

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-025665**Date Inspected:** 06-Jul-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:	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, 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:

ZPMC issued "Inspection Notification Sheet" number 09648 informing Caltrans QA that ZPMC is requesting ultrasonic inspections (UT) of OBG segment 13BE complete joint penetration weld item #1 SEG3009V-048 and item #3 welds SEG3009C-204, SEG3009C-205, SEG0009V-030 and SEG3009V-031. This QA Inspector performed random visual and ultrasonic inspections of approximately 15% length of areas previously tested by ZPMC personnel and items observed by this QA Inspector appear to comply with AWS D1.5 UT requirements. For additional information on these inspections see this QA Inspector's TL6027 Ultrasonic Test Report.

Caltrans and ABF have agreed to conduct visual and magnetic particle inspections (MT) of segment 13 East welds as part of a special inspection program, reference NWIT number 9660. This QA Inspector observed ABF Inspectors had completed and accepted MT inspections of temporary alignment plate welds on the end of segment 13CE adjacent to where segment 14East will be welded. These temporary alignment plate welds did not have any numbers assigned to identify their locations. ABF Inspectors rejected approximately five of these weld removal areas and ZPMC workers ground and or weld repaired these areas. Several of the temporary alignment plate removal areas had been painted and ZPMC workers removed paint from some of these areas. ABF Inspectors stopped working prior to ZPMC removing paint from all of these locations. This QA Inspector performed random visual and magnetic particle inspection of approximately 15 percent of these weld removal areas that had been

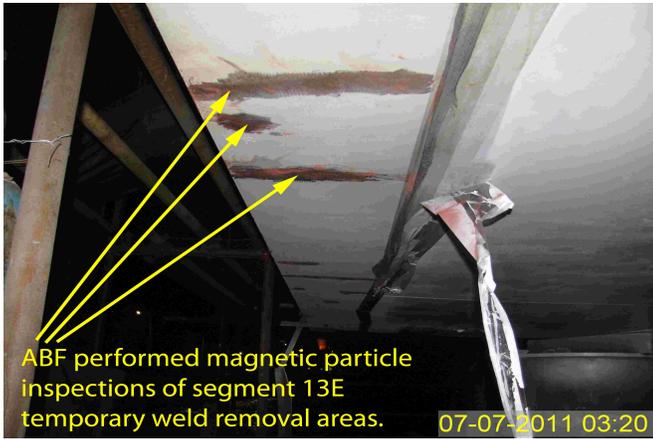
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previously MT accepted by ABF Inspectors and no additional MT indications were observed by this QA Inspector. For additional information on these inspections see this QA Inspector's TL6028 Magnetic Particle Test Report and the photograph below for additional information.

Blast bay #4, OBG segment 13W

ZPMC requested Caltrans personnel to perform visual inspections of OBG segment 13W architectural housing interior plates between panel points PP117.5 and 120 following the initial pre-blast cleaning of the steel surfaces. This QA Inspector along with two other QA Inspectors performed random visual inspections of these areas and observed multiple areas that require grinding to remove arc strikes, sharp edges, minor gouges, temporary welds and two areas that require weld repairs. Caltrans QA Inspectors' provided the locations of these weld repairs to dayshift QA personnel for adding this information to the 13W tracking database.



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
