

**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-006195**Date Inspected:** 06-Apr-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 Splice Yard (North of bay 12)

Crossbeam 2

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 side and bottom panel corner joints. The Weld Designations are as follows:

CB204A-002, 005, 011, 014, 017, and 019.

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 floor beam super assembly welds. The Weld Designations are as follows:

CB204J-001-001, 002, 003, 004, 023, 024, 025, 026, 041, 042, 043, 044, 046, 065, 069, 070, 077, 078, 079, 080, 087, 088, 089, 090, 113, 114, 143, 144, 141, 142, 145, 146, 163, 164, 165, 166, 167, 168, 187, 188, 189, 190, 191, 192, 193, 194, 217, 218, 223, 224, 237, 238, 271, 272, 283, 284, 287 and 288.

CB204J-002-001, 002, 003, 004, 023, 024, 025, 026, 041, 042, 043, 044, 046, 065, 069, 070, 077, 078, 079, 080, 087, 088, 089, 090, 113, 114, 143, 144, 141, 142, 145, 146, 163, 164, 165, 166, 167, 168, 187, 188, 189, 190, 191, 192, 193, 194, 217, 218, 223, 224, 237, 238, 271, 272, 283, 284, 287 and 288.

CB204J-1-001-001~30.

CB204J-1-002-001~30.

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## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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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 side panel super assembly welds. The Weld Designations are as follows:

DP524-020 and 021

DP525-103, 104, 111 and 112

DP526-032, 036, 111 and 112

DP527-011 and 022

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 bottom panel super assembly welds. The Weld Designations are as follows:

BP212-027 and 028

BP213-031 and 032

BP214-031 and 032

BP215-027 and 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 side panel super assembly welds. The Weld Designations are as follows:

SP216-031 and 087

SP217-031 and 034

SP218-041 and 045

SP219-031 and 087

SP220-034

Blast Shop

Segment 4BE

This QA Inspector performed a preliminary random visual inspection after the grit blast of the internal components of the bottom and side plates. Areas of visual indications that will require welding were taped and will be repaired after the coating is applied. ZPMC QC personnel have been made aware of these defects but were not present at the time of inspection.

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.

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# WELDING INSPECTION REPORT

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<b>Inspected By:</b>	Patterson,Rodney	Quality Assurance Inspector
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<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer
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