

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
(707) 649-5453
(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-009898**Date Inspected:** 29-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yan Hua**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 Assembly**Summary of Items Observed:**

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

Segment Repair Yard (North of the Blast Shop)

Segment 6CE

This QA Inspector performed Magnetic Particle testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (MT) report for this date. The members are identified as the corner assembly component welds. The Weld Designations are as follows:

CA030-037~042, 061~068, 085~090 and 113~118.

CSD2-PP43.5-049~056.

CSD2-PP44.5-049~056.

CSD2-PP45.5-049~056.

CSD2-PP46.5-049~056.

CSD4-PP44-069~074, 087, 088, 108, 109, and 130~134.

CSD4-PP46-069~074, 087, 088, 108, 109, and 130~134.

CSD5-PP45-063~074, 087, 088, 108 and 109.

CSD5-PP47-001~012, 023~026, 041 and 042.

SEG032L-003 and 004.

SEG032H-066, 072, 092 and 095.

SEG032J-038, 041, 092 and 095.

SEG032M-011, 019, 034, 036, 050 and 051.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

This QA Inspector performed Magnetic Particle testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (MT) report for this date. The members are identified as the deck drainage plate attachment welds. The Weld Designations are as follows: OBE6D-004 and 005.

This QA Inspector performed Magnetic Particle testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (MT) report for this date. The members are identified as the floor beam sub-assembly welds. The Weld Designations are as follows:

FB003-031-004 and 005.

FB003-034-004 and 005.

FB003-047-004 and 005.

FB012-021-001 and 002.

FB012-002-001 and 002.

FB012-006-001 and 002.

FB032-001-092 and 093.

FB028-001-092 and 093.

FB036-001-092 and 093.

During random verification Magnetic Particle Testing of the internal components of OBG segment 6CE, Caltrans Quality Assurance (QA) Inspector discovered a total of three (3) transverse and four (4) longitudinal linear indications that measured from 5mm to 20mm in length. These welds were previously tested accepted by ZPMC (MT) technicians. See incident report on this date. The affected weld designations are as follows;

Deck Drainage Plate to Deck Plate Attachment Fillet Weld-OBE6D-005 (3) 10mm Transverse Indications.

X3S Stiffener to Edge Plate CJP Weld at PP45.75 Weld –SEG32J-041 (4) 5-20mm Longitudinal Indications.

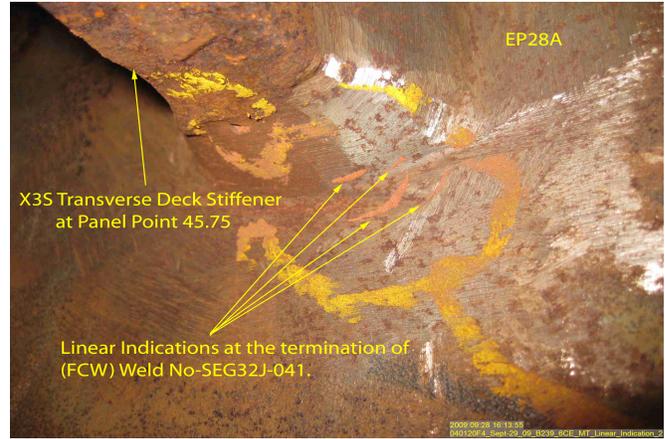
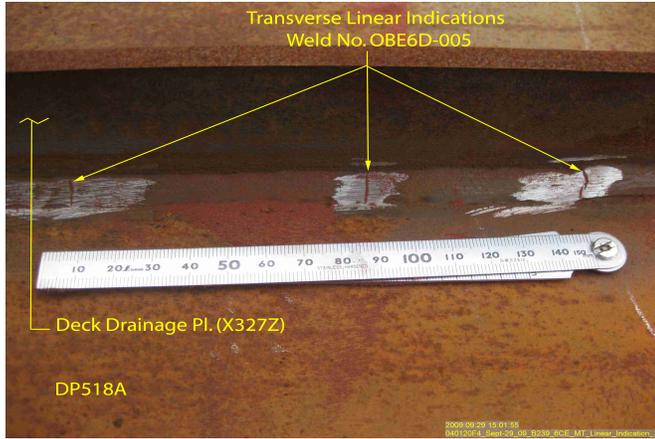
Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No Relevant conversations

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



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: Patterson,Rodney

Quality Assurance Inspector

Reviewed By: Carreon,Albert

QA Reviewer