

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-026096**Date Inspected:** 07-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:** See below**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:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Kelly Leavitt, was present during the times noted above for random observations relative to the work being performed.

This Quality Assurance Inspector (QA) performed Visual Testing (VT) review of randomly selected welds located on OBG13E that was previously tested by American Bridge Fluor (ABF) QA personnel using the Magnetic Particle (MT) and VT method. The following issue(s) have been noted and this QA Inspector provided a turnover to dayshift personal for tracking of these welds. The weld designations reviewed are as follows:

SEG3007C-232

SEG3007AH-080,081

SEG3007U-015,017,019,021

KP3005-001-007

SEG3007AU-099,100,101,102,103,104,030,087,093,094,097,107,108

SEG3007AV-045,046,002,004,005,006,008,009,103,104,116,025,024,067,054,105,106,063,056,026, 027,036,037, 031,032,042,057,058,065,066,059,060,061,062,107,108,

SEG3007Y-327,457,143,144,203,204,225,226,283,284,317,318,398,397,395,396,401,402,332,

SEG3007AX-001,002,005,035~040,006,014~018

SEG3007AY-091098,084,087,089,

SEG3007AZ-088,087,090~097,013,011,009,074,077,108,065,062,008,006, 003,061,058,059,046,111

SEG3007AT-592~607,616~,631,640~655,672~687,696~719,736~767,784~799,816~839,864~875,488~495, 464~471,400~,876~887,472~487,504~511,520~575

FB3127-001-051~082

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FB3124-001-055~086

This QA inspector performed MT of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date. The member was identified as OBG 13E. The weld designations reviewed are as follows:

SEG3007C-232

SEG3007AH-080,081

SEG3007U-015-017,019,021

KP3005-001-007

SEG3007Y-143,144,203,204,332

SEG3007AY-094,095,096,097,098

SEG3007AT-640~655

SEG3007AT-464~471

FB3127-001-051~066

During random in-process visual inspection of welds located in OBG13E, this Quality Assurance Inspector (QA) observed a cracked weld, found by ZPMC Quality Assurance (QC) Inspectors, using Magnetic Particle Testing (MT). The area is located on SEG3007AX and identified as weld number 013. The weld was reported by ZPMC as reject and scheduled for repair. (See Photos below).

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



Summary of Conversations:

“No relevant 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 Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

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Inspected By: Leavitt, Kelly

Quality Assurance Inspector

Reviewed By: Riley, Ken

QA Reviewer