DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-012489
Date Inspected: 24-Nov-2009

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 645
OSM Departure Time: 1845
Location: Shanghai, China

CWI Name: Zhu Zhong Hai

Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**CWI Present:**	☑ Yes	☐ No	
Electrode to specification:	☐ Yes	☐ No	☑ N/A	**Rod Oven in Use:**	☐ Yes	☐ No	☑ N/A
Qualified Welders:	☐ Yes	☐ No	☑ N/A	**Weld Procedures Followed:**	☐ Yes	☐ No	☑ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☑ 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, Hiranch Patel, was present during the times noted above for observations relative to the work being performed.

During a random 10% Magnetic Particle (MT) verification at segment 7DE, Caltrans Quality Assurance (QA) Inspectors discovered a Longitudinal linear indication on the segment 7DE Longitudinal Diaphragm (LD) to Floor Beam (FB) welds. The weld designation is as below. The indication was measured at 7mm in length.
Weld#Seg040C-002, Panel Point (PP)-056, LD to FB, CJP joint, approximately 7mm in length.
The approved weld drawings, detailed these welds as fracture critical welds (FCW) and ZPMC personal completed these weld repairs without prior Engineer approval or utilizing an approved critical weld repair procedure (CWR).

Note: Please reference Incident Report written on 11-23 09,
(04-0120F4_TL-15_B238_11-23-09_7DE_MT_Crack).

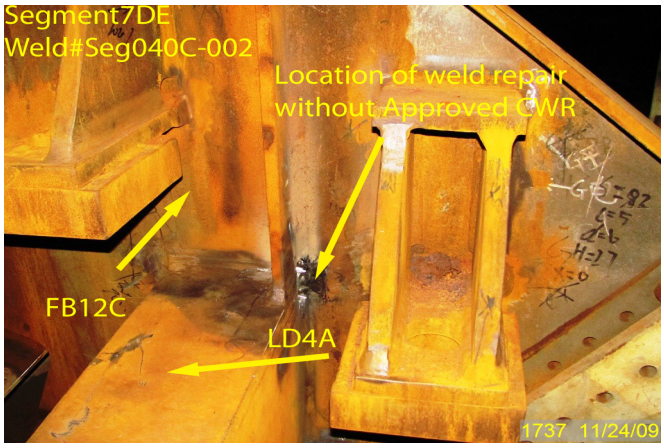
For further information, please see the attached pictures below. Please see incident report on this date.

Segment7DE
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 member is identified as OBG Components. The weld designations reviewed are as follows:
-(Seg040C-003, 031, 033, 026, 027, 054, 063)
-(Seg040C-004, 032, 034, 055, 062, 038, 039)

-(Seg040C-005, 040, 042, 056)
-(Seg040C-005, 040, 042, 056)
-(SSD23-PP55.5-073~084)
-(SSD23-PP55.5-085~096)
-(SSD23-PP55.5-037~048)
-(SSD16-PP56-088, 089, 090)
-(SSD16A-PP56-105, 106, 107)
-(SSD24-PP56.5-073~084)
-(SSD24-PP56.5-085~096)
-(SSD24-PP56.5-037~048)
-(SSD17-PP57-086, 087, 088)
-(SSD17A-PP57-105, 106, 107)
-(SSD24-PP57.5-073~084)
-(SSD24-PP57.5-085~096)
-(SSD24-PP57.5-037~048)
-(SSD18-PP58-089, 090, 091)
-(SSD18A-PP58-109, 110)
-(SSD16-PP56-220, 221, 224, 225, 226, 227, 236, 237)
-(SSD16-PP56-240, 241, 244, 245, 246, 247, 256, 257)
-(SSD16A-PP56-220, 221, 224, 225, 226, 227, 236, 237)
-(SSD16A-PP56-240, 241, 244, 245, 246, 247, 256, 257)
-(DP495A-062~085)
-(SSD16A-PP56-003, 004)

NOTE: THIS REPORT IS THE REVISION OF THE PREVIOUS REPORT WRITTEN ON THIS DATE.

Unless otherwise noted, all 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 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Patel,Hiranch	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer