

**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-014627**Date Inspected:** 25-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:** Zhou 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.

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This QA inspector observed following updates for the bike paths.

1. BK004A-001 End closure plate, Interior diaphragm and longitudinal diaphragm plate removed by carbon arc gouging. Required repair work was completed and heat straightening (HS) at both the end was completed. MT was completed by ZPMC. ABF and CT NDT not complete
2. BK004A-002 Fit up of bearing plate is in process. Fitup of end diaphragm is in process.
3. BK004A-003 End closure plate, Interior diaphragm and longitudinal diaphragm plate removed by carbon arc gouging. Required repair work was completed and heat straightening (HS) at both the end was completed. Required NDT not complete after HS.
4. BK004A-004 Welding of bearing plates to center plates, bearing plate to side plates and bearing plates to stringer plates were completed. Welding of horizontal anchor house plate to longitudinal members was completed. No access for MT on anchor house weld. ZPMC will perform Penetrant Testing in alternative to MT (RFI 1690-R4-SK-1690R4-13). During random visual inspection, QA inspector observed under sized fillet welds connecting Bearing Plate to Stringer Plates and Bearing Plate to Center Plate.
5. BK004A-005 Fit up of bearing plate is in process. Fitup of end diaphragm is in process.
6. BK004A-006 According to the old design interior diaphragm, center plate, closure plate and longitudinal stiffeners were welded. Parts are not removed on this bike path.
7. BK004A-007 End closure plate, Interior diaphragm and longitudinal diaphragm plate removed by carbon arc

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## WELDING INSPECTION REPORT

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gouging. Required repair work was completed and heat straightening (HS) at both the end was completed.  
Required NDT not complete after HS.

8. BK004A-008 Fit-Up (Tack welding) of Side Plates to Top Plate (DP) is in Process. IR generated for Buttering without CWR

9. BK004A-009 Fit up of center plate and intermediate X7 stiffener in process.

10. BK004A-010 Fit-Up (Tack welding) of Side Plates to Top Plate (DP) is in Process. IR generated for Buttering without CWR

11. BK004A-011 Fit-Up (Tack welding) of Side Plates to Top Plate (DP) is in Process. IR generated for Buttering without CWR

12. BK005A-001 Fit up of bearing plate is in process. Fit up of end diaphragm is in process.

13. BK006A-001 Removing of parts was completed. Heat straightening Completed, no NDT was performed after removing of the parts.

14. BK006A-002 Removing of parts was completed. Heat straightening Completed, no NDT was performed after removing of the parts.

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During random visual observation this QA inspector found that following suspender brackets welds were rejected by ZPMC UT technician. ZPMC personnel was performing repair these welds with approved weld repair report (WRR) procedure. The weld designations reviewed are as follows:

-(SB015-064-037, 018, 001, 004, 005, 007)

-(SB015-068-043, 049, 018, 004, 005, 007)

-(SB015-066-001, 004, 007)

-(SB015-062-031, 004)

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