

**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-009384**Date Inspected:** 01-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:** Liu 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 06

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 this date. The member is identified as Side plate / South Tower Diaphragm Assembly at 119M / South Tower Diaphragm Assembly at 143M. The weld designations reviewed are as follows:

(SP3007-001-013) Rejectable indication found by MT method.

(SP3003-001-181,183) Green Tag # 009426.

(SP3004-001-117,119) Green Tag # 009426.

(SP3047-001-033,034,035,036)

(SP3047-001-033,034,035,036)

(SP3047-001-045,046,047,048)

(SP3047-001-057,058,059,060)

(SP3047-001-069,071)

Green Tag # 009425

(SSD1-DPSA4-14B/B-020,024,013)

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# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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(SSD1-DPSA4-9B/B-015,018,019,024)

OBG # BAY 01

This QA Inspector randomly observed the following work in progress:

Flux Cored Arc Welding Process:

Welding of weld joint –004,008 located on PCMK CW001B-PP052. Welder is identified as 251246. ZPMC QC is identified as Liu wei wei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-TC-U4b-F.

Welding of weld joint –001,002,003 located on PCMK CW001B-PP072. Welder is identified as 059450. ZPMC QC is identified as Liu wei wei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-TC-U4b-F.

OBG # BAY 06

Flux Cored Arc Welding Process:

Welding of weld joint –015,017 located on PCMK CB202G-020. Welder is identified as 220061. ZPMC QC is identified as Xu xian ping. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133.

Welding of weld joint –019,169 located on PCMK CB202G-017. Welder is identified as 019006. ZPMC QC is identified as Li yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133.

Submerged Arc Welding Process:

Welding of weld joint –001,002 located on PCMK CB202F-009. Welder is identified as 046830. ZPMC QC is identified as Li yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-B-L2C-S-2.

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 the QA Inspector performed Magnetic particle Test of weld SP3007-001-013 that weld have linear indication. The QA Inspector informed that the QA Inspector will be issuing incident report weld which have linear indication.

NOTE: This report is being submitted to rectify a mistake for a previous report dated June 1, 2009.

### **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

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# WELDING INSPECTION REPORT

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your project.

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