

**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-009207**Date Inspected:** 20-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:** Zhang Qin 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:** 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.

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Caltrans QA performed Visual Testing (VT) and Magnetic Particle Testing (MT) verification of East Tower Lift 3 Skin C to D diagonal plate welds, this Quality Control Inspector discovered intermittent undercut up to 2.5 mm in depth from the 99 to 102.5 meter mark on weld ESTL3-4 B/K-78. Caltrans QA found two MT linear indications on weld ESTL3-4 B/K-77, 40 mm intermittent indication located 40 mm above the 105 meter diaphragm and a 10 mm linear indication at the 99 meter bottom diaphragm. The above mentioned welds have been previously tested and accepted by ZPMC Quality Control (QC). The following welds were tested and accepted by this QA inspector: ESTL3-4 H/K-151, 152, 75, 76, ESTL3-4 G/K-97, 98, ESTL3-4 F/K-151, 152, 75, 76, ESTL3-4 K/K-15, 26 and 39.

This QA inspector performed Ultrasonic Testing (UT) verification of the areas previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members were identified as East Tower Lift 3 Skin plate C to D diagonal plate splice weld. The weld identification numbers are as follows: ESTL3-4 K/K-15, 26 and 39.

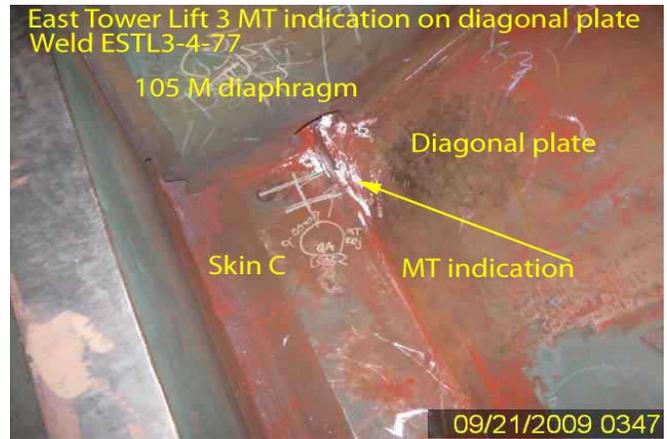
Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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# WELDING INSPECTION REPORT

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## 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 Serge Sinevod, 134 8257 0045, 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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