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 #: 04-0120F4
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-010583
Date Inspected: 02-Dec-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	**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

CWI Present: ☑ Yes ☐ No

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.

Segment 7BW

During the Quality Assurance Magnetic Particle Testing (MT) review of welds located on Segment7BW, this Quality Assurance Inspector (QA) discovered the following issues:

-Two (2) Longitudinal linear indication measuring approximately 8mm and 20mm in length.

-The weld is identified as:

1. -SSD12A-PP52-171@ Panel Point (PP)-052, 8 mm in length.
2. -SSD11A-PP51-175, 176@ Panel Point (PP)-051, 20 mm in length.

-The Weld is a Fillet Weld joining the:

1. -Floor Beam, FB27B (FL3) stiffener to Edge Plate, EP067A joint.
2. -Floor Beam, FB23A (FL3) stiffener fillet weld joint.

-The OBG Segment is located at outside yard.

The Notice of Witness Inspection Number (NWIT) is 004768. The indication is located inside the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel

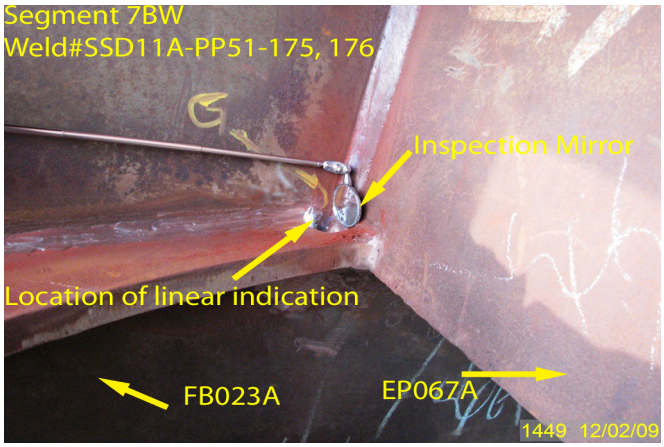
For further information, please see the attached pictures below. Please see incident report on this date.

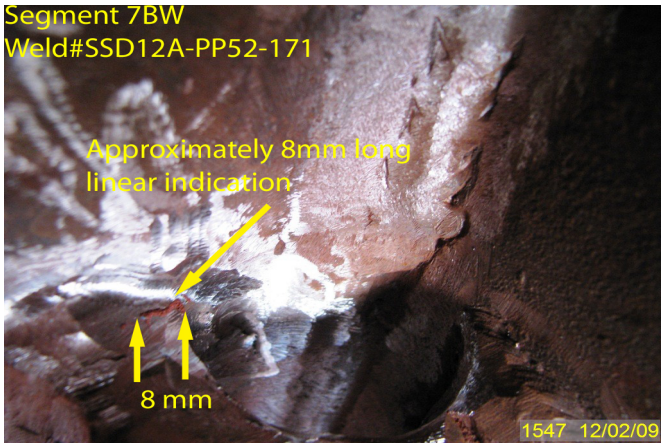
Segment7BW

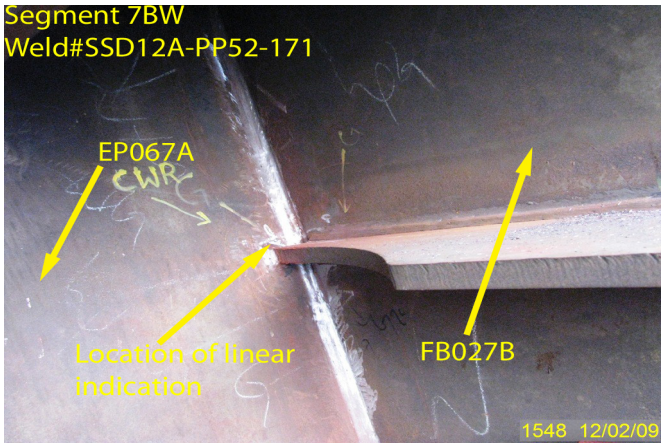
This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member is identified as OBG Components. The weld designations reviewed are as follows:

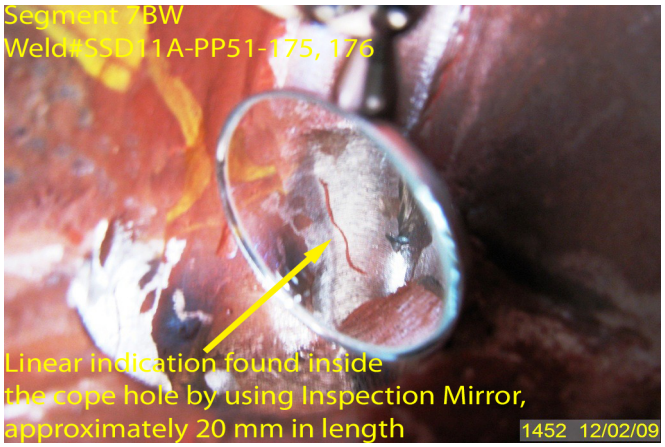
-(SSD11A-PP51-175, 176, 178)- Rejectable indication found inside cope hole.
-(SSD12A-PP52-170, 171)- Rejectable indication found.
-(SSD10A-PP50-166, 167, 168, 169, 172, 173, 174, 175, 177, 178, 180)
-(SSD11A-PP51-164, 165, 166, 167, 170, 171, 172, 173)
-(SSD12A-PP52-172, 173, 175, 176, 177, 178, 180, 181, 183)
-(Seg035D-137, 138, 139, 146, 147, 148, 155, 156, 074)
-(Seg035E-013, 014, 015, 040, 041, 042, 031, 032, 033)

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

WELDING INSPECTION REPORT

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