

**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-007866**Date Inspected:** 30-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**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.

Trial Assembly Yard

Lift 1~5 East/West

This QA Inspector was instructed by task leaders to carry out a close up inspection of areas that were previously green Tagged in the various Segment repair yards prior to Blast, that have had components or welds removed and/or heat straightened in the trial assembly process. The green tags that were issued prior to the removal of welds will be withdrawn until further NDT is completed by ZPMC personnel and confirmed by CALTRANS QA Inspectors. It was found that the following Segment Green tags will need to be withdrawn;

Lift 2

Segment 2AE Segment Tag #3 (Longitudinal Diaphragms)

Segment 2BW Segment Tag #3 (Longitudinal Diaphragms)

Segment 2BE Segment Tag #3 (Longitudinal Diaphragms)

Lift 3

Segment 3AW Segment Tag #16 (Longitudinal Diaphragms)

Segment 3AE Segment Tag #3 (Longitudinal Diaphragms)

Segment 3BW Segment Tag #8 (Longitudinal Diaphragms)

Segment 3BE Segment Tag #3 (Longitudinal Diaphragms)

Lift 4

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# WELDING INSPECTION REPORT

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Segment 4AW Segment Tag #5 (Longitudinal Diaphragms) Tag #2 (Side PL-Btm PL)

Segment 4AE Segment Tag #3 (Longitudinal Diaphragms)

Segment 4BW Segment Tag #5 (Longitudinal Diaphragms)

Segment 4BE Segment Tag #3 (Longitudinal Diaphragms)

Lift 5

Segment 5AW Segment Tag #2 (Longitudinal Diaphragms)

Segment 5AE Segment Tag #2 (Longitudinal Diaphragms)

Segment 5BW Segment Tag #2 (Longitudinal Diaphragms)

Segment Repair Yard (South of bay 14)

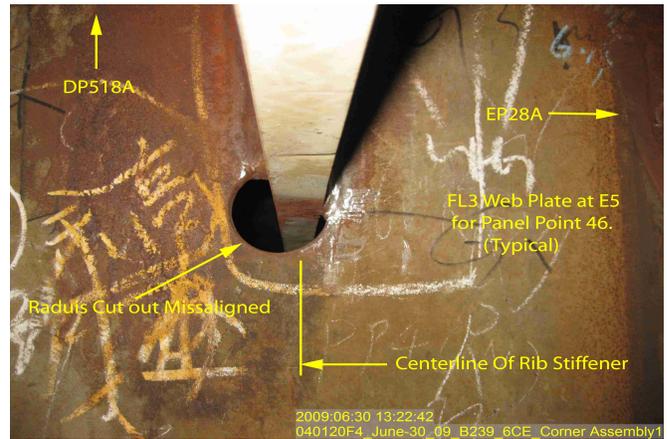
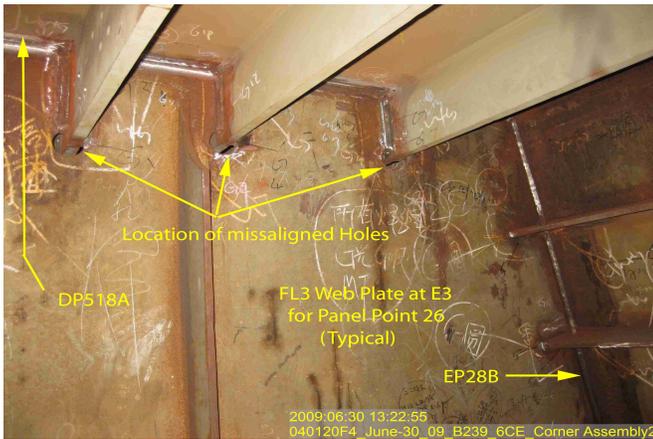
Segment 6CE

During random in process visual inspection of the internal components of Segment 6CE, Caltrans Quality Assurance (QA) Inspector discovered that the radius cut outs in the floor beam web plate, for deck panel 518A rib stiffener penetrations, were misaligned in way of E5 at the following panel points; 44, 45, 46, 46.5 and 47. A total of (11) eleven locations were noted with the fabrication issue as mentioned above. See incident report for 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

**Reviewed By:** Carreon,Albert

QA Reviewer