

**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-016199**Date Inspected:** 08-Aug-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 Segments	

**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 No: 006344

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 11EW. The weld designations reviewed are as follows:

1. SEG 073A-005, 006, 008, 009, 010
2. SEG073B-002, 006, 012, 032
3. CA092-003, 004

Description of Incident: During the Quality Assurance Magnetic Particle inspection on Bike Path at Bay 19, this Caltrans Quality Assurance (QA) Inspector observed that one cope hole/snipe has been welded shut on bike path identified as BK004A-004. The approved shop drawing specifies a cope hole/snipe located at the intersection of stringer plate BKPL7B and intermediate end diaphragm BKX10. A cope hole/snipe is specified at the end of welds identified as BK004A8-004-078 and BK004A8-004-076. This Bike Path is located in the west side of Bay 19. See the attached pictures.

Magnetic Particle Testing (MT) - Document No's: 006355

---

---

# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---

---

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as OBG Bike Path. The weld designations reviewed are as follows:

1. BK004A2-004-004
2. BK004A3-004-019, 020, 043, 044
3. BK004A4 - 004 - 006, 007, 032, 033, 058, 059
4. BK004A6-004-002, 061, 063, 065, 070, 076, 078, 080, 082, 072, 073, 001, 165
5. BK004A8-004-002, 076, 078, 080, 082, 086, 088, 090, 092, 072, 073, 001, 130

BK004A2-004-001, 003, 005, 006, 007, 009, 010, 011, 012 weld joints have VT problems such as no welding, under fill, undercut, lack of fusion etc..

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.

---

**Inspected By:** Kumar,Vibin

Quality Assurance Inspector

---

**Reviewed By:** McClendon,Timothy

QA Reviewer