

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

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-010204**Date Inspected:** 19-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

<b>CWI Name:</b>	N/A	<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes No N/A	<b>Rod Oven in Use:</b>	Yes No N/A	
<b>Electrode to specification:</b>	Yes No N/A	<b>Weld Procedures Followed:</b>	Yes No N/A	
<b>Qualified Welders:</b>	Yes No N/A	<b>Verified Joint Fit-up:</b>	Yes No N/A	
<b>Approved Drawings:</b>	Yes No N/A	<b>Approved WPS:</b>	Yes No N/A	
		<b>Delayed / Cancelled:</b>	Yes No N/A	
<b>Bridge No:</b>	34-0006	<b>Component:</b>	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.

Trial Assembly Yard

This QA inspector was instructed by task leaders to carry out Ultrasonic testing (UT) with ABF QC utilizing scanning pattern 'D' for detecting transverse Indications on the transverse segment splice for OBG Segment 1AAE to 1AE and 1AW to 1BW. The indications found on this date were recorded onto a data sheet that Caltrans QA and ABF QA have jointly filled out.

The Weld Designations are as follows

OBW1A-009

OBE1A-003

Ultrasonic Testing (UT)

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as East line 1AAE to 1AE bottom panel and 1AW to 1BW side panel crossbeam side splice weld .

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# WELDING INSPECTION REPORT

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The Weld Designation are as follows

OBW1A-009

OBE1A-003

Caltrans Quality Assurance (QA) Inspector performed Ultrasonic Testing (UT) of the Transverse Segment Splice of OBG segments designated 1AAE and 1AE, Bottom Panel Splice OBE1A-003.

The QA inspector discovered three (3) class "A" rejectable Longitudinal Linear indications in the OBE1A-003 weld which the contractor failed to identify as this weld has been previously tested and accepted by the contractor. The Y locations of the three Class "A" rejectable Longitudinal Linear indications are as follows; Ind. #1 = 1310 mm, Ind. #2 = 2580 mm and Ind. #3 = 2850 mm. The Y locations were taken from the OBE1A-002 to OBE1A-003 longitudinal weld seam on the Cross Beam side progressing toward the Bike Path side.

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>	Patterson,Rodney	QA Reviewer

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