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-011535
Date Inspected: 30-Dec-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: Lu Li Qing

	Yes	No	N/A
Inspected CWI report:	☐	☑	☐
Electrode to specification:	☐	☐	☑
Qualified Welders:	☐	☐	☑
Approved Drawings:	☑	☐	☐

	Yes	No	N/A
CWI Present:	☑	☐	
Rod Oven in Use:	☐	☐	☑
Weld Procedures Followed:	☐	☐	☑
Verified Joint Fit-up:	☑	☐	☐
Approved WPS:	☐	☐	☑
Delayed / Cancelled:	☐	☑	☐

Bridge No: 34-0006
Component: OBG Components

Summary of Items Observed:

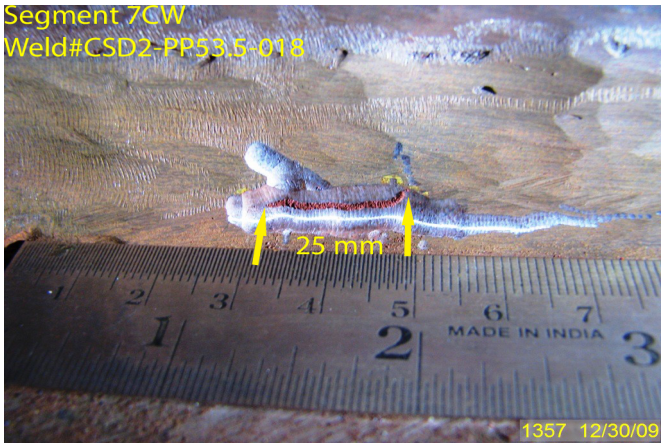
On this date Caltrans OSM Quality Assurance (QA) Inspector, Hiranch Patel, was present during the times noted above for observations relative to the work being performed.

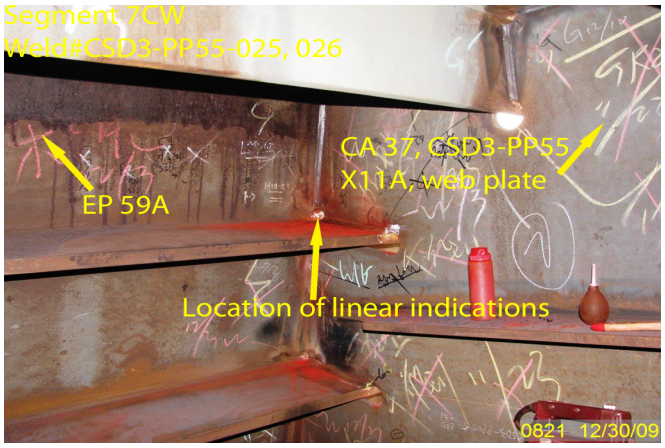
During the Quality Assurance Magnetic Particle Testing (MT) review of welds located on Segment7CW, this Quality Assurance Inspector (QA) discovered the following issues:
-Two (2) Longitudinal linear indication measuring approximately 20mm and 25mm in length.
-The welds are identified as: CSD3-PP55-025, 026 (20 mm) and CSD2-PP53.5-018 (25 mm).
-The welds are a Fillet Weld type joining the Edge Plate (EP59A) stiffeners to Corner Assembly (CA37A) web plates.
-The OBG 7CW segment is located at in front of blast shop.
The Notice of Witness Inspection Number (NWIT) is 004947. The indication is located inside the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. ZPMC's QC personnel are required to perform twenty five (25%) percent MT inspection of this weld.
For further information, please see the attached pictures below. Please see incident report on this date.

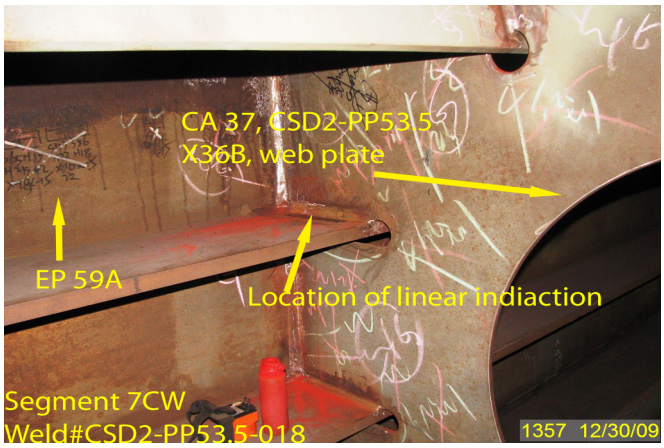
Segment 7CW
This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member is identified as OBG Components. The weld designations reviewed are as follows:
-(CSD2-PP52.5-011~032)
-(CSD2-PP53.5-011~017, 019~032)

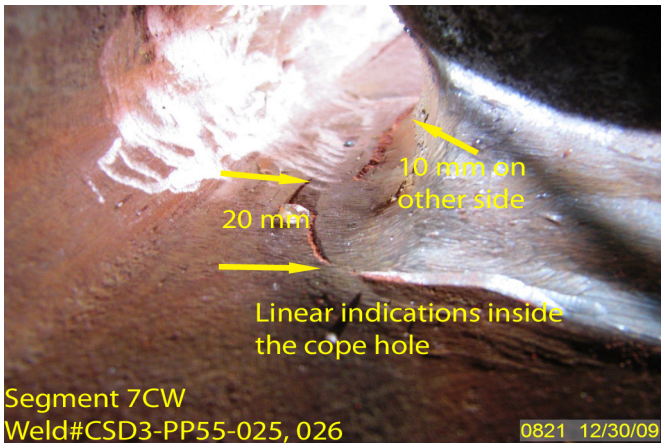
-(CA037-003, 004, 010, 011)
-(CSD3-PP55-005, 006, 011, 012, 027~032, 041~044, 051, 052)
-(CSD3-PP53-005, 006, 011, 012, 025~032, 041~044, 051, 052)
-(CSD9-PP54-068, 074, 088, 090, 092, 094, 104, 106, 112)
-(CSD3-PP55-025, 026)- Rejectable indication found
-(CSD2-PP53.5-018)- Rejectable indication found

Unless otherwise noted, all 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.

Inspected By: Patel,Hiranch Quality Assurance Inspector

Reviewed By: Patterson,Rodney QA Reviewer