

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-026086**Date Inspected:** 29-Jul-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:****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**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Mike Hasler was present during the times noted above for observations and testing relative to the work being performed.

Vessel, Zhen Hua #19

MT Inspection/ Tracking

13W

This Quality Assurance (QA) inspector performed Visual Testing (VT) of an area that has been previously tested by AB/F Quality Control (QC) personnel using the Magnetic Particle (MT) and VT method. This QA Inspector generated a MT tracking report for this date and indicated accept or reject of individual welds on this report. The member was identified as OBG segment 13AW. The weld designations reviewed are as follows:

SEG3013Y-464, SEG3013Y-466, SEG3013Y-005

SEG3013X-122, SEG3013X-313, SEG3013X-485, SEG3013X-486, SEG3013X-584

This QA inspector performed MT of approximately 15% of an area that has been previously tested and accepted by AB/F QC personnel. This QA Inspector generated MT (TL6028) report for this date for welds tested by QA. The weld designations reviewed are as follows:

SEG3013Y-005, SEG3013X-122, SEG3013X-313

This QA inspector observed excessive weld (root) gap at 13AW interior longitudinal diaphragm connection plate to floor beam flange at PP119 +1500 weld SEG3013Y-343 and 344. This QA inspector generated a Quality

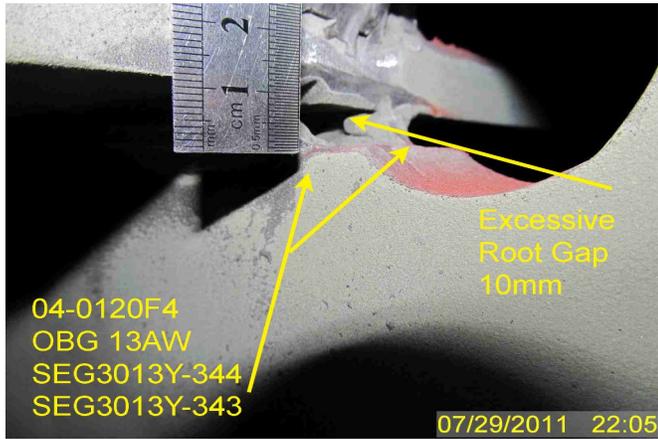
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Assurance-Incident Report for excessive weld gap. See Quality Assurance-Incident Report, dated 07-29-11 for additional information.

The following digital picture illustrates excessive weld gap.

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



Summary of Conversations:

“As noted within the contents of this report.”

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 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Hasler, Mike	Quality Assurance Inspector
Reviewed By:	Riley, Ken	QA Reviewer
