

**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-005464**Date Inspected:** 07-Feb-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** As listed below**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:** TOWER COMPONENTS**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Luis Hutchins, was present during the times noted above for observations relative to the work being performed.

**Inprogress welding:**

FCAW welding of weld joint NSD1-SA179 G/G- 29 and 30. Welder is identified as 053869. ZPMC QC is identified as Fin Dong Liang. The welding variables recorded by QC appeared to comply with the WPS #B-T-2133-TC-F.

FCAW welding of weld joint NSD1-SA166 E/F- 28, 15, 25, 16, 17 and 19. Welders are identified as 053474, 040261, 053870, and 057194. ZPMC QC is identified as Chen Ying Xin. The welding variables recorded by QC appeared to comply with the WPS #B-T-2231-TC-U5-F.

FCAW welding of weld joint NSD1-SA106 - 3B. Welder is identified as 067876. ZPMC QC is identified as Tu Jun. The welding variables recorded by QC appeared to comply with the WPS #B-T-2231-TC-U5-F.

FCAW welding of weld joint NSD1-SA171 A/D- 29, 30, 33, and 34. Welders are identified as 057244, 040338, 203977, 057180, 040345 and 052075. ZPMC QC is identified as Chen Ying Xin. The welding variables recorded by QC appeared to comply with the WPS #B-T-2332-TC-P5-F.

FCAW welding of weld joint NSD1-SA171 C/D- 47 and 48. Welders are identified as 050041 and 068206. ZPMC

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## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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QC is identified as Chen Ying Xin. The welding variables recorded by QC appeared to comply with the WPS #B-T-2332-TC-P5-F.

SMAW welding of weld joint NSD1-SA180 A/E- 5, 3, 8, and 2. Welders are identified as 040500 and 056134. ZPMC QC is identified as Chen Ying Xin. The welding variables recorded by QC appeared to comply with the WPS #B-T-4314-TC-P5-2.

SMAW welding of weld joint NSD1-SA180 B/E- 7, 11, 14, and 8. Welders are identified as 052771 and 053680. ZPMC QC is identified as Chen Ying Xin. The welding variables recorded by QC appeared to comply with the WPS #B-T-4314-TC-P5-2.

### Ultrasonic Inspection:

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a UT report for this date. The members are identified in that report.

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

### Summary of Conversations:

No significant conversations held during the course of inspection.

### 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 Serge Sinevod 134-8257-0045, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Hutchins,Luis	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

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