

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-025671**Date Inspected:** 22-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:****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:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Mike Hasler was present during the times noted above for observations and testing relative to the work being performed.

UT Inspection

This Caltrans QA inspector and Robert DeArmond received ZPMC non-destructive test (NDT) per ZPMC #09792, Item 1 for OBG segment 14E at vessel Zhen Hua #19. This QA Inspector performed verification Ultrasonic Testing (UT) inspection after ZPMC had performed their UT inspection of the following locations;

Item 1: SEG3019W-042, SEG3019M-147, 153, 159, 165

At the time of the verification it was noted that the above component appeared to be within compliance of the contract documents. See Caltrans Magnetic Particle Test Report (TL6028), dated 07-22-2011 for additional information.

MT Inspection

This Caltrans QA inspector received ZPMC non-destructive test (NDT) per ZPMC #09793, Item 1 (Attachment) for OBG segment 14E at vessel Zhen Hua #19. However, ZPMC QC inspector stated the welds had not been cleaned of paint properly and AB/F QC cancelled the Magnetic Particle Testing of Item 1.

At the time of the verification it was noted that the above component appeared to be within compliance of the

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contract documents. See Caltrans Ultrasonic Test Report (TL6027), dated 07-22-2011 for additional information.

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

Summary of Conversations:

“As noted within the contents of this report.”

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.

Inspected By:	Hasler, Mike	Quality Assurance Inspector
Reviewed By:	Riley, Ken	QA Reviewer
