

**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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013914**Date Inspected:** 05-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing 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 Segment 10AE	

**Summary of Items Observed:**

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

**Magnetic Particle Testing (MT)**

This QA inspector performed Visual Testing (VT) on OBG Segment 11AW and VT indications are confirmed by Magnetic Particle Testing (MT) on area previously tested and accepted by ZPMC Quality Control personnel.

This QA Inspector generated an MT report for this date. The indications are clearly marked on the material near the weld for future repair. The members are identified as OBG Segment 11AW. The weld designations reviewed are as follows:

**OBG Segment 11AW-PP96 East side**

1. FB015-042-002
2. FB009-038-004
3. FB003-190-004

**OBG Segment 11AW-PP96 West side**

4. FB015-042-001
5. FB003-190-005

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6. FB009-038-003

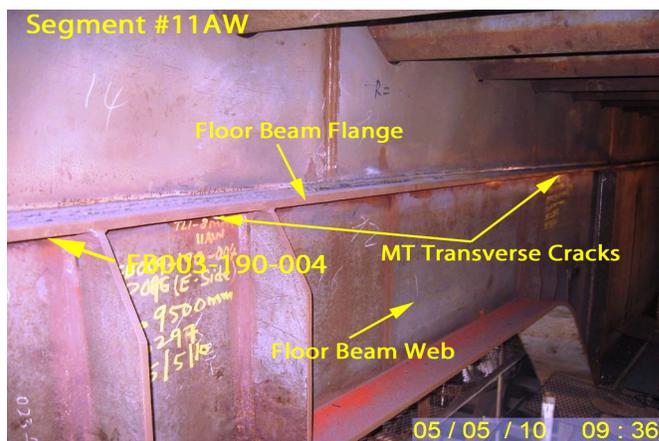
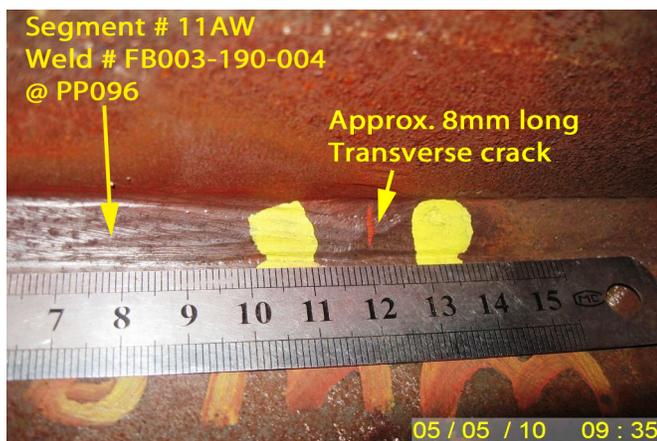
Description of Incident: During random Quality Assurance Visual review of welds located on segment 11AW, this Quality Assurance Inspector (QA) discovered three (3) Transverse linear indications measuring approximately 8 to 10mm in lengths. The indications were discovered visually and confirmed by Magnetic particle Testing (MT) by Caltrans QA. ZPMC Quality Control MT Technicians claimed that magnetic particle testing have been performed on these welds that require 25% MT. The indications are clearly marked on the material near the weld. The weld numbers are identified as FB009-038-004 and FB003-190-004. The panel point is identified as a PP096. This weld is a Fillet weld joining the Floor beam Web to Flange. The Floor Beam Flange weld is identified as Non SPCM. For further information, please see the attached pictures

Ultrasonic Testing (UT) - Document: 005666

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Segment 10AE. The weld designations reviewed are as follows:

1. SEG060\*-016, 017
2. SEG060A-008, 009, 010
3. SEG060A-031, 032, 033, 044

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



## Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

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

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**Inspected By:** Kumar, Vibin Quality Assurance Inspector

**Reviewed By:** McClendon, Timothy QA Reviewer