

**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-008914**Date Inspected:** 13-Aug-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:** Chen Xi/ Li Xiu 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:** OBG /Tower Components**Summary of Items Observed:**

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

**Bay #3**

This QA inspector performed 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 member is identified as OBG Components. The weld designations reviewed are as follows:

- ( CA076-093~100)
- ( CA076-079~086)
- ( CA075-071~078)
- ( CA078-061~068)
- ( CA075-043~050)
- ( CA075-029~036)
- ( CA075-085~092)
- ( CA076-107~114)
- ( CA075-057~064)
- ( CA072-079, 080, 081, 082, 083, 084, 101, 102)

**Bay #11**

This QA inspector performed MT of approximately 15% and Visual Inspection of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member is identified as Tower Components. The weld designations reviewed are as follows:

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-( WSD1-FBSA4-2A/C-54A/B, 67A/B, 68A/B, 88A/B, 89A/B)

-( WSD1-FBSA4-2A/C-55, 56, 58, 59, 63~66, 69, 70, 72, 73)

Bay #2

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member is identified as OBG Components. The weld designations reviewed are as follows:

-(FB3020-001-001, 016, 017)

-(FB3092-001-001, 016, 017)

-(FB3023-001-018, 019)

-(FB3082-003-001, 016, 017)

-(FB3079-001-001, 014, 022)

-(FB3094-001-018, 019)

-(FB3082-001-001, 016, 017)

-(FB3096-001-018, 019)

-(FB3022-001-017, 018)

-(FB3082-001-001, 014, 015)

-(FB3013-002-001, 016, 017)

-(FB3083-002-001, 016, 017)

-(FB3009-001-001, 020, 021)

-(FB3082-002-001, 016, 017)

-(FB3047-001-001, 015)

-(FB3013-003-001, 017)

Bay #11

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member is identified as Tower Components. The weld designations reviewed are as follows:

-( WSD1-FBSA4-2A/C-54A/B, 67A/B, 68A/B, 88A/B, 89A/B)

This QA inspector observed the following work in progress:

Bay#3

Repair by FCAW welding process of weld joint FB023-011-125, 126 located on FB-023-011. Welder is identified as 044790 (1G). ZPMC QC-CWI is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Repair by SMAW welding process of weld joint FB023-010-044, 045, 028, 029 located on FB023-010. Welder is identified as 057795 (1F). ZPMC QC-CWI is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint FB204-041-024, 018, 012, 006 located on FB204-041. Welder is identified as 044830(1F). ZPMC QC-CWI is identified as Yin Dong Hai. The welding variables recorded by QC appeared to comply with the Applicable WPS.

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FCAW welding of weld joint FB204-044-061, 062, 029, 030, 035, 036, 034, 028 located on FB204-044. Welder is identified as 044824(1F). ZPMC QC-CWI is identified as Yin Dong Hai. The welding variables recorded by QC appeared to comply with the Applicable WPS.

### Bay#2

Joint fit-up verified by SMAW welding process of weld joint FB3027-001-023, -31 located on FB3027-001. Welder is identified as 045268 (1G). ZPMC QC-CWI is identified as Zhan Hai Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS

SAW welding of weld joint FB3041-001-023, 031 located on FB3041-001. Welder is identified as 207237(1G). ZPMC QC-CWI is identified as Zhan Hai Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Root Pass performed by FCAW welding of weld joint FB3042-001-023, 031 located on FB3042-001. Welder is identified as 062438 (1G). ZPMC QC-CWI is identified as Zhan Hai Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

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

### Summary of Conversations:

No relevant conversations.

### 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 Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Patel,Hiranch	Quality Assurance Inspector
<b>Reviewed By:</b>	Prue,Erik	QA Reviewer

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