

**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-011886**Date Inspected:** 03-Feb-2010**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

<b>CWI Name:</b>	N/A	<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes No N/A	<b>Rod Oven in Use:</b>	Yes No N/A	
<b>Electrode to specification:</b>	Yes No N/A	<b>Weld Procedures Followed:</b>	Yes No N/A	
<b>Qualified Welders:</b>	Yes No N/A	<b>Verified Joint Fit-up:</b>	Yes No N/A	
<b>Approved Drawings:</b>	Yes No N/A	<b>Approved WPS:</b>	Yes No N/A	
		<b>Delayed / Cancelled:</b>	Yes No N/A	
<b>Bridge No:</b>	34-0006	<b>Component:</b>	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.

## Ultrasonic Testing (UT)

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 9AE Butt, Corner and "T" joint.

The Weld Designations are as follows

SEG19A-PP72-106,131,128,127,002,003,007

SEG19A-PP73-106,131,134,127,002,003,007

CA058-003,004

During the Quality Assurance Ultrasonic Testing (UT) review of welds located on Orthotropic Box Girder (OBG) segment 9AE, this Quality Assurance Inspector (QA) discovered the two (2) longitudinal Class "A" indication measuring approximately 15mm and 12 mm in length. The indication db ratings are +6 and +7.

Material thickness is 20mm for both joint. The depth of the indication is approximately 16.5mm and 17mm.

The welds are identified as SSD19A-PP72-134 and SSD19A-PP73-128. The welds are designated as Non Seismic Performance Critical Material. The indication is clearly marked on or near the weld. The Y distance for those

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# WELDING INSPECTION REPORT

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indications are 70mm and 55 mm from edge of the flange plate. The weld SSD19A-PP72-134 is Complete Joint Penetration (CJP) Butt joint joining Flange Plate X5D-2 (Non SPCM) to Floor Beam X5D(Non SPCM) and weld SSD19A-PP73-128 is Complete Joint Penetration (CJP) "T" joint joining Flange Plate X5D-2 (Non SPCM) to Floor Beam X7L(Non SPCM)

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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