

**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-013671**Date Inspected:** 30-Apr-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:****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:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

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

This QA Inspector carried out NDE on following:

Assembly, In front of Bay 16, 9DW, Segment Tagging.

This QA inspector performs Random Visual Testing & random Magnetic Particle Testing (MT) of area previously tested and accepted by ZPMC Quality Control personnel (Notification # 005616) for Segment Tagging. This QA Inspector generated an MT report (TL-6028) for this date. The members are identified as

- 1) SEG055-PP82-04, 32, 34, 55, 83, 05, 40, 42, 08, 64, 55.
- 2) SEG055-PP82-38, 39. (15% MT)
- 3) SSD11-PP81-108, 110, 112, 47, 49, 51, 101, 97, 98, 43, 41, 39.
- 4) SSD22-PP81.5-41 to 46, 49 to 54.
- 5) SSD12-PP82-110, 112, 114, 49, 51, 53, 108.
- 6) SEG055D-70 to 73, 79 to 82, 108 to 109, 115 to 118.
- 7) SP673-001-41, 42, 43, 46, 47, 48.
- 8) SSD11A-PP81-129, 131, 135, 138, 140, 142, 144.
- 9) SSD12A-133, 135, 137, 141, 143, 145, 147.
- 10) SSD22-PP81.5-123 to 126, 129 to 136, 143, 144, 139, 140, 147 to 150, 157 to 162.

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## WELDING INSPECTION REPORT

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During Magnetic Particle Testing (MT) review of OBG segment 9DW this Quality Assurance Inspector (QA) observed following:

-Three transverse linear indications, one measuring approximately 9mm and two indications measuring approximately 5mm in length at Longitudinal Diaphragm (LD) LD 3A to Floor beam (FB) FB 11A.

-Weld is identified as SEG055B-034 and designated as a Fracture Critical Weld (FCW).

-The weld is a 14mm Complete Joint Penetration (CJP) T-joint joining LD 3A shear plate identified as X39B to FB web plate identified as X47C (Seismic Performance Critical Material SPCM).

-The indications are clearly marked on the material.

The Notice of Witness Inspection Number (NWIT) is 005616. The indication is located inside the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. Per the contract documents ZPMC's QC personnel are required to perform 100% MT inspection of this weld.

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, 1500.042.2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Juvekar,Amit	Quality Assurance Inspector
<b>Reviewed By:</b>	Hall,Steven	QA Reviewer

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