

**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-006516**Date Inspected:** 16-May-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 Blast Shop)

Segment 2AE

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 diaphragm to U-rib welds. The Weld Designations are as follows:

DP593-056, 058, 059, 061, 062, 096, 097, 099 and 101.

DP583-038, 040, 041, 043, 044, 064, 065, 067, 070 and 069.

DP588-001-048, 050, 051, 053, 054, 082, 083, 085, 087 and 089.

DP588-002-048, 050, 051, 053, 054, 082, 083, 085, 087 and 089.

DP598-056, 058, 059, 061, 062, 096, 097, 099, 101, and 102.

DP603-056, 058, 059, 061, 062, 096, 097, 099, 101 and 102.

DP608-038, 040, 041, 043, 044, 064, 065, 067, 070 and 069.

DP612-270, 272, 268, 267 and 264.

DP617-244, 247, 248, 250 and 252.

DP617-002-244, 247, 248, 250 and 252.

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

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members are identified as the longitudinal diaphragm super assembly welds. The Weld Designations are as follows:

SEG008B-001, 003, 007, 009, 031 and 033.

SEG008C-001, 003, 007, 009, 031 and 033.

SEG008D-003, 005, 009, 029, 035 and 039.

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 corner assembly welds. The Weld Designations are as follows:

CA100-007, 010, 019~024, 047~052 and 075~078.

SSD56-PP14.5-134~145, 160, 161, 185 and 186.

SSD17-PP15-136~147.

SSD18-PP16-140~151.

CSD10-PP14.5-065~076.

CSD5-PP15-063~074.

CSD2-PP16.5-049~056.

CSD4-PP16-069~074 and 130~134.

During random verification Magnetic Particle Testing of open rib deck stiffener to the corner assembly floor beam web plate weld numbers SSD56-PP14.5-141,137, SSD17-PP15-142 and CSD10-PP14.5-073, Caltrans Quality Assurance (QA) Inspector discovered a total of four (4) longitudinal 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 floor beam super assembly welds. The Weld Designations are as follows:

SSD55-PP13-197 and 198.

SSD55A-PP13-003, 139 and 140.

SSD57-PP13.5-125.

SSD57A-PP13.5-003 and 133.

SSD54-PP14-012 and 013.

SSD54A-PP14-003, 133 and 134.

SSD56-PP14.5-125 and 131.

SSD56A-PP14.5-124 and 136.

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

**Summary of Conversations:**

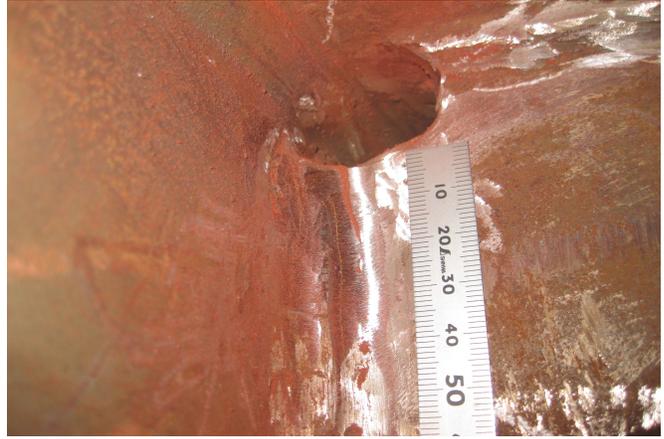
No Relevant conversations

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

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**Inspected By:** Patterson,Rodney

Quality Assurance Inspector

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**Reviewed By:** Carreon,Albert

QA Reviewer