

**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-010727**Date Inspected:** 01-Dec-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:** 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 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 area

SMAW in the 4G position of the OBG segment 6BE corner joint at side plate to bottom plate, weld No. SEG-030A-007 at CB side. The welder is identified as #067571. ZPMC QC is identified as Mr. Zhang Hai Tao. The welding variables recorded by QC appear to comply with WPS- B-P-2214-Tc-U4b-FCM-1.

Witness of Magnetic Particle Testing

This QA inspector was Witnessing of Magnetic Particle Testing which was carried by ABF QC Technicians at corner Weld between deck plate to edge plate at 1AAE, 1AE and 1BE. This inspector observed the ABF QC found there was no indication on the weld area.

The weld designations reviewed are as follows:

CA097-002,004 and 006

CA107-002,004 and 006

Ultrasonic Testing

QA Verification UT performed after repair on portion of bottom plate to side plate corner joint of 3AW and 3BW at counter weight side. This Inspection was performed after ABF UT Inspectors performed UT of this joint. The

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# WELDING INSPECTION REPORT

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result were recorded onto a data sheet that Caltrans QA and ABF QA have jointly filled out on this date.

The Weld Designations are as follows

SEG-017A-007

SEG-19A-031

During in-process visual inspection Quality Assurance Inspector observed the ZPMC personnel was Performing critical weld repair excavation of welds located on Segment 2BW and discovered the following issues:

- Three location excavated more than 65% of weld size (Thickness 20mm).
- The weld is identified as: CA102-004, Deck plate DP-727 to Edge Plate EP103A.
- The Weld is a Complete Joint Penetration (CJP) Corner joint Between Deck plate DP-727 to Edge Plate EP103A.
- The OBG Segment 2BW is located at Trial Assembly yard.

This QA Inspector generated an incident report for this date.

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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