

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

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-013736**Date Inspected:** 24-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 9EE	

**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: 005583

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 9EE. The weld designations reviewed are as follows:

1. SEG058\*-017, 018
2. SEG058A-001, 002, 003, 004
3. SEG058B-002, 012, 014, 044
4. SEG058B-001, 011, 013, 043
5. SEG058B-003, 017, 019
6. SEG058B-005, 021, 023, 047
7. SSD19A-PP083-002, 009, 127
8. SSD19A-PP084-002, 007, 106, 131, 126, 127
9. SSD19A-PP085-002, 007, 106, 131, 126, 127
10. CA069-003, 004

Description of Incident: During the Quality Assurance Ultrasonic Testing (UT) review of weld located on Segment

---

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---

---

9EE, this Quality Assurance Inspector (QA) discovered Three (3) Class “A” indication measuring approximately 15 to 25mm in lengths. The indications D-rating are +1 to 4dB. The weld joints are identified as SSD019A-PP084-105, SSD019A-PP084-131 and SSD019-PP083-135. The welds are Complete Joint Penetration (CJP) butt joints joining floor beam FB016A to Floor beam FB013B. The Thickness of the floor beam butt joint is 30mm. The indications are clearly marked by QA on/near the weld. This weld joint is designated as non Seismic performance critical weld member (non 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.

---

<b>Inspected By:</b>	Kumar,Vibin	Quality Assurance Inspector
----------------------	-------------	-----------------------------

---

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