

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-014297**Date Inspected:** 15-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), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	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 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 Assurance (QA) Inspector performed Visual inspection and verification of Magnetic Particle Testing (MT) 15% for Segment 10BE. This QA inspector generated a (MT) report for this date. This weld was previously tested and accepted by ZPMC QC MT technicians.

The weld designations reviewed are as follows:

SEG062B-001,002,003,004,005,009,010,011,012,013,014,015,016,017,018,019,020,021,022,023,025,032,033,
034,035,037,038,039,040,041

SSD29-PP88.5-164,164,165,166,175,176,177,178

SSD19-PP89-044,045,046,047,048,049,050,051,101,102,103,104,108,109,110,111,112

SSD29-PP89.5165,166,167,168,171,172,173,174

SSD29-PP90-044,045,046,047,048,049,050,051,101,102,103,104,108,110,111,112

SSD29-PP90.5-163,164,165,166,171,172,173,174

SSD19-PP91-042,044,048,050,101,103,108,109,111

During the Quality Assurance Magnetic Particle Testing (MT) review of welds located on Segment 10BE, these

WELDING INSPECTION REPORT

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Quality Assurance (QA) Inspectors discovered a total of one (1) Transverse linear Indications and one (1) Longitudinal linear Indications measuring approximately 5 mm and 13 mm in length. One (1) Transverse indication, approximately 5mm in length at Panel Point 89 (East side), in the weld designated as SEG062B-010, joining Floor Beam Flange FB16A (X7J) to Longitudinal Diaphragm LD1A (X75F). One (1) Longitudinal indication, approximately 13mm in length at Panel Point 89 (West side), in the weld designated as SSD13-PP89-108, joining Floor Beam FB16A (X94E) to Bottom Panel BP184A (PL828A). All the welds are Non Seismic Performance Critical Material (Non SPCM). The indications are marked clearly near the weld. OBG segment 10BE is located in outside yard, North of Blast Shop. The Notice of Witness Inspection (NWIT) Number is 005723. The indications are located inside the area previously tested and accepted by ZPMC personnel.

The QA inspector given all information to another QA inspector Mr. Anand to generate 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

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.

Inspected By:	Bera,Subhasis	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
