

**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-012308**Date Inspected:** 09-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**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, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

**OUTSIDE SHOP**

This QA inspector performed MT of critical weld repair areas those previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an MT report for this date. The members are identified as Segment 8CE. The weld designations reviewed are as follows:

FB003-088-004.

FB024-002-093.

DP418-001-163.

This QA inspector performed UT of critical weld repair areas those previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an UT report for this date. The members are identified as Segment 8CE. The weld designations reviewed are as follows:

SEG048\*-008.

SEG048B-032.

**OUTSIDE SEGMENT**

The following weld did not appear to comply with the applicable contract documents:

SEG 9BE:

1) PP75-FB003-146 – 004.

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- During in process visual inspection of the above mentioned weld, this QA observed Two (2) linear indications.
- This was confirmed with MT wherein, One (1) longitudinal crack measuring approximately 50 mm length. Second (1) linear crack measuring approximately 40mm length respectively were observed.
- The above mentioned welds were previously Magnetic Particle Testing (MT) tested and accepted by ZPMC Quality Control (QC) personnel.
- The member(s) are identified as OBG components – Floor Beam & Floor Beam Flange on PP75 east side.
- This QA Inspector has generated MT report for this date.
- For further information, please see the attached photos.

## SEG 9BE

### PP76 East side

- This QA inspector performed in process Visual Inspection of the below mentioned fillet welds between Floor Beam Flange and Floor Beam Web.

FB012-026-002.

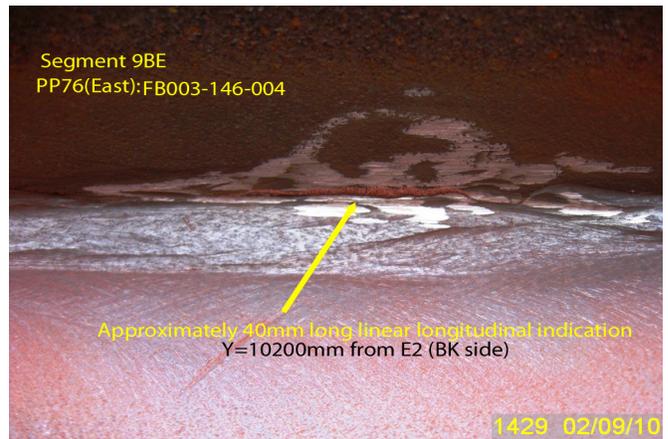
During the Quality Assurance Magnetic particle Testing (MT) review of welds located on OBG Segment 9BE, this Quality Assurance Inspector (QA) discovered the following issue:

- Two (2) linear Longitudinal indication that measured approximately 50mm and 40mm in length.

For more information please see the Incident report

04-0120F4\_TL-15\_B247\_02-09-10\_Seg9BE\_\_MT\_Linear\_Indication[1].

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

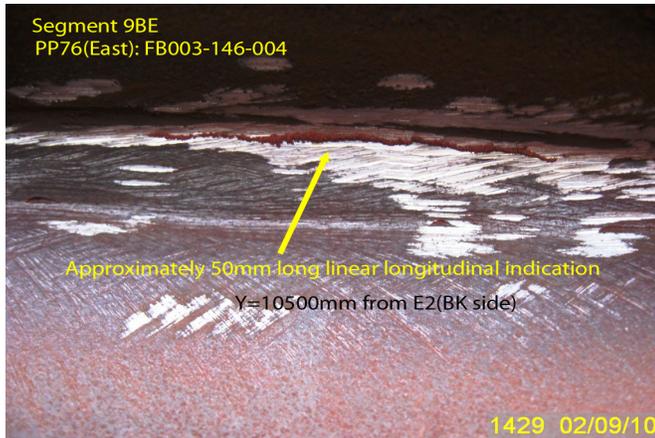


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## Summary of Conversations:

No relevant Conversation.

## 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-15--0042-2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Kumar, Chadra	Quality Assurance Inspector
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<b>Reviewed By:</b>	McClendon, Timothy	QA Reviewer
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