

**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  
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(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009294**Date Inspected:** 27-Feb-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Zhi Jiang**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 (QA) Inspector, Sandeep Kumar was present during the times noted above for observations relative to the work being performed.

Issued the Green Tag for the following components, where the required percentage of NDT methods found completed.

BAY 3

CA095 – 23; 24 – Green Tag - 003735

CA095 – 51; 52 – Green Tag - 003733

CA095 – 79; 80 – Green Tag - 003720

CA095 – 65; 66 – Green Tag - 003645

CA096 – 37; 38 – Green Tag - 003684

CA096 – 09; 10 – Green Tag - 003692

CA096 – 23; 24 – Green Tag - 003698

CA096 – 65; 66 – Green Tag - 003718

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CA096 – 51; 52 – Green Tag - 003723  
CA097 – 23; 24 – Green Tag - 003713  
CA097 – 09; 10 – Green Tag - 003696  
CA097 – 79; 80 – Green Tag - 003706  
CA097 – 51; 52 – Green Tag - 003686  
CA097 – 37; 38 – Green Tag - 003725  
CA098 – 23; 24 – Green Tag - 003688  
CA098 – 09; 10 – Green Tag - 003695  
CA098 – 37; 38 – Green Tag - 003716  
CA098 – 79; 80 – Green Tag - 003727  
CA098 – 51; 52 – Green Tag - 003707  
CA098 – 65; 66 – Green Tag - 003731  
CA099 –13; 14 – Green Tag - 003685  
CA099 –69; 70 – Green Tag - 003687  
CA099 –41; 42 – Green Tag - 003700  
CA099 –27; 28 – Green Tag - 003705  
CA099 –55; 56 – Green Tag - 003719  
CA099 –83; 84 – Green Tag - 003736  
CA100 –69; 70 – Green Tag - 003694  
CA100 –83; 84 – Green Tag - 003689  
CA100 –13; 14 – Green Tag - 003709  
CA100 –27; 28 – Green Tag - 003732  
CA100 –55; 56 – Green Tag - 003708  
CA100 –41; 42 – Green Tag - 003703  
CA101 –49; 50 – Green Tag - 003693  
CA101 –91; 92 – Green Tag - 003699  
CA101 –63; 64 – Green Tag - 003701  
CA101 –77; 78 – Green Tag - 003710  
CA101 –21; 22 – Green Tag - 003722  
CA102 –21; 22 – Green Tag - 003721  
CA102 –49; 50 – Green Tag - 003724  
CA102 –77; 78 – Green Tag - 003712  
CA102 –35; 36 – Green Tag - 003704  
CA102 –91; 92 – Green Tag - 003690  
CA102 –63; 64 – Green Tag - 003691  
CA103 –63; 64 – Green Tag - 003717  
CA103 –49; 50 – Green Tag - 003715  
CA103 –77; 78 – Green Tag - 003714  
CA103 –91; 92 – Green Tag - 003711  
CA103 –35; 36 – Green Tag - 003683  
CA103 –21; 22 – Green Tag - 003728  
CA104 –35; 36 – Green Tag - 003734  
CA104 –91; 92 – Green Tag - 003729  
CA104 –49; 50 – Green Tag - 003726

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CA104 –63; 64 – Green Tag - 003702

CA104 –77; 78 – Green Tag - 003730

CA104 –21; 21 – Green Tag – 003697

This QA Inspector observed the following work in progress:

SAW process welding of weld joint #021 located on Floor Beam FB009-032. Welder is identified as 250050. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2221 – B – L2c – S – 2.

BAY 5

### Magnetic Particle Testing

This QA inspector performed 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. The members are identified as OBG Components. The weld designations reviewed are as follows:

BK001 – 001 – 32; 34; 36; 63; 66

BK001 – 002 – 32; 34; 36; 63; 66

BK001 – 003 – 32; 34; 36; 63; 66

BK001 – 004 – 32; 34; 36; 63; 66

BK001 – 005 – 32; 34; 36; 63; 66

BK001 – 006 – 32; 34; 36; 63; 66

BK001 – 007 – 32; 34; 36; 63; 66

BAY 6

### Magnetic Particle Testing

This QA inspector performed 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. The members are identified as OBG Components. The weld designations reviewed are as follows:

SP110 – 001 – 15; 17; 19; 21; 23; 25; 27 – Green Tag - 004519

SP350 – 001 – 13; 15; 17; 19; 21; 23 – Green Tag – 004520

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

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your project.

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<b>Inspected By:</b>	Kumar,Sandeep	Quality Assurance Inspector
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<b>Reviewed By:</b>	Whitehead,Lonnie	QA Reviewer
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