

**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-006310**Date Inspected:** 23-Mar-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

<b>CWI Name:</b>	Yu Dongping / Li Hongfei / Zhang			<b>CWI Present:</b>	<b>Yes</b>	<b>No</b>	
<b>Inspected CWI report:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Approved WPS:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
				<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Bridge No:</b>	34-0006			<b>Component:</b>	TOWER COMPONENTS		

**Summary of Items Observed:**

On this date, the Caltrans OSM Quality Assurance (QA) Inspector, "Victor" KS Narayan was present during the times noted above for observations relative to following work performed.

Bay 11 – TOWER ASSEMBLY:

I. Lift 3 – Skin Plates' butt welding:

Weld process, SAW of butt weld joints located on Lift 3-East Tower Skin "C/E" plate butt welds:

The weld designation numbers and the welder was identified as follows.

ESD1-FCSA3-2B/C-8B-2 (CJP): The welder was identified as Li Xiaoqing and the welder number was identified as 044560.

ESD1-FCSA3-2B/C-26B-1, 26B-2 (CJP) &amp; 31, 22 (PJP): The welder was identified as Qin Xiulan and the welder number was identified as 044550.

ESD1-FCSA3-2B/C-37 (PJP) &amp; 34B (CJP): The welder was identified as Xia Wenying and the welder number was identified as 044558.

ESD1-FCSA3-2B/C-14 (PJP) &amp; 17B (CJP): The welder was identified as Wu Aixiang and the welder number was identified as 040772.

ESD1-FESA3-2B/D-24A, 47A (CJP): The welder was identified as Yang Meizhan and the welder number was identified as 42195.

ESD1-FCSA3-2B/C-64A, 63A (CJP): The welder was identified as Cao Xiaohua and the welder number was identified as 056975.

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# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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ESD1-FCSA3-2B/C-53A, 62A (CJP): The welder was identified as Zou Xiaohua and the welder number was identified as 207463.

ESD1-FESA3-2B/D-23A (CJP): The welder was identified as Deng Junfeng and the welder number was identified as 202756.

The ZPMC CWIs were identified as Li Hongfei & Zhang Zhineng and the ABF representatives were identified as Zhang Jicai & Wang Chenjun. The welding variables recorded by QC appeared to comply with applicable WPS, WPS-B-T-2221-B-P3-S-Z for PJP weld joints & WPS-B-T-2221-B-U3C-S-Z for CJP weld joints.

## II. Struts' welding:

Weld process, SMAW of PJP weld joints located on North Tower struts:

The weld designation numbers and the welders were identified as follows.

WD1-A467-43M-2-2B: The welder was identified as Yang Zaihua and the welder # was identified as 040669.

WD1-A467-43M-2-3A: The welder was identified as Chen Shangchun and the welder # was identified as 046704.

ND1-A476-47.6M-1-31B, 1A: The welder was identified as Cui Guozhong and the welder # was identified as 040656.

ND1-A476-47.6M-1-16B: The welder was identified as Zhu Zeyuan and the welder # was identified as 053916.

The ZPMC CWI was identified as Yu Dongping and the ABF representative was identified as Wang Chenjun.

The welding variables recorded by QC appeared to comply with applicable WPS, WPS-B-T-3212-Tc-U5b-1 for PJP weld joints.

## ULTRASONIC TESTING:

Bay 11 - Tower Assembly:

This QA Inspector performed 10% UT of area previously tested by ZPMC UT personnel. This QA Inspector generated a TL-6027 UT report on this date.

1. The members were identified as Lift 3 – East Tower Skin “A” Stiffener Splice butt weld joints (CJP).

The weld designation numbers are as follows.

ESD1-FASA3-2E/Z-23B (R1), 24B (R1)

2. The member was identified as Lift 1 – West Tower Skin “C” Interior connection plate T weld joint.

The weld designation number is as follows.

WSD1-SA99-3A/B

3. The members were identified as Lift 3 – East Tower Skin “B” plate butt weld joints (CJP).

The weld designation numbers are as follows.

ESD1-FBSA3-2A/C-9B-2, 12B, 13B, 16B-1, 16B-2, 22B, 21B

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

## Summary of Conversations:

No relevant conversations

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.

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# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

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## 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 (134-825-70045), who represents the Office of Structural Materials for your project.

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