

**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-008587**Date Inspected:** 24-Apr-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Zhi Jiang**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:** Tower**Summary of Items Observed:**

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

BAY #11

## Magnetic Particle Inspection

This Q.A Inspector performed Magnetic particle testing of approximately 15% of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (M.T) report for this date. The member are identified as the East Tower Lift#2. The welds Designation are as follows.

East tower Lift 2, C/D corner seam except for one point (74m diaphragm).

East tower Lift 2, b/c corner seam.

East tower Lift 2 b/c corner weld joint outside

Bay # 10

## Magnetic Particle Inspection

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# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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This Q.A Inspector performed Magnetic particle testing of approximately 15% of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (M.T) report for this date. The member are identified as the South Tower Lift#1. The welds Designation are as follows.

Angle beam ob 9m and 13m diaphragm of lift 1 south tower – SSD1-SA 15D/F-27, SSD1-SA15D/F-28, SSD1-SA16F/G-95, SSD1SA16F/G96, SSD1SA16F/G97, SSD1-SA15D/F-35, SSD1-SA15D/F-36, SSD1-SA15D/F-37, SSD1-SA15D/F-40.

Lift 1 South corner seam D/E fit lug from 18 meters to 47.6 meters diaphragm, welds SSD1-a111g/h-240, 241, 104, 107; SSD1-A164c/j-251, 253, 98, 99; SSD1-A164d/j-224, 225,101,102, SSD1-A164e/j-94, 95, 216, 217; SSD1-a164f/j-89, 93, 209, 210; SSD1-A164g/j-96, 97, 212, 214; SSD1-A164h/j-91, 92, 203 and 204.

Lift 1 South corner seam D/E triangle diaphragm to skin plate from 18 meters to 47.6 meters welds SSD1-A, SSD1-A111g/h-110, 239, SSD1-A164c/j-97, 160; SSD1-A164d/j; SSD1-A164e/j-92, 208, SSD1-A164f/j-92, 204, SSD1-A164g/j-91, 215, SSD1-A164h/j-101, 194.

Lift 1 South corner seam D/E fit lug from 18 meters to 47.6 meters diaphragm welds SSD1-A111g/h-102, 104, 106, 108, 237, 238, 214, 213; SSD1-A164c/j-95, 96, 100, 101, 249, 250, 159, 252, SSD1-A164d/j-96, 97, 103, 104, 222, 223, 226, 227; SSD1-A164e/j-88, 93, 96, 97, 214, 215, 218, 219; SSD1-A164f/j-87, 88, 94, 95, 207, 208, 211, 21,; SSD1-A164g/j-94, 95, 98, 99, 210, 211, 212, 213; SSD1-A164h/j-89, 90, 93, 94, 201, 202, 205, and 206.

During random verification Magnetic Particle Testing (MT) of corner seam weld between skin plate C and D Lift 2 East tower, Caltrans Quality Assurance (QA) Inspector discovered one transverse linear indication with a length of approximately 15mm. which is previously overlooked by ZPMC Quality control (MT) Technicians. Incident report submitted to Task leader and other supervisor.

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

**Summary of Conversations:**

No relevant conversation

**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 Serge Sinevod 134-8257-0045, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Utekar,Shrikant	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

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