

**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-006598**Date Inspected:** 21-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 Repair Yard (South of bay 13)

Segment 1BW

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:

DP541-038~057.

DP551-058~065.

DP556-056~063.

DP561-056~063.

DP566-038~047.

DP571-098~109.

DP576-078~89.

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 attachment welds. The Weld Designations are as follows:

SEG005B-005, 006, 009, 010, 034 and 036.

SEG005C-005, 006, 009, 010, 034 and 036.

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# WELDING INSPECTION REPORT

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SEG005D-009, 029, 051 and 071.

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 component welds. The Weld Designations are as follows:

SSD44A-PP10.5-106~123.

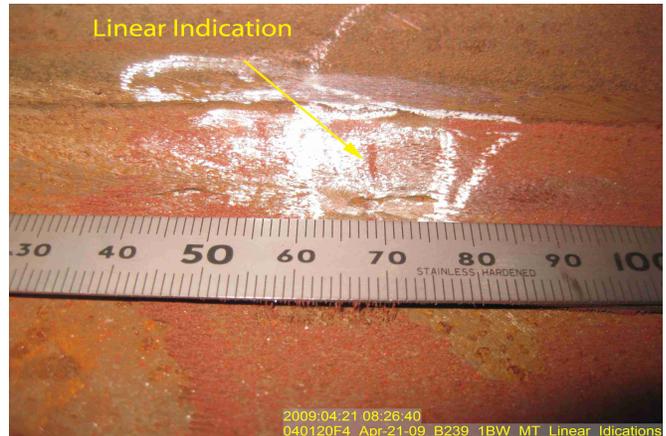
SSD44-PP10.5-106~129.

During random verification Magnetic Particle Testing of the floor beam web to bottom plate weld# SSD46A-PP11-117, Caltrans Quality Assurance (QA) Inspector discovered a total of one (1), 15mm long transverse linear indication previously overlooked by ZPMC Quality Control MT Technicians. This QA inspector then carried out random Magnetic Particle Testing of areas NOT previously tested by ZPMC Quality Control MT Technicians and discovered welds with multiple transverse linear indications. See 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, (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