

**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-011875**Date Inspected:** 13-Jan-2010**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.

**Magnetic Particle Testing(MPT)**

This Quality Insurance Inspector (QA) performed 15% verification Magnetic Particle Testing (MT) for OBG segment 8BE after repair ,welds area. This weld was previously tested and accepted by ZPMC QC MT technicians.

The weld designations reviewed are as follows:

SEG047F-017,013,014,015 and 016  
SSD21-PP67.5-041,042,043 and 044  
SP447-063 and 064  
SSD10-PP68-097 and 099  
SSD10-PP68-039,041 and 043  
SSD10A-PP68-140,142,133 and 144  
SSD10A-PP68-166 and 172  
SSD21-PP67.5-163,154,161,151,144,140,134 and 127  
SEG047H-074,079 and 137  
SEG047J-040 and 049

# WELDING INSPECTION REPORT

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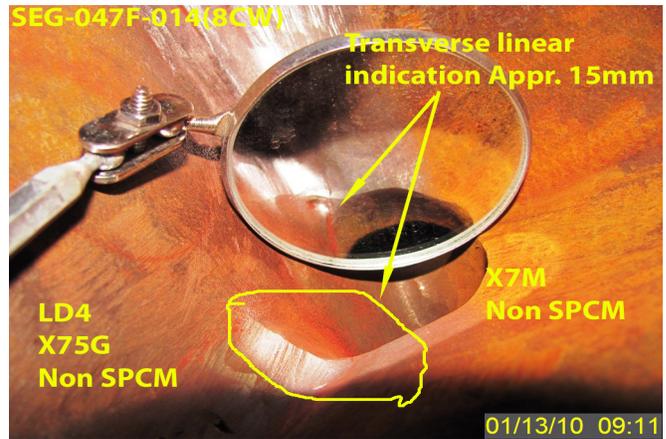
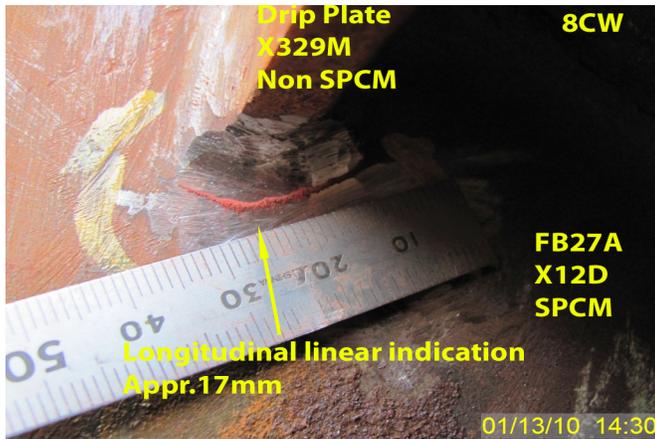
SSD10A-PP68-188 and 172

SSD11A-PP69-164 and 170

During the Quality Assurance Magnetic Particle Testing (MT) review of welds located on Segment 8CW, this Quality Assurance (QA) Inspector discovered Linear indications on the following welds are Weld #SSD10-PP68-101: Two (2) l Transverse linear indication measuring approximately 15 mm and 4 in length respectively. Weld #SEG047F-002: One (1) l longitudinal linear indication measuring approximately 15 mm in length. Weld#SEG047F-014: One (1) l Transverse linear indication measuring approximately 15 mm in length. Weld#SP447A-063: One (1) l Transverse linear indication measuring approximately 8 mm in length. Weld#SSD10A-PP68-144: One (1)l Longitudinal linear indication measuring approximately 13 mm in length. Weld# Between Drip plate to Floor Beam (FB27A) at Panel Point PP70 (Cross Beam Side) : One (1) l Transverse linear indication measuring approximately 17 mm in length. All indications are clearly marked on the material near the weld. For details, see Magnetic particle Testing (MT) report generated by this QA for this date. The weld SSD10-PP68-101 joint joining between FB11C (X46B) Non SPCM to SP158A (PL548A) SPCM. The weld SEG047F-002 joint joining between FB19B (X49F) SPCM to LD4(X75G) Non SPCM. The weld SEG047F-014 joint joining between LD4(X75G) Non SPCM to FB19B(X7M) Non SPCM. The weld SP447A-063 joint joining between FB19B (X12C) SPCM to Side Plate 'I' Stiffener (RS91GB) Non SPCM. The weld SSD10A-PP68-144 joint joining between FB19B (X12C) SPCM to Deck Plate 'I' Stiffener (RS62GA) Non SPCM. The sixth indication between Drip plate (329M) Non SPCM to Floor Beam FB27A(X12D) SPCM at Panel Point PP70 (Cross Beam Side)

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:

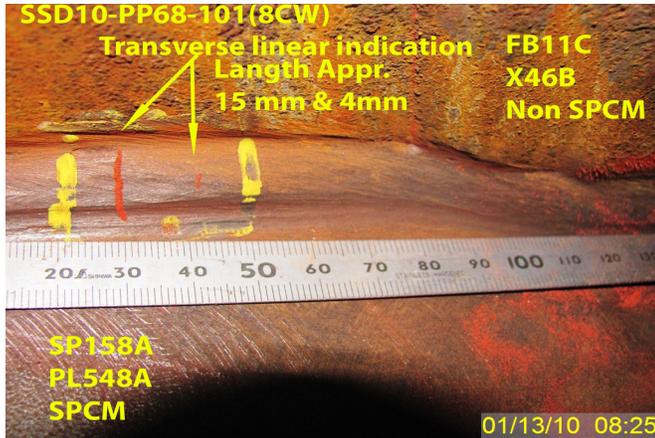
No relevant conversations

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## 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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