

**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-007429**Date Inspected:** 14-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wu Zhi Cheng**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:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Larry Viars was present during the times noted above for observations relative to the work being performed.

**OBG Trial Assembly Area-**

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 an MT report for this date. The member was identified as OBG Segment 4BE longitudinal diaphragm weld SEG020C-007.

This QA inspector performed Ultrasonic Testing (UT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member are identified as OBG Segments 2AE to 2BE stiffener splice welds for Bottom and Side Plates.

During Ultrasonic testing verification of 2AW to 2BW stiffener complete joint penetration welds as requested in NDT Inspection Notification Sheet number 003423. This QA Inspector observed that the weld DP724-001-025 and several adjacent welds were UT tested and accepted by ZPMC QC without the removal of paint from the base metal for the full scanning distance surface area. The thickness of the stiffener base metal of the associated weld joints were 30mm and 35mm. This base metal thickness requires a transducer stand-off distance for scanning of 83mm and 92mm, respectively from the centerline, when scanning is performed from both Face A and B. When scanning is performed from only face A the transducer stand-off distance for scanning required 165mm and 192mm respectively, from the toe of the weld. The paint was observed to be removed from approximately 50 mm

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# WELDING INSPECTION REPORT

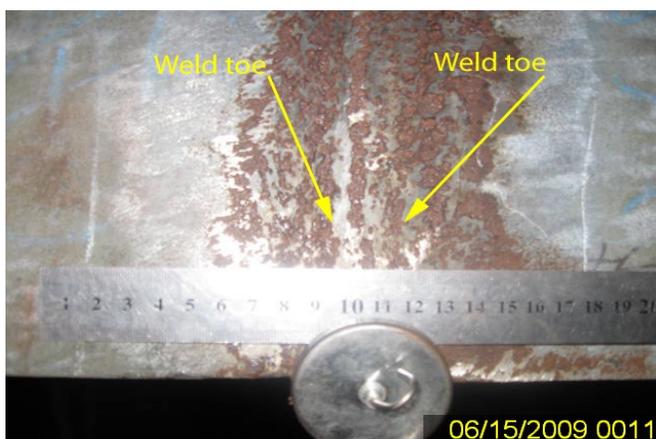
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of the base metal surface both sides of weld centerline. An incident report was issued on this date for the above mentioned violation of AWS Section 6.19.3.

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



### Summary of Conversations:

As identified within the contents of this report.

### 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, 150 0042 2372, who represents the Office of Structural Materials for your project.

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

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