

**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-011885**Date Inspected:** 02-Feb-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.

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 Segment 9AE Butt and "T" joint.

The Weld Designations are as follows

SEG050-003,004,005,006,007,008,009,026

SEG050A-007,008,009,010

Ultrasonic Testing (A,B,C and D-Scan )

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 portion Deck plate to Edge plate Corner joint of segment 9BE. This Inspection was performed after ABF UT Inspectors performed UT of this joint. The result was recorded onto a data sheet according to rejection criteria of "D" Scan procedure that Caltrans QA and ABF QA have jointly filled out on this date.

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The Weld Designation is as follows

CA060-004

SEG052-047

During the Ultrasonic Testing (UT) verification on OBG segment 9AE, this QA Inspector discovered five (5) longitudinal Class "A" indication measuring approximately 15mm, 12mm, 16mm, 10mm and 15mm in length respectively. The indication ratings are +10, +8, +9, +10 and +9. Material thickness is 18mm. The depths of the indications are approximately 13mm to 14mm. The weld is identified as SEG-050A-009 at side plate to Side plate. Then the Quality Assurance Inspector called ZPMC technician to confirm those area and the QA Inspector observed ZPMC technician getting indication level approximately 6 dB differences than CT QA Inspector. After that the QA inspector checked there (ZPMC) calibration of the scope and found it was normal. Then the QA Inspector verifies with ABF UT technician and found same result which were done by CT QA inspector. After that the QA inspector informed to another CT QA Inspector to crosscheck those area and found same result which was found by him.

Regarding this incident the QA Inspector informed to his lead Inspector.

This QA Inspector did not generate any 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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**Inspected By:** Bera, Subhasis

Quality Assurance Inspector

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**Reviewed By:** Patterson,Rodney

QA Reviewer