

**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-008298**Date Inspected:** 05-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Yang**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 and OBG**Summary of Items Observed:**

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

Bay 10:

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 an MT report for this date. The members are identified as North Tower Lift 1 Skin Plate C to D corner weld joints. The weld identification numbers are as follows: NSD1-A112 B/H-2B and NSD1-A166 E/J-124B. After completion of Magnetic Particle Testing verification this QA Inspector signed green tag document 8393 along with ZPMC QC Liu Yang and American Bridge Flour QC Yang Yi Heng.

Bay 10-

FCAW welding of South Tower Lift 3 Corner weld joint SSSL3-1 B/K- 82B. ZPMC welder was identified as 053116. ZPMC QC is identified as Du Zhi Qun. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2231-C-U2-F.

FCAW welding of North Tower Lift 4 Skin Plate D longitudinal stiffener welds, NSD1-FDSA4-3 D/D-19 and 20. ZPMC welders were identified as 057266 and 057244. ZPMC QC is identified as Du Zhi Qun. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2332-TC-P5-F.

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# WELDING INSPECTION REPORT

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Bay 11-

This QA Inspector observed the following work in progress: FCAW welding of West Tower Lift 2 diaphragm weld WSD1-A115 G/J-196. ZPMC welder was identified as 067184. ZPMC QC is identified as Peng Guo. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-4333-TC-P4-F.

FCAW welding of East Tower Lift 4 Skin D stiffener connection plate welds, ESD1-FDSA4-2 C/D-11, 12, 25, 26, 27 and 28 . ZPMC welders were identified as 066882, 070212, 070254 and 0701240. ZPMC QC is identified as Peng Guo. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-4332-TC-P4-F.

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

### Summary of Conversations:

As identified within the contents of this report.

### 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>	Viars,Larry	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer

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