

**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-012347**Date Inspected:** 03-Mar-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**CWI Name:** Zhon Cheng**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 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.

**Bay#19**

During random Quality Assurance Visual review of welds located on Suspender Bracket (SB), this Quality Assurance Inspector (QA) discovered the following issues:

-Visual crack found by ZPMC QC on fillet weld and fillet weld removed by carbon arc gouging and changing fillet weld to Complete Joint Penetration (CJP).

-The weld is identified as: SB008-046-008.

-According to approved drawing this weld is 8mm fillet weld.

-This Fillet weld joining the plate SB46E-B to SB stiffener X62K is non SPCM.

- The plate SB46E-B to SB stiffener X62K is identified as non SPCM.

- This weld removal was done without informing the engineer

-SB008-46E is located in OBG Bay#19.

For further information, please see the attached pictures below. Please see incident report written on this date

**Bay#19**

This QA inspector performed MT of punch list item#460 (IR 1170) 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:

-(SB42W)

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-(SB46W)

## Bay#19

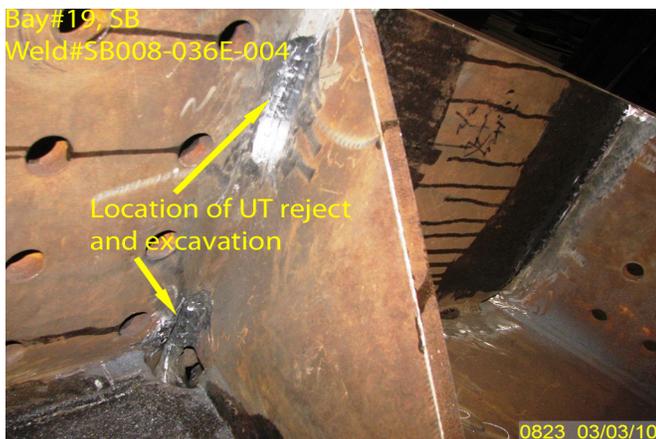
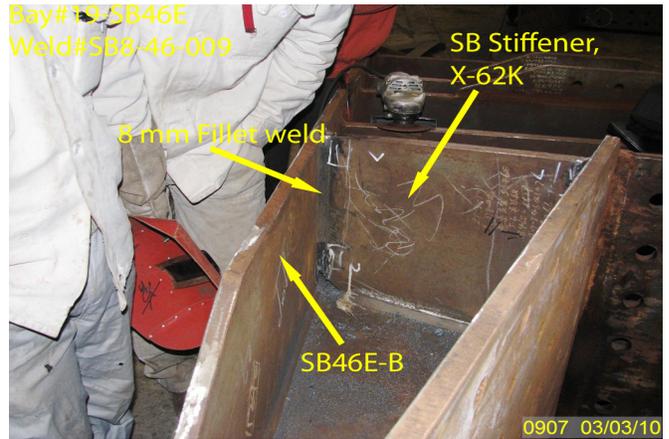
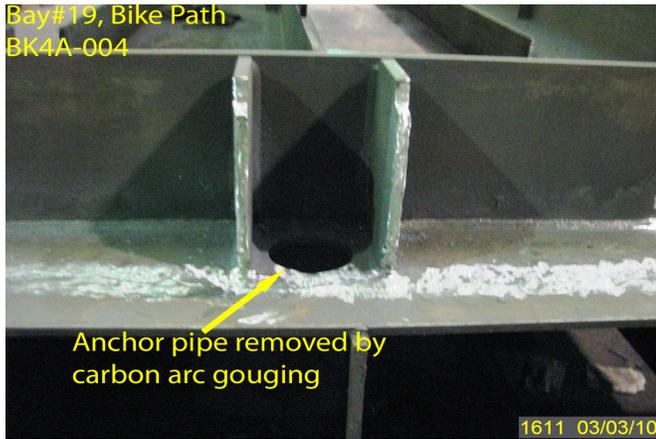
During random in process inspection of suspender brackets, this QA inspector observed that ZPMC UT technician found defects on CJP welds. These welds are non FCW. ZPMC personal removed the defective weld by carbon arc gouging. The maximum length of the gouging area measured is 750 mm.

For further information, please see the attached pictures below.

During random in process inspection of bike path BK4A-004 this QA inspector observed that ZPMC personal removing the anchor pipe, longitudinal stiffeners and closure plates by carbon arc gouging. ZPMC need to perform MT on base metal after grinding on parts removal areas.

For further information, please see the attached pictures below.

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

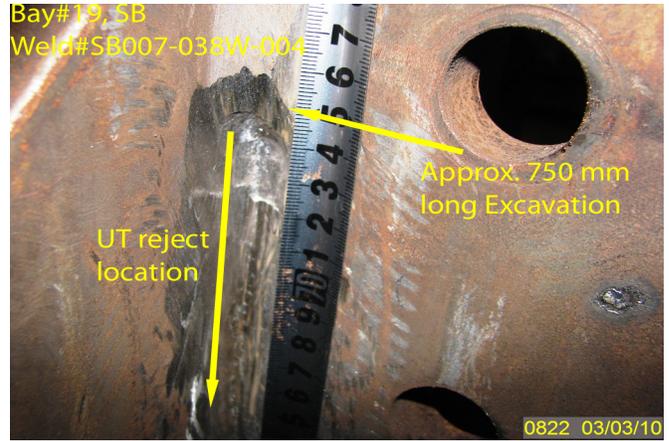


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# WELDING INSPECTION REPORT

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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 150-0042-2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Patel, Hiranch	Quality Assurance Inspector
<b>Reviewed By:</b>	McClendon, Timothy	QA Reviewer

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