

**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-007657**Date Inspected:** 25-Jun-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 yang**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 Cross Beam 06**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, D.Sukanthan was present during the time noted above for observations relative to the work being performed.

OBG # BAY 6

This QA inspector performed Magnetic Particle Test of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an Magnetic Particle Test report for this date. The member is identified as Skin A Shear link / Tower 123M Diaphragm. The weld designations reviewed are as follows:

(WD1-A305-77M-3-56A, 57A, 5B, 3A, 6B, 4A)

(WD1-A305-77M-2-56A, 5B, 3A, 4A)

(WD1-A305-77M-4-57A, 6B)

(WD1-A305-65M-2-4A, 6B)

(WD1-A305-65M-3-4A, 6B)

(WSD1-DPSA4-5B/B-5, 8, 17)

This QA Inspector randomly observed the following work in progress:

OBG # Cross Beam 06 – OPEN YARD

---

---

# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---

---

This QA inspector observed that ZPMC has deviated from the weld joint design on welds by changing the fillet weld detail to a complete joint penetration (CJP) without the approval of the Engineer. The weld designations reviewed are as follows:

202G-009-043,044

202G-010-043,044

202G-011-043,044

202G-012-043,044

202G-009-089,090,091,092,093,094,095,096

202G-012-117,118,119,120,167,168

### Summary of Conversations:

The QA Inspector informed ZPMC QC Mr. Chen shi ming that the weld joint design on welds by changing the fillet weld detail to a complete joint penetration (CJP) without the approval of the Engineer. The QA Inspector informed that the QA Inspector will be issuing incident 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 150-00422372, who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Sukanthan,Dhanasingh	Quality Assurance Inspector
<b>Reviewed By:</b>	Prue,Erik	QA Reviewer

---