

**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-013393**Date Inspected:** 01-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**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 9BE	

**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.

Ultrasonic Testing (UT) - Document: 005442

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Segment 9BE. The weld designations reviewed are as follows:

1. SEG052\*-001~006
2. SEG052\*-011, 012, 017, 018, 023, 024
3. SEG05C\*-002~005, 052~056, 061~064
4. SSD16A-PP074-001, 008, 126, 127, 130, 105
5. SSD17A-PP075-001, 008, 126, 127, 130, 105
6. SSD18A-PP076-002, 009, 129, 130, 133, 108
7. CA060-003, 004
8. SEG052E-173, 119, 110, 101
9. SEG052A-023, 026
10. SSD18A-PP076-253, 257, 243, 247

Ultrasonic Testing (UT) - Document: 005457

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## WELDING INSPECTION REPORT

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This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Segment 9BE. The weld designations reviewed are as follows:

1. SEG0051A-003
2. SEG0051\*-003
3. SEG052\*-015

Description of Incident: During the Quality Assurance Ultrasonic Testing (UT) review of weld located on Segment 9BE, this Quality Assurance Inspector (QA) discovered One (1) Class “B” indication measuring approximately 20mm in length. The indications D-rating are +11dB each and the weld joint is identified as SEG052\*-001. The weld is a Complete Joint Penetration (CJP) butt weld joining Side plate to Side plate. The Thickness of the Side plate is 14mm. The indications are clearly marked by QA on/near the weld. This weld joint is designated as Seismic performance critical weld member (SPCM). The indication is located inside the area that has been previously 100% tested and accepted by ZPMC Quality Control (QC) personnel.

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

### 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
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<b>Reviewed By:</b>	McClendon,Timothy	QA Reviewer
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