

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-025842**Date Inspected:** 09-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 inspections (MT) of welds as part of a special joint inspection program. In response to ZPMC NDT Inspection Notification Sheets (NWIT) #09689 for magnetic particle testing inspection of the following:

This QA Inspector performed random VT of the welds previously tested and accepted by ABF Quality Control personnel but was unable to perform MT because all welds were rejected by this QA Inspector during VT. The welds displayed weld profiles with either overlap, incomplete fusion, or both, and/or rough surfaces in the cope holes. This QA Inspector provided a turnover to dayshift personnel for tracking of these welds. The members were identified as follows:

OBG Segment 13AW, SEG3013Q. The weld designations reviewed were: 086, 087, 088, 091, 092, 093, 096, 097, 098, 101, 102, 103. OBG Segment 13AW, SEG3013L. The weld designations reviewed were: 055, 056, 057, 060, 061, 062, 065, 066, 067, 070, 071, 072. OBG Segment 13AW, SEG3013J. The weld designations reviewed were: 046, 047, 048, 050, 052, 053, 054, 055, 056, 057. Weld joint SEG3013J-051 was also listed on NWIT #09689 and accepted for VT but rejected for MT by ABF inspectors. However, this QA Inspector rejected the weld based on VT and did not perform MT on this weld.

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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
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Reviewed By:	Riley,Ken	QA Reviewer
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