

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-025551**Date Inspected:** 02-Jul-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) 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, Vikram Singh was present during the times noted above for observations relative to the work being performed at ZPMC.

NDT

Bay 16

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 09630.

Ultrasonic Testing (UT)

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an UT report for this date. The member is identified as OBG. The weld designations reviewed is as follows:

W2-SAS-1-001-039

E5-SAS-1-001-039

E2-SAS-1-001-039

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

W5-SAS-1-001-039

BLAST INSPECTION

Blast Shop-4

OBG 13AW

This Quality Assurance (QA) Inspector performed Post blast visual inspection (VT) of internal surfaces of deck plates, side plates, edge plate and floor beam in between PP118 to PP119-1500 at CB Side of the OBG 13AW, Areas marked up for weld repair were recorded on a weld map for future repair. Areas requiring additional grinding were marked by QA and repaired by ZPMC personnel.

During the Quality Assurance Inspection of Visual testing (VT) of Post blast inspection of Deck Plate (DP3116) internal welds at PP119-1500 of the OBG 13AW [CB Side], this Quality Assurance Inspector (QA) discovered the Miss Weld measuring approximately 50 mm long on weld joint identified as SEG3013L-029 located on deck plate to deck plate diaphragm. The location is marked up for weld repair and was recorded on a weld map for future repair. For further information, please see the attached pictures below:

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

No relevant conversations were reported on this date.

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, 15000422372, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By: Singh, Vikram

Quality Assurance Inspector

Reviewed By: Riley, Ken

QA Reviewer