

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-009764**Date Inspected:** 14-Oct-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:** Xu Yumin and 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**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG Assembly Yard

1AE &amp; 1BE

This QA Inspector performed Ultra Sonic (UT) inspection of weld joint OBE1A-008 (bottom plate) on segment 2E, utilizing scanning pattern D to detect transverse indication reflectors. Noted UT inspection was performed in conjunction with ABF UT Department. This QA Inspector did not complete the full length of the above noted weld joint due to work shift ending.

**NDT Observation**

This QA Inspector observed ZPMC Ultra Sonic (UT) Technician performing UT on various locations in the trial assembly yard. Locations are as followed:

1. UT was performed on weld OBW1-007 (deck plate) SAW repair area with a 70° wedge. Scanning "D" pattern was observed at time of UT inspection. Area was not accepted at this time, due to unacceptable indications present in weldment.

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## WELDING INSPECTION REPORT

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Y locations of transverse indications are as followed:

390mm, 680mm, 1240mm, 1350mm, 1560mm, 1710mm, 3100mm, 3460mm, 3860mm, 4570mm, 5300mm and 5700mm.

Measurements were taken from the cross beam edge, length of excavation is approximately 6120mm and 1 transverse indication is noted at each y location mark.

2. UT was performed and accepted on weld OBW1-006 (deck plate) SAW repair area with a 70° wedge. Scanning “D” pattern was observed at time of UT inspection. Length of repair area is approximately 1700mm. Y location at center of excavation is approximately 1500mm off bike path side of segment.

3. UT was performed and accepted on weld OBW1-007 (deck plate) SAW repair area with a 70° wedge. Scanning “D” pattern was observed at time of UT inspection. Length of repair area is approximately 6620mm. Y location at center of excavation is approximately 360mm off weld joint OBW1-006.

This QA Inspector observed ZPMC Magnetic Particle (MT) Technician performing MT on various locations in the trial assembly yard. Locations are as followed:

1. Excavation area at weld joint OBW1A-009 on the cross beam side of segment 1AAW to 1AW.

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

### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### 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 (134-8257-0045), who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Alaniz,Joe	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer

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