

**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-011596**Date Inspected:** 10-Dec-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Sun Bo**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 COMPONENT**Summary of Items Observed:**

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

In process Inspection

Bay #9

This QA Inspector observed the following work in progress:

SAW in the 1G position for the OBG Deck Panel DP3003-001 to DP3003A-001 , weld No. DP-3003-001-021. The welder is identified as #059418. ZPMC QC is identified as Mr.Zhong Qiao. The welding variables recorded by QC appear to comply with WPS-B-T-2221-B-L2c-S-2 .

FCAW in the 1G position for the OBG Deck Panel DP3009-001 to DP3009A-001 , weld No. DP-3009-001-021. The welder is identified as #059416. ZPMC QC is identified as Mr.Zhong Qiao. The welding variables recorded by QC appear to comply with WPS-B-T-2231-B-U2-F .

Ultrasonic Testing(Phased Array)

The QA Inspector performed Phased Array Ultrasonic Testing (PAUT) on Orthotropic Box Girder deck plates to closed rib welds at the tack weld locations (marked for crack confirmation) which were previously tested by Caltrans QA personnel. The QA Inspector generated a field inspection UT report on this date designating areas of

---

# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

rejectable indications.

Panel identification numbers are

DP-3048-001(12AW)

## Green Tagging

This QA inspector performed Visual Inspection for Green Tagging which were previously tested and accepted by ZPMC Quality Control personnel and ABF QA personnel. The members are identified as OBG Deck Panels.

The Panels are as follows:

DP-3008-001 Green Tag No:010492

DP-3002A-001 Green Tag No:011827

## Magnetic Particle Testing

This Quality Insurance Inspector (QA) performed 15% verification Magnetic Particle Testing (MT) for OBG Deck Panel at outside yard area. This weld was previously tested and accepted by ZPMC QC MT technicians.

The weld designations reviewed are as follows:

DP-3008-001-011,012 and 013

DP-3002A-001-001,002 and 003

## Ultrasonic Testing

QA Verification UT performed after repair on portion of bottom plate of Splice joint Between 4AE to 4BE. This Inspection was performed after ABF UT Inspectors performed UT of this joint. The result were recorded onto a data sheet that Caltrans QA and ABF QA have jointly filled out on this date.

The Weld Designation is as follows

OBE4A-003

Unless otherwise noted, all work 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

*( Continued Page 3 of 3 )*

---

---

<b>Inspected By:</b>	Bera,Subhasis	Quality Assurance Inspector
----------------------	---------------	-----------------------------

<b>Reviewed By:</b>	Patterson,Rodney	QA Reviewer
---------------------	------------------	-------------