

**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-014994**Date Inspected:** 20-Jun-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

<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	

**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

TRIAL ASSEMBLY YARD

ULTRASONIC INSPECTION

OBG SEGMENT 11AE

ABF Request No: 06202010-1

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the weld between deck panel and edge panel (Cross beam side) of OBG segment 11AE. Inspection was carried out on repair areas. The weld designations are as follows.

CA081-004 (OBG 11AE, D.P to E.P – Cross beam side)

ULTRASONIC INSPECTION

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# WELDING INSPECTION REPORT

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## OBG SEGMENT 8CE

ABF Request No: 06192010-1

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the weld between Bottom panel and side panel (Cross beam side) of OBG segment 8CE. Inspection was carried out on repair areas. The weld designations are as follows.

SEG048B-046 (OBG 8CE, B.P to S.P-Cross beam side@ 9AE)

## ULTRASONIC INSPECTION

### OBG SEGMENT 11AE

ABF Request No: 06202010-1

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the weld between deck panel and edge panel (Bike path side) of OBG segment 11AE. Inspection was carried out on repair areas. The weld designations are as follows.

CA082-004 (OBG 11AE, D.P to E.P – Bike path side)

## ULTRASONIC INSPECTION

### OBG SEGMENT 9AE

ABF Request No: 06192010-1

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the weld between side panel and bottom panel (Bike path side) of OBG segment 9AE. Inspection was carried out on repair areas. The weld designations are as follows.

SEG050A-014 (OBG 9AE, S.P to B.P, Bike path side@ 8CE)

## MAGNETIC PARTICLE INSPECTION

### OBG SEGMENT 11AE

ABF Request No: 06202010-1

This QA Inspector Witnessed ABF personal performing Magnetic particle Testing (MT) on the welds between deck panel and edge panel of OBG segment 11AE (Bike path side). Inspection was carried out on repair areas. Weld identification number were.

CA082-004 (OBG 11AE, D.P to E.P – Bike path side)

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# WELDING INSPECTION REPORT

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No relevant indications were observed.

## MAGNETIC PARTICLE INSPECTION

### OBG SEGMENT 8CE

ABF Request No: 06192010-1

This QA Inspector Witnessed ABF personal performing Magnetic particle Testing (MT) on the weld between side panel and bottom panel (Cross beam side) of OBG segment 8CE. Inspection was carried out on repair areas.

Weld identification number were.

SEG048B-046 (OBG 8CE, B.P to S.P-Cross beam side@ 9AE)

No relevant indications were observed.

## MAGNETIC PARTICLE INSPECTION

### OBG SEGMENT 11AE

ABF Request No: 06202010-1

This QA Inspector Witnessed ABF personal performing Magnetic particle Testing (MT) on the welds between deck panel and edge panel of OBG segment 11AE (cross beam side). Inspection was carried out on repair areas.

Weld identification number were.

CA081-004 (OBG 11AE, D.P to E.P – Cross beam side)

No relevant indications were observed.

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

### **Summary of Conversations:**

Only general conversation was held between QA and QC

### **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, +(86) 1500 042 2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Utekar,Shrikant	Quality Assurance Inspector
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<b>Reviewed By:</b>	Peterson,Art	QA Reviewer
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