

**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-025831**Date Inspected:** 27-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

<b>CWI Name:</b>	N/A	<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes No N/A	<b>Rod Oven in Use:</b>	Yes No N/A	
<b>Electrode to specification:</b>	Yes No N/A	<b>Weld Procedures Followed:</b>	Yes No N/A	
<b>Qualified Welders:</b>	Yes No N/A	<b>Verified Joint Fit-up:</b>	Yes No N/A	
<b>Approved Drawings:</b>	Yes No N/A	<b>Approved WPS:</b>	Yes No N/A	
		<b>Delayed / Cancelled:</b>	Yes No N/A	
<b>Bridge No:</b>	34-0006	<b>Component:</b>	OBG Components	

**Summary of Items Observed:**

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

Vessel Zhenhua #19

Caltrans and ABF have agreed to conduct visual inspection (VT) and magnetic particle inspection (MT) of welds as part of a special joint inspection program. In response to ABF NDT Inspection Notification Sheets (NWIT) #09822 for MT of the following:

This QA Inspector performed random VT and then MT of approximately 15% of the area previously tested and accepted by ABF Quality Control personnel. This QA Inspector generated an MT report for this date and provided a turnover to dayshift personnel for tracking of these welds. The members were identified as follows:

OBG Segment 13AW, FB3180-001. The weld designations reviewed were: 033, 035. No apparent MT indications were observed. ABF personnel reported no apparent VT or MT indications were observed in weld designations 032, 034, also listed on NWIT #09822. No apparent VT indications were observed by this QA Inspector in the areas of the welds accessible for MT and no MT was performed by this QA Inspector. All 4 welds had one end of each weld terminate at a common cope hole. All 4 of these welds had rough, irregular surfaces in and at the cope hole requiring grinding. This QA Inspector had been directed by this QA Inspector's shift leader, in an effort to complete the MT workload, to perform MT on the welds even if an end of any weld terminated in a cope hole that appeared to require grinding. All 4 welds were accepted for VT and MT, but the cope hole was rejected by this QA Inspector based on VT.

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This QA Inspector observed ZPMC personnel performing final tightening of bolt sets using an air impact wrench in Segment 13BE, north (crossbeam) side, between panel point 121 and panel point 121.5, bottom plate I-rib splice plates. After performing the tightening with the air impact wrench, the workers then checked the tightness of the bolt sets using a calibrated torque wrench.

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

**Summary of Conversations:**

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

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

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