

**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-008200**Date Inspected:** 06-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	Du Zhi Qun, Yu Dong Ping	<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 CALTRANS OSM Quality Assurance (QA) Inspector, Dilip Chakrabarti was present during the times noted above for observations relative to the work being performed.

Bay# 10- Tower Assembly:

This QA Inspector randomly observed the following work in progress:

**FCAW Process:**

Welding of weld joint# 6 located on PCMK NSD1 FDSA4-3 D/D. Welder is identified as 201825. ZPMC QC is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2332-TC-P5-F.

Welding of weld joint# 5 located on PCMK NSD1 FDSA4-3 D/D. Welder is identified as 054069. ZPMC QC is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2332-TC-P5-F.

Welding of weld joint# 49 located on PCMK NSD1 FDSA4-3 D/D. Welder is identified as 057266. ZPMC QC is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2332-TC-P5-F.

Welding of weld joint# 50 located on PCMK NSD1 FDSA4-3 D/D. Welder is identified as 057244. ZPMC QC is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the specified WPS no.

---

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

---

B-T-2332-TC-P5-F.

Welding of weld joint# 38 located on PCMK NSD1 FASA4-1 E/E. Welder is identified as 053870. ZPMC QC is identified as Du Zhi Qun. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2331-TC-P5-F.

Welding of weld joint# 50A located on PCMK NSD1 FASA4-1 E/E. Welder is identified as 053870. ZPMC QC is identified as Du Zhi Qun. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2331-TC-U5-F.

Final VT:

This QA inspector performed Final Visual Testing (FVT) of entire welded area excluding Double Diaphragm 1200mm length, previously tested and accepted by ZPMC Quality Control personnel of the member and weld designated are as follows:

Sl # Section # Weld # Green Tag # Location

- |    |               |      |    |    |
|----|---------------|------|----|----|
| 1. | WD1- A112 B/H | 1 B  | NA | NA |
| 2. | WD1- A166 E/J | 97 B | NA | NA |

Magnetic Particle Testing (MT):

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6028 MT report on this date. The member and the weld designations are as follows:

Sl # Section # Weld # Green Tag # Location

- |    |               |      |    |    |
|----|---------------|------|----|----|
| 1. | WD1- A112 B/H | 1 B  | NA | NA |
| 2. | WD1- A166 E/J | 97 B | NA | NA |

Bay# 11- Tower Assembly:

This QA Inspector randomly observed the following work in progress:

SAW Process:

Welding of weld joint# 1A located on PCMK WD1 A5007-21, 22, 23, 24. Welder is identified as 042195. ZPMC QC is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3221-TC-U5-S-1.

Welding of weld joint# 1A located on PCMK WD1 A5001-5, 6, 7, 8. Welder is identified as 040634. ZPMC QC is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3221-TC-U5-S-1.

SMAW Process:

Repair welding of weld joint# 50 A/B located on PCMK ESD1 FCSA4-2 F/F. Welder is identified as 040669. ZPMC QC is identified as Mao Bin Bin. The welding variables recorded by QC appeared to comply with the specified WPS no. WPS-345-SMAW-2G (2F) Repair

---

---

## WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

---

Repair welding of weld joint# 17 A/B located on PCMK ESD1 FCSEA4-2 F/F. Welder is identified as 053916. ZPMC QC is identified as Mao Bin Bin. The welding variables recorded by QC appeared to comply with the specified WPS no. WPS-345-SMAW-2G (2F) Repair

Repair welding of weld joint# 50 A/B located on PCMK ESD1 FCSEA4-2 F/F. Welder is identified as 047470. ZPMC QC is identified as Mao Bin Bin. The welding variables recorded by QC appeared to comply with the specified WPS no. WPS-345-SMAW-2G (2F) Repair

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

**Summary of Conversations:**

No relevant Conversation

**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.

---

<b>Inspected By:</b>	Chakrabarti,Dilip Kumar	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

---