

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-015003**Date Inspected:** 08-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**CWI Name:** Xu Tao**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.

Outside Yard

OBG Segment #11DW

This QA inspector performed Visual Testing (VT) on OBG Segment 11DW and VT indications are confirmed by Magnetic Particle Testing (MT) 100% 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 11DW.

The weld designations reviewed are as follows:

Panel Point PP104

FB003-189-004

FB011-034-004

FB019-009-093

OBG Segment #11EW

This QA inspector performed Visual Testing (VT) on OBG Segment 11EW and VT indications are confirmed by Magnetic Particle Testing (MT) 100% on area previously tested and accepted by ZPMC Quality Control personnel.

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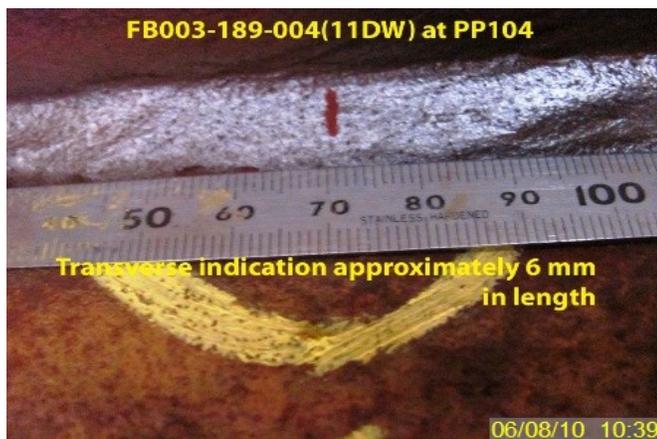
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This QA Inspector generated an MT report for this date. The members are identified as OBG Segment 11EW. The weld designations reviewed are as follows:
Panel Point PP108
FB009-033-003

During random Quality Assurance visual review of welds located on segment 11DW, this Quality Assurance Inspector (QA) discovered a total of one (1) Transverse indication measuring 8 mm in length. The weld details is as follows: One (1) Transverse indication approximately 6 mm in length at Panel Point 104 (East side) in the weld designated as FB003-189-004 at Y location-5400mm, measured from the termination of the weld on the Cross Beam side. The welds are Fillet welds joining the Floor Beam flange (X6F) to web(X49D). The weld is designated as Non Seismic Performance Critical Material (Non SPCM). The indications were discovered visually and confirmed by Magnetic particle Testing (MT) by Caltrans QA. The indications are marked clearly near the weld. OBG segment 11DW is located in outside yard north of fabrication Bay14. The indications are not located within the area previously tested and accepted by ZPMC personnel. Per the contract documents, ZPMC is required to perform 25% Magnetic particle Testing (MT) of these welds.

The QA inspector generated 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

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Reviewed By: Patterson,Rodney

QA Reviewer