

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-025698**Date Inspected:** 03-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.

Trial Assembly

This Quality Assurance Inspector (QA) performed Visual Testing (VT) review of randomly selected welds located on OBG13W that was previously tested by American Bridge Fluor (ABF) QA personnel using the Magnetic Particle (MT) and VT method. The following issue(s) have been noted and this QA Inspector provided a turnover to dayshift personal for tracking of these welds. The weld designations reviewed are as follows:

SEG3011L-139,140,141,142,143,144,145,146,223,242,243

This QA inspector performed MT of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date. The member was identified as OBG 13W. The weld designations reviewed are as follows:

SEG3011L-143,144,145,146,147,148

This QA Inspector observed the following work in progress for Trial Assembly.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Li Ping.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Components; 13E
PCMK: SEG3011L
Weld No: 242
Welder: 037723
WPS-B-P-2212-TC-U4b-FMC-1

Components; 13E
PCMK: Drip Plate
Weld No:
Welder: 501946
WPS-B-P-2114

This Caltrans QA Inspector performed a post primer visual inspection of the exterior surface of bottom plate on OBG 13E. The primer was tested for thickness. Area's where the primer was too thick was covered with masking tape, for repair later, and the remainder readied for top coat of paint. ZPMC QC and ABF inspection personnel were present during the inspection and informed of QA findings.

This Caltrans QA Inspector performed a pre-primer visual inspection of OBG 13W internal vertical of anchor plate area to PP125. 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.

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
