

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-012350**Date Inspected:** 28-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

CWI Name:	N/A	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.

Segment-10AE

During the Quality Assurance Visual review of welds located on Segment 10AE, Caltrans Quality Assurance Inspectors (QA) discovered the following issues:

- One (1) linear indication in sub-assembly floor beam flange to web weld at panel point 87.
- The welds were identified as:
 - FB012-033-002 (7mm transverse linear indication) at "Y" location 3010mm (panel point 87 east side).
 - The "Y" Location measurement for weld FB012-033-002 was pulled from weld SSD17A-PP87-002.
- This indication is clearly marked on the material or near the weld.
- Visual indication was confirmed by Magnetic Particle Testing by Caltrans QA.
- Indication appears to be outside of the area tested and accepted by ZPMC QC.
- The welds are 6mm fillet welds joining the FL1 floor beam web to flange.
- This OBG Segment is located at outside yard.

For further information, please see the attached pictures below.

Segment 10AE

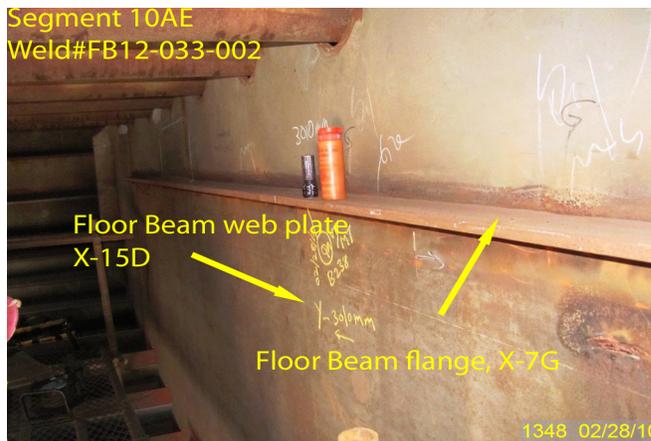
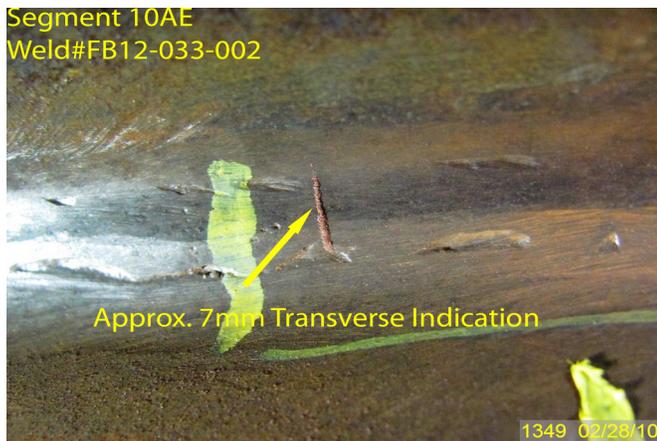
This QA inspector performed VT of approximately 100% of the area previously tested and accepted by ZPMC Quality Control personnel. The member is identified as OBG Components. The weld designations reviewed are as follows. For further information, please see attached pictures.

WELDING INSPECTION REPORT

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- (FB003-161-004/005)@ PP86
- (FB012-031-001/002)@ PP86
- (FB020-006-092/93)@ PP86
- (FB003-169-004/005)@ PP87
- (FB012-033-001/002)@ PP87
- (FB024-008-092/093)@ PP87

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