

**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-017088**Date Inspected:** 18-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), 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 COMPONENT	

**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

## Ultrasonic Testing (UT) for Segment 11CW

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as segment 11CW weld joints.

The welds designation reviewed are as follows:

SEG069\*-006,007,008,009,010  
SEG069B-004,005,006,020,025,026  
SSD14-PP101-002,009  
CSD2-PP101.5-007,011  
SSD13-PP102-003,002,009,131,132,135,136,108  
CSD9-PP102,-085,089,113,131,133,083,081,065,067,143  
SSD14-PP103-002,009,131,132,202,135,108

During the Quality Assurance Ultrasonic Testing (UT) review of welds located on Orthotropic Box Girder (OBG) segment 11CW, this Quality Assurance Inspector (QA) discovered the following issues that One (1) longitudinal

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# WELDING INSPECTION REPORT

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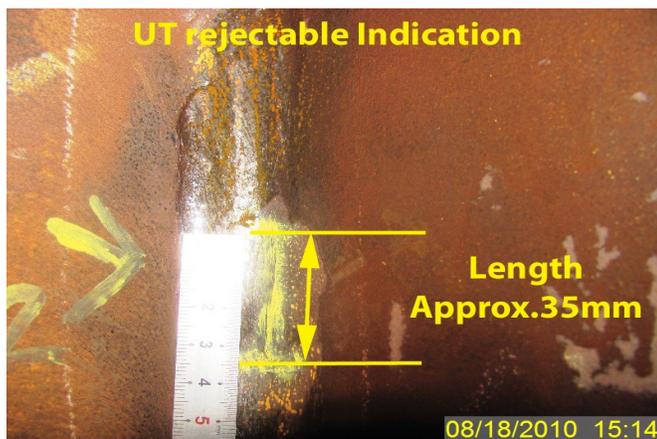
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linear Class “A” rejectable indication measuring approximately 35mm in length. The indication dbS rating is a +5. Material thickness is 22mm and the depth of the indication is approximately 12.2mm. The weld is identified as CSD9-PP102-067 at Counter Weight Side on Panel Point PP102. According to approved shop drawing, the weld is fillet weld. But converted to CJP “T” joint by ZPMC personnel because of excessive root gap. The joint connects the Corner Assembly Diaphragm (X151A) to Deck Plate Stiffener (RS62BC). The indication is clearly marked on or near the weld. The Y distance for this indication is 75 mm from top cope hole of the stiffener. Segment 11CW is located at near trial Assembly Area. The Notice of Witness Inspection (NWIT) No. is 006413. The indication is located within an area previously tested and accepted by ZPMC Quality Control (QC) personnel. As per the contract documents, ZPMC’s QC personnel are required to perform hundred (100%) percent UT inspection of this weld.

The QA Inspector generated an incident report on this date.

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



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

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**Inspected By:** Bera, Subhasis

Quality Assurance Inspector

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**Reviewed By:** Patterson, Rodney

QA Reviewer