

**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-012199**Date Inspected:** 22-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 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 8CE**

This QA Inspector performed a preliminary random visual inspection after the grit blast of the internal components of the side plate, floor beam and bottom plate of this segment. Areas of visual weld defects that will require welding were taped and will be repaired after the coating is applied. ZPMC QC personnel are aware of these areas and were present during the inspection.

During random visual inspection of OBG Segment 9DE, this QA inspector observed that approximately 90mm base metal repair location in segment 9DE @ PP 82. Component is identified as floor beam, FB012A. Base metal repair located on web plate of FB012A, X15B. The location requires grinding and MT for further evaluation. For further information, please see attached pictures.

**Segment 9DE**

This QA inspector performed VT of approximately 100% of the area previously tested and accepted by ZPMC Quality Control personnel. The member is identified as OBG Components. The weld designations reviewed are as follows. For further information, please see attached pictures.

-(FB003A-005)@ PP82- 3mm Visual Porosity.

-(FB012A-001)@ PP82

---

---

# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

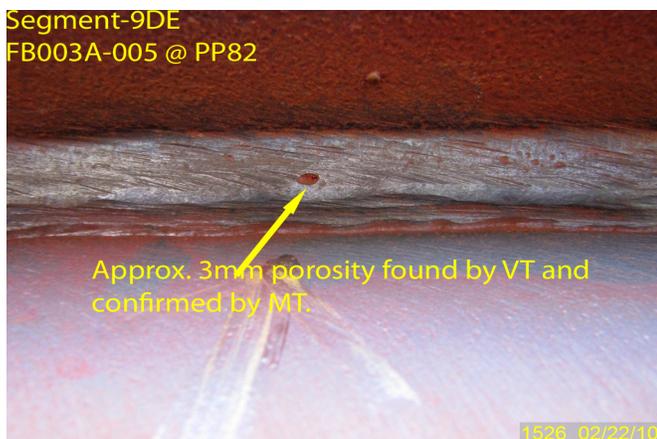
---

---

-(FB003A-004)@ PP81

-(FB024A-093)@ PP82

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.

---

**Inspected By:** Patel, Hiranch

Quality Assurance Inspector

---

**Reviewed By:** McClendon, Timothy

QA Reviewer