

**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-008109**Date Inspected:** 09-Jul-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:** Lui Wei Wei**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:**

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 12**

This QA inspector performed Ultrasonic Test of approximately 10% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an Ultrasonic Test report for this date. The member is identified as Splice on U - Rib. The weld designations reviewed are as follows:

(USPL1-140-001) Rejectable Indication found by UT method.

(USPL1-140-002)

(USPL1-131-001, 002)

(USPL1-117-001,002)

(USPL1-118-001,002)

(USPL1-119-001,002)

(USPL1-105-001,002)

**OBG # BAY 05**

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

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this date. The member is identified as Traveler Rail. The weld designations reviewed are as follows:

(TR6A-PP16-001,002)

(TR1A-PP17-002)

(TR5B-PP13-003,004)

(TR5B-PP15-003,004)

This QA Inspector randomly observed the following work in progress:

OBG # Cross Beam 07 – BAY 01

Flux Cored Arc Welding Process:

Welding of weld joint –002 located on PCMK CB201A-007. Welder is identified as 216575/054460. ZPMC QC is identified as Lui Wei Wei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-TC-U4b-F.

Welding of weld joint –053,054 located on PCMK FB204-013. Welder is identified as 251246. ZPMC QC is identified as Lui Wei Wei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-B-U2-F.

OBG # BAY 02

This Quality Assurance Inspector (QA) observed ZPMC personnel performing welded restoration of the material with mislocated drill holes at 5 locations. The member is identified as Floor beam FB020-005. ZPMC QC did not provided WPS or Engineer notification for the above mention Repair

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

### **Summary of Conversations:**

The QA Inspector informed ZPMC QC Mr. Shen xue jian that after Ultrasonic testing verification of weld USPL1-140-001, that was previously accepted by ZPMC (UT) technicians, a total of one (1) Class “A” Rejectable indication was found by this QA inspector.

The QA Inspector informed ZPMC QC Mr. Shen xue jian that this QA inspector observed ZPMC personnel performing welded restoration of the material with mislocated drill holes at 5 locations. The member is identified as Floor beam FB020-005. ZPMC QC did not provided WPS or Engineer notification for the above mention Repair. 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.

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