

**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-013931**Date Inspected:** 11-May-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), Changxing 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	

**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

TRIAL ASSEMBLY YARD

ULTRASONIC INSPECTION

OBG SEGMENT 8BE

ABF Request No: 05102010-2

This QA Inspector performed Ultrasonic Testing (UT) on approximately 10% of OBG components previously accepted by ZPMC ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3 and Detection of Transverse Planar Discontinuities with Significant Flaw Height Dimension Procedure. Inspection was carried out on repair areas. Weld identification numbers were.

CA052-002, 006 (8BE, D.P to E.P- Bike path side)

This QA Inspector performed conventional UT (Ultrasonic Testing) after ABF UT department for detection of planar transverse indication.

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# WELDING INSPECTION REPORT

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No relevant indications were observed

## ULTRASONIC INSPECTION

### OBG SEGMENT 7EE

ABF Request No: 05102010-2

This QA Inspector performed Ultrasonic Testing (UT) on approximately 10% of OBG components previously accepted by ZPMC ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3 and Detection of Transverse Planar Discontinuities with Significant Flaw Height Dimension Procedure. Inspection was carried out on repair areas. Weld identification numbers were.

CA045-002, 006 (7EE, D.P to E.P- Cross beam side)

This QA Inspector performed conventional UT (Ultrasonic Testing) after ABF UT department for detection of planar transverse indication.

No relevant indications were observed.

### OBG SEGMENT 8AE-8BE

## MAGNETIC PARTICLE INSPECTION

ZPMC NWIT No: 005707

This Q.A Inspector performed Magnetic particle testing of approximately 15% of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (M.T) report for this date. The members are identified as the Corner assembly. The welds Designation are as follows.

SEG044A-027

CA48-001

CA051-001

CA052-005

### OBG SEGMENT 7BW-7CW-7EW

ZPMC NWIT No: 005708

This Q.A Inspector performed Magnetic particle testing of approximately 15% of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (M.T) report for this date. The members are identified as the floor beam stiffener to the longitudinal diaphragm top flange. The welds Designation are as follows.

SEG035B-032, 040

SEG035C-040, 032

SEG037B-018, 021

SEG037C-008, 017

SEG041B-010, 016

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SEG041C-007, 008

TRIAL ASSEMBLY YARD

MAGNETIC PARTICLE INSPECTION

OBG SEGMENT 7EE

ABF Request No. 05102010-2

This QA Inspector Witnessed ABF personal performing Magnetic particle Testing (MT) on weld between edge panel and deck panel (Cross beam side) of the OBG segment 7EE. Inspection was carried out on repair areas. Weld identification number was.

CA078-004 (10CE, D.P to E.P- Bike path side)

During the magnetic particle inspection ABF QA Inspector found five transverse linear indications.

MAGNETIC PARTICLE INSPECTION

OBG SEGMENT 8BE

ABF Request No. 05102010-2

This QA Inspector Witnessed ABF personal performing Magnetic particle Testing (MT) on weld between edge panel and deck panel (bike path side) of the OBG segment 8BE. Inspection was carried out on repair areas. Weld identification number was.

CA052-002, 006 (8BE, D.P to E.P- bike path side)

During the magnetic particle inspection ABF QA Inspector found two transverse linear indications.

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.



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# WELDING INSPECTION REPORT

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**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, +(86) 1500 042 2372, who represents the Office of Structural Materials for your project.

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

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