DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-010176
Date Inspected: 27-Oct-2009

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 645
OSM Departure Time: 1845
Location: Shanghai, China

CWI Name:	Shen Fu You	**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 Components

Summary of Items Observed:

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

During a 10% Magnetic Particle (MT) verification of OBG segment 6CW. The Caltrans Quality Assurance Inspector discovered three (3) Linear Cracks identified as one (1) Toe Crack, 80mm in length located at weld Seg031F-032 and two (2) Longitudinal Cracks located inside the cope hole at weld Seg031F-034. These welds were previously tested and accepted by ZPMC QC MT. For further information, please see the attached pictures below. Please see incident report on this date.

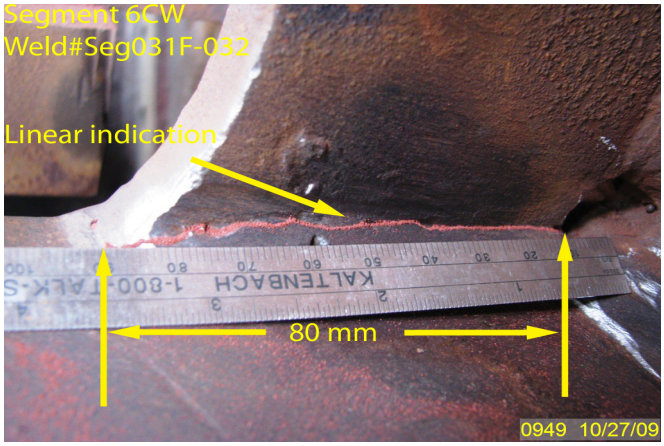
Bay#2
This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member is identified as OBG Components. The weld designations reviewed are as follows:
-(FB3028-001-043)
-(FB3028-001-045)
-(FB3037-001-043)
-(FB3037-001-045)
-(FB3002-001-043)
-(FB3002-001-045)
-(FB3001-001-043)
-(FB3001-001-045)

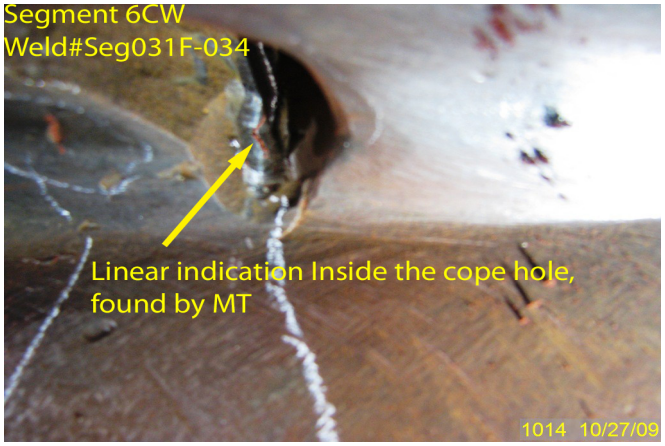
Segment 6CW

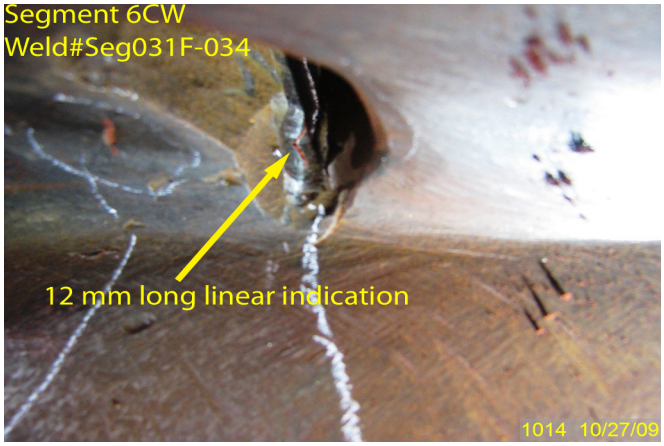
This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member is identified as OBG Components. The weld designations reviewed are as follows:

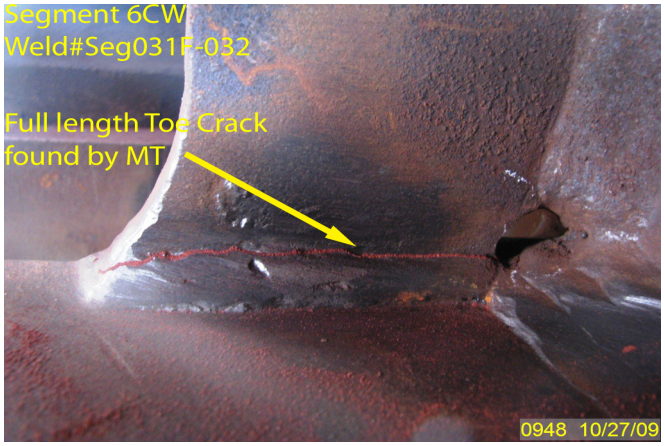
-(Seg31F-032, 034) Rejectable indication found
-(Seg031B-022)
-(Seg031F-029, 030, 008, 048)
-(SSD30-PP43.5-049, 050, 051, 052, 053 054, 055, 056, 057, 058, 059, 060)
-(SSD30-PP43.5-037, 038, 039, 040, 041, 042, 043, 044, 045, 046, 047, 048)
-(SSD30-PP43.5-085, 086, 087, 088, 089, 090, 091, 092, 093, 094, 095, 096)
-(SSD10-PP44-105, 106, 017, 101, 102, 036, 038, 040, 042, 044, 046)
-(SSD10-PP44-048, 050, 052, 054, 056, 058)
-(SSD10B-PP44-033, 035, 037, 039, 041 ,043)

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









Summary of Conversations:

No relevant conversations.

Comments

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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.

Inspected By:	Patel,Hiranch	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer