

**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-010098**Date Inspected:** 14-Nov-2009**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

<b>CWI Name:</b>	N/A	<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes No N/A	<b>Rod Oven in Use:</b>	Yes No N/A	
<b>Electrode to specification:</b>	Yes No N/A	<b>Weld Procedures Followed:</b>	Yes No N/A	
<b>Qualified Welders:</b>	Yes No N/A	<b>Verified Joint Fit-up:</b>	Yes No N/A	
<b>Approved Drawings:</b>	Yes No N/A	<b>Approved WPS:</b>	Yes No N/A	
		<b>Delayed / Cancelled:</b>	Yes No N/A	
<b>Bridge No:</b>	34-0006	<b>Component:</b>	OBG/Tower	

**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

## TRIAL ASSEMBLY YARD

## ULTRASONIC INSPECTION

## OBG SEGMENT 2AE-2BE

This Quality Assurance (QA) Inspector performed conventional UT (Ultrasonic Testing) after ABF Ultrasonic inspection for detection of planar transverse indication.

UT performed on deck panel splice weld between OBG segment 2AE and 2BE (OBE2-002) utilizing scanning pattern A, B, C and D (Fig 6.7). During the inspection this Quality Assurance (QA) Inspector found two transverse indications that had not identified by ABF ultrasonic inspector. The Y location of indications was measured approximately 955mm and 925mm.

See Caltrans Ultrasonic Transverse Indication Evaluation sheet dated November 14th, 2009 for further information on inspections.

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# WELDING INSPECTION REPORT

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## OBG SEGMENT 2AW-2BW

This Quality Assurance (QA) Inspector performed conventional UT (Ultrasonic Testing) after ABF Ultrasonic inspection for detection of planar transverse indication.

UT performed on side panel (counter weight side) splice weld between OBG segment 2AW and 2BW (OBW2A-003) utilizing scanning pattern A, B, C and D (Fig 6.7). During the inspection this Quality Assurance (QA) Inspector found one transverse indications that had not identified by ABF ultrasonic inspector. The Y location of indications was measured approximately 5110mm.

See Caltrans Ultrasonic Transverse Indication Evaluation sheet dated November 14th, 2009 for further information on inspections.

Unless otherwise noted, all work observed on this dated 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 +(86) 150.0042.2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Utekar,Shrikant	Quality Assurance Inspector
<b>Reviewed By:</b>	Dawson,Paul	QA Reviewer

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