

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-025697**Date Inspected:** 04-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:** See below**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, Kelly Leavitt, was present during the times noted above for random observations relative to the work being performed.

Blast Bay 2

This Caltrans QA Inspector performed a pre-primer visual inspection number 7312 at 19:25 of OBG 14W internal anchor plate area remaining ceiling and vertical of floor beam (approx. 60%). Surface defects and base metal surface irregularities that required re-blasting were marked up with colored chalk, and weld defects that require welding were taped with gray masking tape for repair after the coating has been applied. ZPMC QC and ABF inspection personnel were present during the inspection and informed of QA findings. Area was rejected for rust and stains still on steel.

This Caltrans QA Inspector performed a pre-primer visual inspection number 7312 item 1 at 19:25 of OBG 14W internal west section floor and vertical of floor beam from anchor plate to P128. Surface defects and base metal surface irregularities that required re-blasting were marked up with colored chalk, and weld defects that require welding were taped with gray masking tape for repair after the coating has been applied. ZPMC QC and ABF inspection personnel were present during the inspection and informed of QA findings. Area was rejected for rust and stains still on steel. Test were taken and listed below.

2 each salt: 34.6, 37.5

3 each profile: 61~79

This Caltrans QA Inspector performed a pre-primer visual inspection number 7312 item 2 at 19:25 of OBG 14W

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internal anchor plate partial ceiling and vertical of floor beam (approx. 40%). Surface defects and base metal surface irregularities that required re-blasting were marked up with colored chalk, and weld defects that require welding were taped with gray masking tape for repair after the coating has been applied. ZPMC QC and ABF inspection personnel were present during the inspection and informed of QA findings. Area was rejected for rust and stains still on steel. Test were taken and listed below.

1 each salt: 20.0

3 each profile: 76~82

This Caltrans QA Inspector performed a pre-primer visual inspection number 7315 at 21:00 of OBG 14W internal anchor plate area remaining ceiling and vertical of floor beam. Surface defects and base metal surface irregularities that required re-blasting were marked up with colored chalk, and weld defects that require welding were taped with gray masking tape for repair after the coating has been applied. ZPMC QC and ABF inspection personnel were present during the inspection and informed of QA findings. Area was accepted.

Blast Bay 4

This Caltrans QA Inspector performed a pre-primer visual inspection number 7318 item 1 at 22:30 of OBG 13W internal west and middle section ceiling and vertical of floor beam from PP118 to PP119-1500. Surface defects and base metal surface irregularities that required re-blasting were marked up with colored chalk, and weld defects that require welding were taped with gray masking tape for repair after the coating has been applied. ZPMC QC and ABF inspection personnel were present during the inspection and informed of QA findings. Area was accepted as after blowing dust off. Test were taken and listed below.

2 each salt: 16.0, 37.4

3 each profile: 70~84

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

Inspected By:	Leavitt,Kelly	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
