

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-025834**Date Inspected:** 18-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:	N/A	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 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.

Trial Assembly Area

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) #09773 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, SEG3013AH. The weld designation reviewed was: 078. No apparent VT or MT indications were observed. ABF personnel reported no apparent VT or MT indications were observed in weld designation SEG3013AH-100 also listed on NWIT #09773. No apparent VT indications were observed by this QA Inspector who did not perform MT on this weld.

This QA Inspector also randomly observed the following work in progress in the OBG Trial Assembly Area:

Six to 8 ZPMC workers performing touch-up painting of inorganic zinc coating in OBG Segment 13W.
Truck crane offloaded a 3 deck plate deck panel from OBG Segment 13CW to stanchions on slab-on-grade.

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In OBG Segment 13BE, an approximate total of 20 ZPMC workers were performing sandblasting, initial and final bolt tightening, moving splice plates, and grinding.

Heavy Dock

This QA Inspector began to randomly observe the following on the Heavy Dock in response to Bolting Inspection Notification Sheet No. 00698. However, the test was not completed on this shift as noted below:

OBG Segment 14W, longitudinal diaphragms, 4.75 meter height locations, panel points 125~126 and panel points 126.5~127, north and south sides: ZPMC workers performed final ASTM A325M bolt tightening verification of bolt sets noted below at the direction of ZPMC QC Zhang Lin (QC1) using ZPMC calibrated wrench #X02-777. No less than 10% of the ASTM A325 bolt sets at each connection were torque tested. QC1 could not provide this QA Inspector with any of the RoCap Set numbers, bolt set sizes, or the NM test results for torque tightening purposes. Without this information this QA Inspector was unable to verify the proper tightening of the bolt sets installed at these locations. QC1 informed this QA Inspector that the above noted information would be provided to Caltrans QA after 0700 hours on 7/19/11. This QA Inspector informed QC1 that the test would have to be postponed until the information was made available. This QA Inspector informed Caltrans QA day shift personnel of the above attempt to fill the requirements of Bolting Inspection Notification Sheet No. 00698 and QC1's inability to provide the necessary information to conduct the test.

This QA Inspector also randomly observed the following work in progress on the vessel Zhenhua #19 moored at the end of the Heavy Dock:

A crew of approximately 6 ZPMC workers performing spray coating of inorganic zinc in OBG Segment 14W, center area.

Eight ZPMC workers loading and securing splice plates at various locations for the upcoming voyage.

Three ZPMC workers installing catwalk handrails in CB19.

Approximately 10 to 15 other ZPMC workers performing various tasks, such as grinding.

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.

Inspected By:	Goulet, George	Quality Assurance Inspector
Reviewed By:	Riley, Ken	QA Reviewer
