

**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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025736**Date Inspected:** 12-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) Chanxing Island **Location:** Shanghai, China**CWI Name:** Wang Lu (Testino)**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:** OBE 13BE**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Dennis Combs, was present during the times noted above for the observations relative to the work being performed.

**TRIAL ASSEMBLY YARD**

This QA inspector monitored testing of magnetic particle yokes used by ZPMC, and AB/F for testing of OBG welds with Interzink 22 primer located in contact area. Yokes were tested using a 10lb.+ steel plate with Interzink 22 primer with a DFT of 2 to 4 mils.

This Caltrans QA inspector received ZPMC non-destructive test (NDT) notification number 09696 from ZPMC for Trial Assembly Yard. This QA inspector performed magnetic particle testing (MT) verification of welds after ZPMC had performed their MT inspection. The segment is identified as OBG 13BE. The weld designations reviewed are as follows.

SP3073-001-009, 010

SP3074-001-001, 002, 003, 004

This Quality Assurance (QA) Inspector, responding to NDT notification 09696, performed 100% Visual Inspection (VT) and approximately 15% Magnetic Particle Testing (MT) of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. The component OBG 13BE at SP3074-001 weld numbers 005, and 006 was found to be incomplete, at this time these welds have not yet been deposited. This QA

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# WELDING INSPECTION REPORT

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informed ZPMC lead QC Inspector Wang Lu (Testino) of the problem. A TL-015 Incident Report will be documented for the accordance.

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 150-0042-2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Combs,Dennis	Quality Assurance Inspector
<b>Reviewed By:</b>	Riley,Ken	QA Reviewer

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