

**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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012335**Date Inspected:** 18-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) Chanxing 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 Segment 10BE	

**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA), Vibin Kumar Selvanayaham, was present during the times noted above for observations relative to the work being performed.

**Magnetic Particle Testing (MT)**

This QA inspector performed Visual Testing (VT) on OBG Segment 10BE and VT indications are confirmed by Magnetic Particle Testing (MT) on area previously tested and accepted by ZPMC Quality Control personnel.

This QA Inspector generated an MT report for this date. The indications are clearly marked on the material near the weld for future repair. The members are identified as OBG Segment 10BE. The weld designations reviewed are as follows:

**OBG Segment 10BE-PP90 West side**

1. FB016-039-003
2. FB003-160-004
3. FB010-032-001

**OBG Segment 10BE-PP90 East side**

1. FB016-039-004
2. FB003-160-005

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3. FB010-032-002

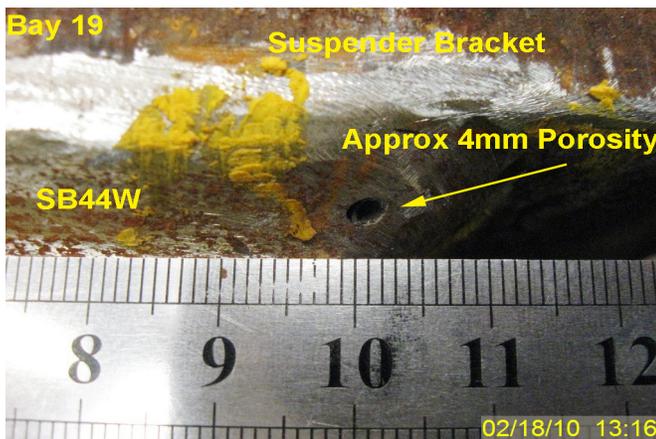
Bay 19

During random Quality Assurance visual review of welds located bay-19 on Suspender Brackets, this Quality Assurance Inspector (QA) discovered four (4) porosities, that measuring approximately 1.5 to 3mm in diameter. The indication is clearly marked on the material near the weld. The Suspender Brackets are identified as SB44W and SB38E. The Suspender Bracket weld is identified as Non SPCM. For further information, please see the attached pictures

BLAST SHOP 1

Caltrans Quality Assurance (QA) Inspectors performed random visual inspection of OBG segment 8CE interior Corner Assembly, Bottom Panel, Deck Panel, Floor Beam and Longitudinal Diaphragms surfaces from the panel point 67.5 to 69 after grit blasting and also carried out random visual inspection on segment 8CE exterior such as Bottom Panel, Deck Panel, and Side Panels. Areas that marked for repair were recorded for future repair. Areas requiring additional grinding were marked by QA and repaired by ZPMC personnel

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



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**Summary of Conversations:**

Only general conversation was held between QA and QC concerning this project.

**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 , who represents the Office of Structural Materials for your project.

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

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