

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-025565**Date Inspected:** 19-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:** Mr. Li Yang ZPMC**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:** TA Yard OBG 13E, 13W**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Robert A. DeArmond was present during the time noted above and conducted observations relative to the work being performed.

TRIAL ASSEMBLY YARD

Ultrasonic Testing (UT)

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. All components were as listed on NWIT notification no. 09775. The member(s) is/are identified as OBG 13AW and 13BE Stiffener to Web Plate, Floor Beam Web Splice, Floor Beam Flange splice, and Gusset to Floor Beam. The weld designations reviewed are as follows

SEG3013W-001, 205, 014, 015, 048, 049, SEG3013V-104, 124, 125, 528, 136, 143, 162, 515, 519,
SEG3009V-034, 038, SEG3013C-168

HEAVY DOCK

Ultrasonic Testing (UT)

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. All components were as listed on NWIT notification no. 09772. The member(s) is/are identified as OBG 14W Traveler Rail Connection Plates.

WELDING INSPECTION REPORT

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The weld designations reviewed are as follows

SA8506-001-001, SA8506-002-001, SA8506-001-002, 003

TRIAL ASSEMBLY YARD

This QA Inspector observed the following work in progress:

Ultrasonic Testing (UT) Review of SEG3013C-168 was performed per ZPMC Non-Destructive Testing (NDT) notification 09775. This QA Inspector discovered missing 25 mm weld access hole (cope hole) from stiffener plate X4199G, based on approved shop drawing identified as X4199G, Specifies a 25 mm radius cope hole. This QA informed ZPMC QA identified as Mr. Zhong Wei and ABF QA Steve Lawton of this issue and that an incident report would be generated concerning this issue. For further details refer to the incident report issued by this QA on this date and the attached photos

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



Summary of Conversations:

As mentioned above between QA and QC concerning this project

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, 150000422372, who represents the Office of Structural Materials for your project.

Inspected By: DeArmond,Robert

Quality Assurance Inspector

Reviewed By: Riley,Ken

QA Reviewer