

**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:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008967**Date Inspected:** 03-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wan Wen Zhong**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 and Tower**Summary of Items Observed:**

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

**OBG Trial Assembly:**

This QA inspector performed Magnetic Particle Testing (MT) verification of OBG Segment 1AAE to 1AE longitudinal diaphragm splice weld SEG004B-050 at panel point 8.5. This QA Inspector located 4 linear indications in the base metal that appear to be in the area where temporary weld fixtures were removed. Indications were found on north side of the weld at Y locations 1160 mm, 2705mm, 4140 mm and 3065 mm. The length of indications ranged from 12 mm to 52 mm. This QA inspector generated an MT report for this date. See the attached photos below of the above mentioned indications.

This QA Inspector performed MT of OBG segment 3BE side panel stiffener hold back weld repair areas (west end) for the following welds, SP041-001-030, SP053-001-032, 037 and SP065-001-035. This QA inspector generated an MT report for this date.

**Bay 10:**

This QA Inspector observed the following work in progress: FCAW welding of weld joint SSTL3-1 K/K-029 located on the South Tower Lift 3. ZPMC welder was identified as 052075. ZPMC QC is identified as Wan Wen Zhong. The welding appeared to be in conformance with welding procedure specification,

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# WELDING INSPECTION REPORT

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WPS-B-T-2233-B-U2-F.

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



## Summary of Conversations:

As identified 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, 150 0042 2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Viars,Larry	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer

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