

**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-003575**Date Inspected:** 08-Aug-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2230**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Fu Yu Hong**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:**

CALTRANS Quality Assurance (QA) Inspector, Alfredo Acuna was present for the fabrication scheduled for this project at the ZPMC facility in Shanghai, China for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

The QA Ultrasonic testing with Phased Array (UT)

The QA inspector performed ultrasonic testing (UT) with the phased array (PA) technology after Caltrans representatives performed the preliminary scan with the conventional UT following ZPMC UT procedure for detecting lack of penetration at the junction of deck panel to U-ribs. The QA inspector was performing 100 % UTPA at tack welds areas suspected to be crack like indications. The QA inspector confirmed crack like indications as follows: 1. Deck panel DP-025-001 suspected to be crack like indications with conventional UT, 7; confirmed with the Phased array method 3, DP-026-001 suspected to be crack like indications 12, confirmed with the PA method 5, DP-027-001 suspected to be crack like indications 14, confirmed with the PA method 10, DP-026-002 suspected to be crack like indications 26, confirmed with the PA method 22 and DP-068-001 suspected to be crack like indications 6, confirmed with the PA method 6.

Note: 2 Panels were Purchased by CT for testing Initial procedural development and further procedure development & testing. At the time no writing procedure have been issued. However, all the test samples identified as crack indication were confirmed after macro-etching and magnetic particle testing.

**Summary of Conversations:**

As noted above.

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# WELDING INSPECTION REPORT

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## 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 Ady Velasco. 858 344-8746, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Acuna,Alfredo	Quality Assurance Inspector
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<b>Reviewed By:</b>	Cochran,Jim	QA Reviewer
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