

**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-009041**Date Inspected:** 10-Sep-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 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.

Segment Repair Yard (South of the Blast Shop)

Segment 6BW

This QA Inspector performed Ultrasonic testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as the deck panel diaphragm splice welds. The Weld Designations are as follows: SEG029\*-015~020, 031 and 032.

This QA Inspector performed Ultrasonic testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as the longitudinal diaphragm to floor beam splice welds. The Weld Designations are as follows:

SEG029B-003, 004, 005, 022 and 023.

SEG029C-002~ 004, 005, 022 and 023.

This QA Inspector performed Ultrasonic testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as the floor beam component welds. The Weld Designations are as follows: SSD9-PP42-001, 002, 007, 008, 126, 127, 130 and 133.

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# WELDING INSPECTION REPORT

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SSD9B-PP42-001, 002, 007, 008, 105, 126, 127, 130 and 133.

SSD9-PP43-126

SSD9B-PP43-126

During random verification Ultrasonic Testing (UT) of the deck panel diaphragm splice weld and floor beam flange splice weld at panel point 42, Caltrans Quality Assurance (QA) Inspector discovered a total of (2) two, rejectable defects of up to 30mm in length. The weld designations are as follows; SEG029\*-031 (diaphragm splice) and SSD9-PP42-002 (flange splice). These welds have been previously tested and accepted by ZPMC Quality Control (UT) Technicians. Due to the amplitude and planar characteristics of the ultrasonic response in the deck panel diaphragm splice weld SSD9-PP42-002, This (QA) inspector carried out Magnetic Particle Testing (MT) on the excavation of the rejected weld and found a linear indication in that measured a total of 20mm in length.

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

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**Reviewed By:** Carreon,Albert

QA Reviewer