

**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:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016614**Date Inspected:** 03-Sep-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 Segments 11DE	

**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.

Ultrasonic Testing (UT) – Document No: 006556

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 11DE. The weld designations reviewed are as follows:

1. SEG072\*-031, 032, 034
2. SEG072A-019, 020, 011, 031, 032
3. SEG072C-031, 032, 033, 034
4. SSD18A-PP106-002, 009, 129, 130, 133, 136
5. SSD17A-PP105-001, 008, 126, 127, 130, 133
6. SSD16A-PP104-001, 008, 126, 127, 130, 133

Description of Incident: During the Quality Assurance Ultrasonic Testing (UT) review of weld located on Segment 11DE, this Quality Assurance Inspector (QA) discovered one (1) Class “A” indication measuring approximately 15mm in lengths. The indication D-rating is +9dB. The weld is a Complete Joint Penetration (CJP) corner weld joining the Longitudinal Diaphragm to Floor Beam. The indication is located on the weld joint identified as SEG072C-033. The thickness of the plate is 14mm and depth of the indication approximately 9mm. The indication

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is clearly marked by QA on/near the weld. This weld joint is designated as non Seismic performance critical weld member (non SPCM). The indication is located within the area that has been previously 100% tested and accepted by ZPMC Quality Control (QC) personnel.

Visual Inspection after Blast

Segment 11AW

This QA Inspector performed a preliminary random visual inspection on OBG Segment 11AW, after the grit blast of the interior components of the deck panel, floor beams and corner assemblies of this segment. Areas of visual weld defects that will require welding were taped and will be repaired after the coating is applied. ZPMC QC personnel are aware of these areas and were present during the inspection.

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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<b>Inspected By:</b>	Kumar,Vibin	Quality Assurance Inspector
<b>Reviewed By:</b>	McClendon,Timothy	QA Reviewer

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