

**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 #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006186**Date Inspected:** 30-Mar-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yan Hua**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 Assembly**Summary of Items Observed:**

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

Segment Repair Yard (North of the paint shop)

Segment 1BE

This QA Inspector performed Magnetic Particle testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (MT) report for this date. The members are identified as the floor beam to bottom plate attachment welds. The Weld Designations are as follows:

SSD45-PP12.5-106, 107, 108, 109, 110, 111, 112 and 113.

During random verification Magnetic Particle Testing of floor beam to bottom plate weld numbers SSD45-PP12.5-106, 107 and 109, Caltrans Quality Assurance (QA) Inspector discovered a total of eight (4) transverse linear indications from 10mm to 20mm in length. See incident report on this date.

This QA Inspector performed Magnetic Particle testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (MT) report for this date. The members are identified as the deck panel to diaphragm welds. The Weld Designations are as follows:

DP581-098, 100, 101, 103, 105, 125, 126, 127, 129 and 130.

DP586-001-124, 126, 129, 130, 128, 130, and 132.

DP591-152, 154, 155, 159, 157, 160, 184, 186, 187 and 190.

---

---

# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

---

DP611-095, 097, 098, 092, 093, 089, 140, 137, 139, 135, 134 and 141.

DP596-158, 160, 161, 163, 164, 166, 192, 194, 195, 197, 199 and 198.

DP616-088, 092, 093, 097, 095, 099, 131, 134, 135, 139 and 137.

DP586-002-124, 126, 127, 129, 130 and 132.

DP606-098, 100, 101, 103, 104 and 106.

DP601-192, 194, 195, 199, 197 and 200.

## Segment 4BE

This QA Inspector performed Ultrasonic testing (UT) of approximately 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 the deck panel splice welds. The Weld Designations are as follows: SEG020\*-001, SEG020\*-002, SEG020\*-003, SEG020\*-004, SEG020\*-005, SEG020\*-006, SEG020\*-025, SEG020\*-026, SEG020\*-027 and SEG020\*-028.

This QA Inspector performed Magnetic Particle testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (MT) report for this date. The members are identified as the longitudinal diaphragm splice welds. The Weld Designations are as follows: SEG20B-002, 003, 004, 015, 023, 024, 025 and 027. SEG20C-002, 003, 004, 005, 020, 021, 022, 023, 029 and 031.

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, (15000422372), who represents the Office of Structural Materials for your project.

---

**Inspected By:** Patterson,Rodney

Quality Assurance Inspector

---

---

# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

---

**Reviewed By:** Carreon,Albert

QA Reviewer