

**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-010646**Date Inspected:** 06-Dec-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**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) Shrikant Utekar 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:

## TRIAL ASSEMBLY YARD

## ULTRASONIC INSPECTION

## OBG SEGMENT 2WEST

This Quality Assurance (QA) Inspector performed conventional UT (Ultrasonic Testing) in conjunction with ABF Ultrasonic Testing (UT) department for detection of planar transverse indication.

Ultrasonic Testing (UT) performed on repair areas of the corner weld between deck panel and edge panel (cross beam side) of OBG segment 2West (CA102-002, 004, 006) utilizing scanning pattern A, B, C and D (Fig 6.7).

American Bridge Fluor (ABF) request number was 12052009-1.

No relevant indications were found.

## MAGNETIC PARTICLE INSPECTION

## OBG SEGMENT 2WEST

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## WELDING INSPECTION REPORT

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This Quality Assurance (QA) Inspector performed Magnetic Particle Testing (MT) in conjunction with ABF Magnetic Particle Testing (MT) department. Magnetic Particle Testing (MT) performed on repair areas of the corner weld between deck panel and edge panel (cross beam side) of OBG segment 2West (CA102-002, 004, 006). During the inspection American Bridge Fluor (ABF) found two transverse indications. Bridge Fluor (ABF) request number was 12052009-1. For more additional information see attached photos.

### TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress.

#### OBG SEGMENT 6 EAST

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 220069 performing Flux Cored Arc Welding process for the weld OBE6C-002 located on PCMK side panel splice weld (cross beam side) between OBG segment 6BE and 6CE. ZPMC QC Mr. Song Hui monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233T.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 220066 performing Flux Cored Arc Welding process for the weld OBE6C-005 located on PCMK side panel splice weld (bike path side) between OBG segment 6BE and 6CE. ZPMC QC Mr. Song Hui monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233T.

#### OBG SEGMENT 6 WEST

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 220063 performing Flux Cored Arc Welding process for the weld OBW6B-003 located on PCMK bottom panel splice weld between OBG segment 6AW and 6BW. ZPMC QC Mr. Feng Ya Jun monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-B-U2A-F.

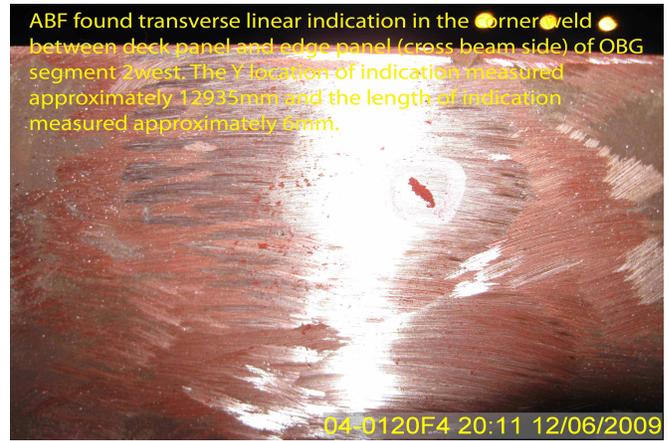
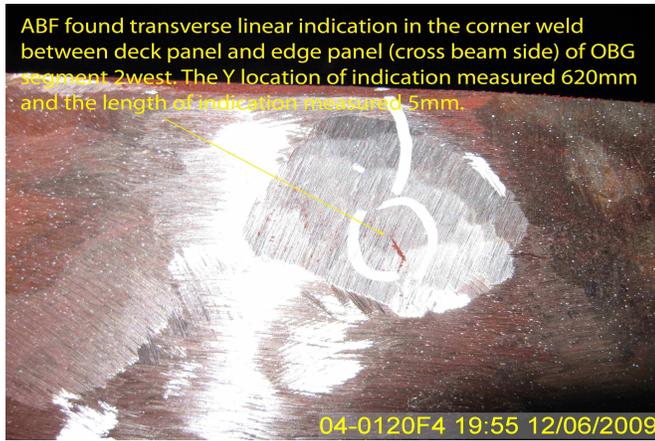
Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.

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# WELDING INSPECTION REPORT

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## 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 +(86) 150.0042.2372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Utekar,Shrikant

Quality Assurance Inspector

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**Reviewed By:** Dawson,Paul

QA Reviewer