

**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-013646**Date Inspected:** 25-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**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**Summary of Items Observed:**

CWI Inspectors: NA

On this date CALTRANS OSM Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. This QA Inspector observed the following:

OBG Yard, between of Bay 15 and the blast shop

ZPMC has recently presented QA personnel with a "Notification of Witness Inspection" document that states ZPMC is requesting Caltrans to perform magnetic particle (MT) inspections of OBG segment 9EE. QA Inspector was informed the welds identified on tag numbers 3 and 7 remain to be completed. This QA Inspector performed random magnetic particle (MT) inspections of the welds that are listed below and these welds appear to comply with AWS D1.5 MT requirements. For additional information on these inspections see this QA Inspector's TL6028 Magnetic Particle Test Report for additional information.

Tag 3 MT: Segment 9EE welds

SEG058C-16, 22

Tag 5 MT: Segment 9EE welds

CSD2-PP82.5-52, 54, 72, 74, 76, 78

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# WELDING INSPECTION REPORT

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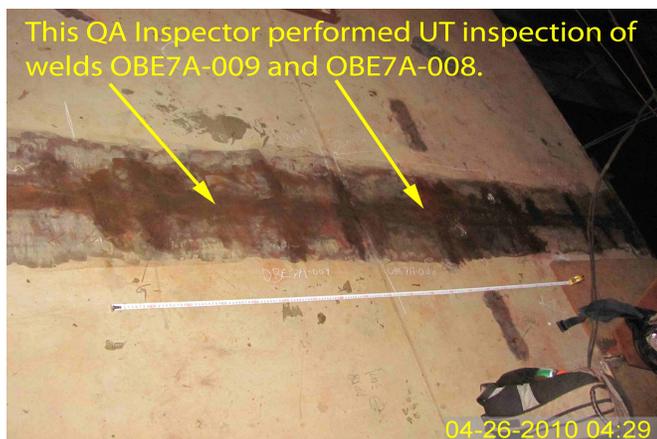
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CSD2-PP83.5-51, 53, 59, 60, 76, 78  
CSD5-PP85-44, 46, 48, 52, 54, 26  
CSD5-PP84-04, 10, 41, 51, 43, 53, 45  
CSD7-PP84-06, 10, 44, 46, 52, 54, 146, 148

## Segment Assembly

ABF issued UT inspection report number UT-7E-066 informing QA personnel that on 4-24-2010 Inspectors had completed ultrasonic (UT) inspections of OBG segment 7DE / 7EE welds OBE7A-007, OBE7A-008 and OBE7A-009 which join the top deck plates together. These welds are located at the Trial Assembly area. This QA Inspector observed ABF has identified weld rejections on weld OBE7A-007 at locations Y=1570mm, Y=1580mm and weld OBE7A-009 has one weld rejection at Y=1520mm. This QA Inspector performed ultrasonic inspections for detection of longitudinal and planar transverse indications utilizing scanning patterns A, B, C and D (AWS D1.5 Fig 6.7) of approximately one meter length of each of the three welds listed above and no additional weld repair locations were observed. Note: These inspections are being documented and tracked on "Verification Witness Request" documents and no TL-6027 UT report was issued for these inspections. Note: Caltrans QA Inspector Mr. Mike Hasler also performed random ultrasonic inspections of weld OBE7A-008. See the photograph below for additional information.



### Summary of Conversations:

See Above.

### 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 phone: 150-0042-2372 , who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Dawson,Paul	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer

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