

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-025847**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:	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 and magnetic particle (MT) inspections of welds as part of a special joint inspection program. In response to ZPMC verbal request for magnetic particle testing (MT) inspection of the following:

This QA Inspector performed random visual testing (VT) and then MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel per a handwritten document presented by ZPMC QC 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 13CE, SEG3011L. The weld designations reviewed were: 124, 127, 129, 132, 166, 167, 175, 176. No apparent VT or MT indications were observed. Weld joints SEG3011L-121, 122, 123, 125, 126, 130, 131, 133, 134, 135, 136, 137, 138, 157 were also listed on the ZPMC document and accepted by ZPMC inspectors. No apparent VT indications were observed by this QA Inspector.

OBG Segment 13CE, SEG3011C. The weld designations reviewed were: 099, 111, 115. No apparent VT or MT indications were observed. Weld joints SEG3011C-095, 103, 119, 123, 127, 131, 135, 139, 143, 147, 151, 155, 159 were also listed on the ZPMC document and accepted by ZPMC inspectors. No apparent VT indications were

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observed by this QA Inspector.

This QA Inspector performed random visual testing (VT) and then MT of approximately 15% of the area previously tested and accepted by ABF Quality Control personnel per a document presented by ABF QC 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 13CE, BP3043-001. The weld designations reviewed were: 051, 052. No apparent VT or MT indications were observed. Weld joints BP3043-001-049, 050, 053, 054, 055, 056, 057, 058, 059, 060 were also listed on the ABF document and accepted by ABF inspectors. No apparent VT indications were observed by this QA Inspector.

OBG Segment 13CE, BP3044-001. The weld designations reviewed were: 053, 054. No apparent VT or MT indications were observed. Weld joints BP3044-001-049, 050, 051, 052, 055, 056, 057, 058, 059, 060 were also listed on the ABF document and accepted by ABF inspectors. No apparent VT indications were observed by this QA Inspector.

OBG Segment 13CE, BP3045-001. The weld designations reviewed were: 053, 054. No apparent VT or MT indications were observed. Weld joints BP3045-001-049, 050, 051, 052, 055, 056, 057, 058, 059, 060 were also listed on the ABF document and accepted by ABF inspectors. No apparent VT indications were observed by this QA Inspector.

Blast Shop 2

This QA Inspector and QA Inspector Kelly Leavitt responding to phone notification from ABF Inspectors performed a pre-final sandblast inspection of Segment 14W, north (counterweight) side between panel point 127 and panel point 128.7, at and near bottom plate and side plate. This QA Inspector observed several surface irregularities requiring grinding. These areas were marked for grinding. This QA Inspector observed several surface irregularities appearing to be arc strikes requiring grinding and magnetic particle testing (MT). These areas were marked for grinding and MT. This QA Inspector also observed the weld missing between SA3412A (NS) and FB3345A. The weld was designated as SEG3020B-109. The missing weld was documented and reported in a Post Blast Repair Report of this date. See that report for further details.

Blast Shop 2 (2nd Inspection)

This QA Inspector and QA Inspectors Paul Dawson, Kelly Leavitt responding to phone notification from ABF Inspectors performed a pre-final sandblast inspection of Segment 14W, vertical diagonal shear plates and associated I rib stiffeners and connection plates in the anchor plate area, from panel point 125 to anchor plate. This QA Inspector also observed 1 weld at the anchor plate not completed to the end of the shear plate I-rib at the cope hole. The location of the weld was communicated to day shift QA Inspector personnel for documentation and entry into a data base.

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

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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
