**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-010178
**Date Inspected:** 29-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

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|---|---|---|---|---|---|---|---|---|
| **Inspected CWI report:** | ☐ Yes | ☑ No | ☐ N/A | **CWI Present:** | ☑ Yes | ☐ No | |
| **Electrode to specification:** | ☐ Yes | ☐ No | ☑ N/A | **Rod Oven in Use:** | ☐ Yes | ☐ No | ☑ N/A |
| **Qualified Welders:** | ☐ Yes | ☐ No | ☑ N/A | **Weld Procedures Followed:** | ☐ Yes | ☐ No | ☑ N/A |
| **Approved Drawings:** | ☑ Yes | ☐ No | ☐ N/A | **Verified Joint Fit-up:** | ☑ Yes | ☐ No | ☐ N/A |
| | | | | **Approved WPS:** | ☐ Yes | ☐ No | ☑ N/A |
| | | | | **Delayed / Cancelled:** | ☐ Yes | ☑ No | ☐ N/A |

**Bridge No:** 34-0006
**Component:** OBG/Tower 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.

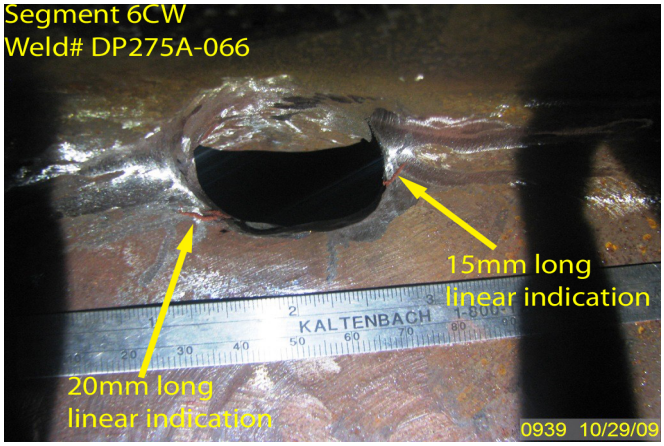
Caltrans Quality Assurance Inspector found three (03) Rejectable Indication inside the cope hole in segment6CW, weld#DP275A-066 during 10% Magnetic Particle Testing on the weld previously inspected and accepted by ZPMC. For further information, please see the attached pictures below. Please see incident report on this date.

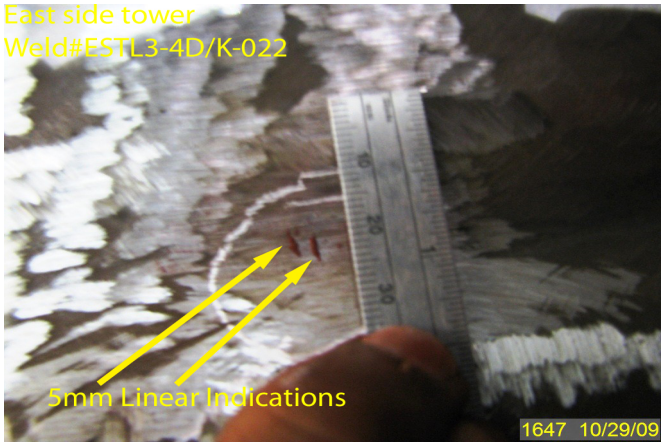
Caltrans Quality Assurance Inspector found Rejectable Indication in East side tower lift3, weld#ESTL3-4D/K-022 during 10% Magnetic Particle Testing on the weld previously inspected and accepted by ZPMC. For further information, please see the attached pictures below. Please see incident report on this date.
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:
-( DP275A-066) Rejectable indication found
-( DP275A-062~065, 067~087)
-( DP86A-062~87)
-( Seg031M-013, 007, 008, 011, 012, 050, 051)
-( Seg031J-061, 062, 084, 085)
-( Seg031H-018, 019, 041, 042)
-( CSD3-PP47-023, 024, 025, 026, 027, 028, 029, 030)

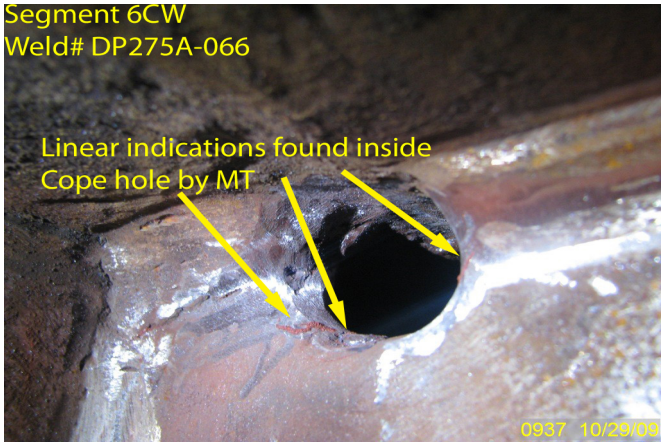
-( CSD3-PP46-085, 086, 087, 088, 089, 090, 091, 092)
-( CSD3-PP45-023, 024, 025, 026, 027, 028, 029, 030)
-( CSD2-PP45-009, 010, 013, 014)
-( CSD2-PP46-009, 010, 013, 014)
-( CSD2-PP47-009, 010, 013, 014)
-( CA029-004, 003)
-( SSD21-PP46.5-127, 128, 137, 138, 139, 140)
-( SSD21-PP45.5-127, 128, 137, 138, 139, 140)
-( SSD10-PP44-228, 224, 226, 220, 238, 236, 234, 248, 246, 244, 240, 258, 256, 254)

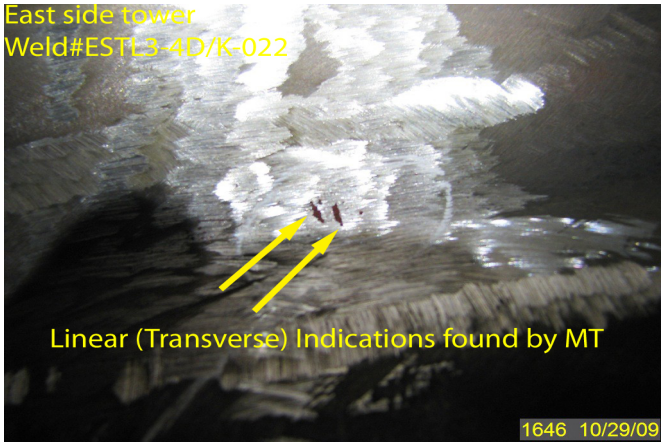
East Side Tower Lift3
This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member is identified as Tower Components. The weld designations reviewed are as follows:
-( ESTL3-4-C/K-048, 049, 052, 053, 058, 059, 084, 083, 078, 077, 029, 011, 012, 010, 009)
-( ESTL3-4D/K-022) Rejectable Indication found

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



# WELDING INSPECTION REPORT

*( Continued Page 3 of 3 )*

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