

**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-009371**Date Inspected:** 28-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1830**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Jia**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 COMPONENT**Summary of Items Observed:**

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

In process Inspection

Trial Assembly Yard

This QA Inspector observed the following work in progress:

Splice joint between 1AAW &amp; 1AW

SMAW welding of weld joint 001 located on OBW1(Y location-10300). Welder is identified as 067571. ZPMC QC is identified as Xu Yumin. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-1G (1F)-Repair-1 and repair procedure WR7650.

SMAW welding of weld joint 001 located on OBW1(Y location-10570). Welder is identified as 067571. ZPMC QC is identified as Xu Yumin. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-1G (1F)-Repair-1 and repair procedure CWR774.

SMAW welding of weld joint 001 located on OBW1(Y location-6600). Welder is identified as 068764. ZPMC QC is identified as Xu Yumin. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-1G (1F)-Repair-1 and repair procedure WR7650.

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## WELDING INSPECTION REPORT

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SMAW welding of weld joint 001 located on OBW1(Y location-5820).Welder is identified as 067571. ZPMC QC is identified as Feng Yasun .The welding variables recorded by QC appeared to comply with WPS-345-SMAW-1G (1F)-Repair-1 and repair procedure CWR774.

### Magnetic Particle Testing(MT)

This Quality Assurance Inspector (QA) performed 15% verification Magnetic Particle Testing (MT) for West Tower Diaphragm weld at Bay # 6. This QA inspector generated a (MT) report for this date. This weld was previously tested and accepted by ZPMC QC MT technicians.

The Weld Designations are as follow

WSD1-DPSA4-10A/B-003 and 004

WSD1-SA4-50-003 and 005

WSD1-DPSA4-10B/B-3,4,6,8,9,10,11

This Quality Assurance Inspector (QA) performed 15% verification of Magnetic Particle Testing (MT) on weld joints identified as WSD1-DPSA4-10B/B-26 and 27 at West Tower diaphragm (119M) . This QA Inspector discovered three rejectable linear transverse Indication measuring approximately 3,5 and 7 mm in length respectively .

This welds were previously tested and accepted by ZPMC QC MT technicians.

This QA Inspector generated an 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 150-0042-2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Bera,Subhasis	Quality Assurance Inspector
<b>Reviewed By:</b>	Whitehead,Lonnie	QA Reviewer

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