

**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-008203**Date Inspected:** 10-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>	Li Lin			<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>	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# 11- Tower Assembly:

This QA Inspector randomly observed the following work in progress:

**SMAW Process:**

Welding of weld joint# 31A located on PCMK WSD1 FESA4-4 F/F. Welder is identified as 041271. ZPMC QC is identified as Li Lin. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3211-TC-U5b-1.

Welding of weld joint# 29 located on PCMK WSD1 FESA4-4 F/F. Welder is identified as 041271. ZPMC QC is identified as Li Lin. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3311-TC-P5.

**Ultrasonic Testing (UT):**

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6027 UT report on this date.

The member and the weld designations are as follows:

Sl # Section # Weld # Green Tag # Location

1. WSD1 A115 D/J 151 NA NA

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## WELDING INSPECTION REPORT

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2. WSD1 A115 E/J 23 NA NA

3. WSD1 A115 F/J 24 NA NA

Bay# 10- Tower Assembly:

This QA Inspector randomly observed the following work in progress:

FCAW Process:

Welding of weld joint# 19 located on PCMK NSD1 FDSA4-3 D/D. Welder is identified as 201825. ZPMC QC is identified as Jiang Xiao Bo. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2332-TC-P5-F.

Welding of weld joint# 20 located on PCMK NSD1 FDSA4-3 D/D. Welder is identified as 057244. ZPMC QC is identified as Jiang Xiao Bo. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2332-TC-P5-F.

Welding of weld joint# 15A located on PCMK NSD1 FDSA4-3 D/D. Welder is identified as 066733. ZPMC QC is identified as Jiang Xiao Bo. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2232-TC-U5-F.

Welding of weld joint# 2 located on PCMK NSD1 FDSA4-1 C/C. Welder is identified as 052075. ZPMC QC is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2332-TC-P5-F.

Welding of weld joint# 3 located on PCMK NSD1 FDSA4-1 C/C. Welder is identified as 050041. ZPMC QC is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2332-TC-P5-F.

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.

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