**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-011538
**Date Inspected:** 03-Jan-2010

**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:** | Lu Li Qing | **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 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.

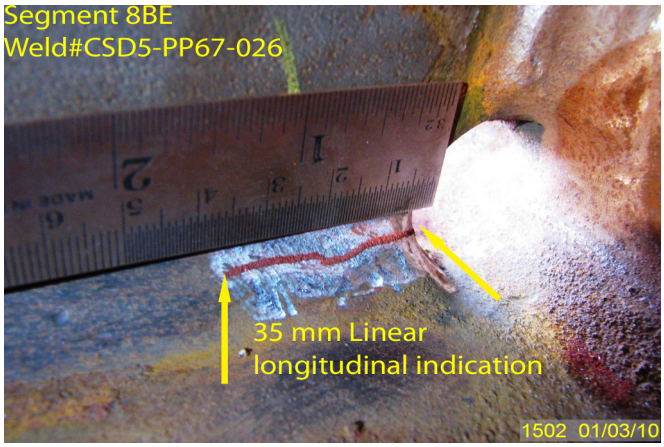
During the Quality Assurance Magnetic Particle Testing (MT) review of welds located on Segment8BE, this Quality Assurance Inspector (QA) discovered the following issues:
-Two (2) Longitudinal linear indication measuring approximately 22mm and 35mm in length.
-The welds are identified as: CSD5-PP67-052 (22 mm) and CSD5-PP67-026 (35 mm).
-The welds are a Fillet Weld type joining the Side Plate (SP467A) and Edge Plate (EP95A) stiffeners to Corner Assembly (CA52A) web plates.
-The OBG 8BE segment is located at outside yard.
The Notice of Witness Inspection Number (NWIT) is 004978. The indication is located inside the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. ZPMC's QC personnel are required to perform twenty five (25%) percent MT inspection of this weld.
For further information, please see the attached pictures below. Please see incident report on this date.

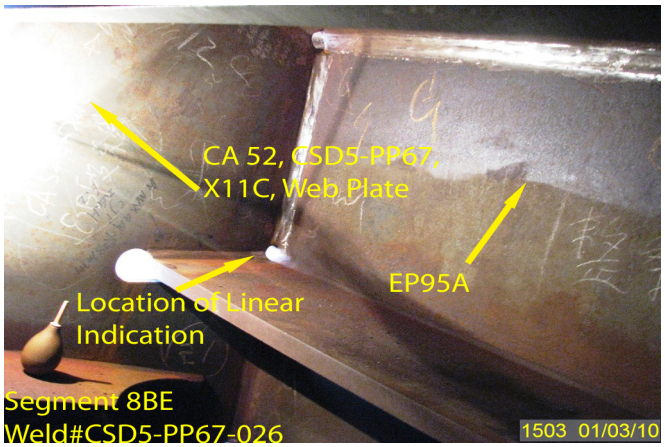
Segment 8BE
This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member is identified as OBG Components. The weld designations reviewed are as follows:

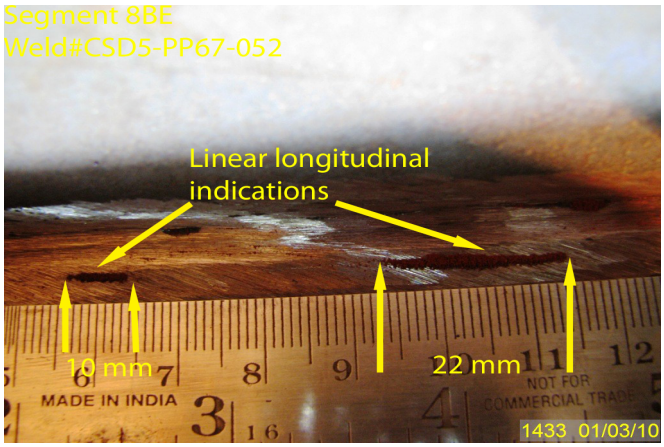
-(CA052-015, 018, 003, 004)

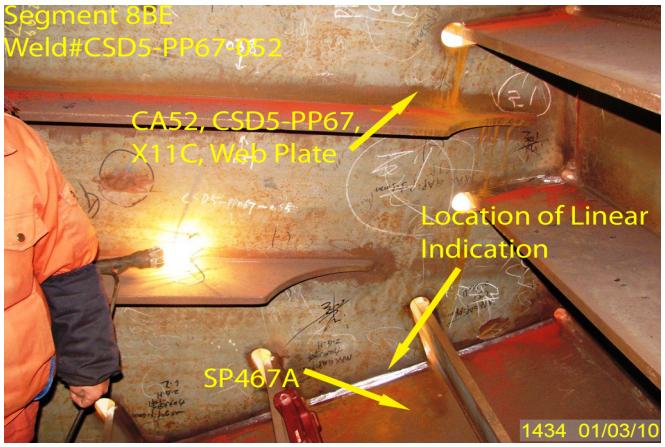
-(CSD2-PP64.5-053~074)
-(CSD2-PP65.5-053~074)
-(CSD2-PP66.5-053~074)
-(CSD5-PP65-005, 006, 011, 012, 023~032, 041~044, 051, 052)
-(CSD7-PP66-005, 006, 011, 012, 023~032, 041~044, 051, 052, 139~146)
-(CSD5-PP67-005, 006, 011, 012, 023~025, 027~032, 041~044, 051)
-(CSD5-PP67-026, 052)- Rejectable indication found.

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

*( Continued Page 3 of 3 )*

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