017, 023, 035, 041, 047, 053, 072, 077, 084, 096, 101, 114, 126, 137, 138, 144, 149,
224, 225, 226, 300, 301, 302, 303, 304, 305, 306, 307, 308, 319, 338, 342, 346, 350, 361

SEG3013C-005, 011, 023, 035, 071, 078, 251, 255, 259

SEG3013AA-030, 035

SEG3013AH-102, 103

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

SEG3013K-021, 022, 025, 038, 039, 044, 046, 053, 054, 057, 061, 065, 066, 069, 070, 073, 074, 077, 081, 085, 086, 091, 094, 098, 102, 145, 146, 147

SEG3013L-029, 030, 032, 034, 036, 041, 042, 074, 075, 077, 078, 080, 081, 083, 084, 087, 095, 105, 432

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC and AB/F personnel. This QA inspector generated an MT report for this date. The segment is identified as 13AW. The weld designations reviewed are as follows.

SEG3013B-005, 011, 017, 072, 077, 084, 301, 302, 303, 304, 338, 342, 346

SEG3013C-251, 255

SEG3013K-021, 022, 025, 038, 044, 046, 054, 066, 070, 074, 094, 098, 102

SEG3013L-074, 075, 077, 078

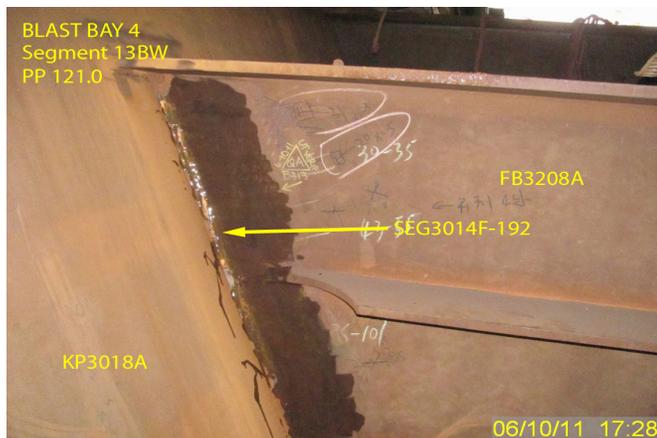
TRIAL ASSEMBLY YARD

This Caltrans QA inspector received ZPMC non-destructive test (NDT) notification number 09420 from ZPMC for Trial Assembly Yard. This QA inspector performed ultrasonic testing (UT) verification of welds after ZPMC had performed their UT inspection. The segment is identified as OBG 13BW. The weld designations reviewed are as follows.

SEG3014H-231,232,159

SEG3014F-227,192,165

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



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 James Devey 15000026784, who represents the Office of Structural Materials for

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

your project.

Inspected By:	Combs,Dennis	Quality Assurance Inspector
----------------------	--------------	-----------------------------

Reviewed By:	Riley,Ken	QA Reviewer
---------------------	-----------	-------------