

**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-011873**Date Inspected:** 18-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.

**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-3028-001 (12CE) Green Tag No:11817

DP-3030-001 (12CE) Green Tag No:11830

**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-3028-001-001,002 and 003

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# WELDING INSPECTION REPORT

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DP-3030-001-001,005 and 007

## Ultrasonic Testing

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as segment 8BW for green tagging .

The Weld Designation is as follows

SEG045A-002,003,004 and 007

SSD13-PP65-002,003 and 009

The Caltrans Quality Assurance (QA) Inspector performed 10% verification of Ultrasonic Testing (UT) on the weld between Side Plate to Corner Assembly located at Segment 8BW near panel point 65 (PP65). The QA inspector discovered one (1) class "A" non-conforming indication measuring approximately 15 mm in length. The weld is identified as SEG045A-001 near PP65. The weld is located between Side Plate SP103A to Corner Assembly CA49A. The weld is a Complete Joint Penetration (CJP) Butt Joint.

This QA Inspector generated an incident report for this date.

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.

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<b>Inspected By:</b>	Bera,Subhasis	Quality Assurance Inspector
<b>Reviewed By:</b>	Patterson,Rodney	QA Reviewer

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