

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

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-025852**Date Inspected:** 26-Jun-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.

## Bay 14

Caltrans and ABF have agreed to conduct visual and magnetic particle (MT) inspections of welds as part of a special joint re-inspection program. In response to ZPMC NDT Inspection Notification Sheet (NWIT) #09605 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. 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 14W, SEG3020AZ. The weld designation appearing to be visually acceptable, then reviewed by MT was: 209 and no apparent MT indications were observed.

Weld joints SEG3020AZ-021, 022, 023, 024, 400, 401, 402, 403, 404, 405, 406, 407, 408, 409, 410, 360, 362, 161, 163, 164 were also listed on NWIT #9605 and were accepted by ZPMC inspectors. However, this QA Inspector rejected all of the noted welds due to VT indications observed, including uneven surfaces and weld overlap in the cope hole area and possible weld repairs, some obscured by copious amounts of debris. No red iron powder used in MT testing or red discoloration was observed at or near many of the welds noted. Weld joints SEG3020AZ-021,

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022, 023, 024, 400, 401, 402, 403, 404, 405, 406, 407, 408, 409, 410, 360, 362, 161, 163, 164 were not further reviewed by this QA Inspector.

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

**Summary of Conversations:**

No significant 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 James Devey 15000026784, 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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