

**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-009229**Date Inspected:** 25-Sep-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:** Du Zhi Qun**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 and Tower**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 8-

Caltrans QA Inspectors Goulet and Viars were requested to perform Magnetic Particle Testing (MT) verification of OBG Floor beam welds tested and accepted by ZPMC QC, as per NDT Inspection Notification sheet 004288. Upon arrival several Floor beams were found to be visually unacceptable. Discontinuities noted included undercut, overlap, base metal damage and poor weld profile. Caltrans QA Inspectors showed discontinuities to ZPMC QC and ZPMC concurred with QA. ZPMC QC cancelled the notification and stated they would perform the visual inspection again and resubmit the inspection notification. QA inspector Goulet issued an Incident Report this date for the above mentioned issues. Please see attached photographs.

Bay 10-

This QA Inspector observed the following work in progress: Flux Cored Arc Welding (FCAW) welding of North Tower Lift 4 Skin Plate D stiffener connection plate welds NSD1-FDSA4-3 C/D-013 and 061. ZPMC welders were identified as 053116 and 052075. ZPMC QC is identified as Du Zhi Qun. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-4332-TC-P5-F.

SMAW tack welding of South Tower Lift 4 Skin Plate A to Skin Plate B weld SSTL4-1 B/L-4A. ZPMC welder

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# WELDING INSPECTION REPORT

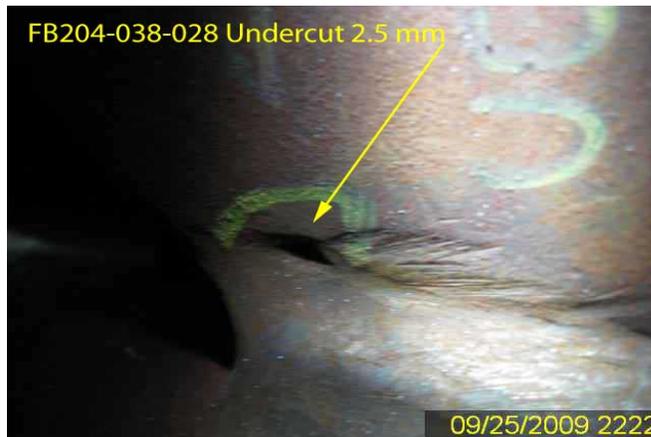
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was identified as 057220. ZPMC QC is identified as Du Zhi Qun. The welding appeared to be in conformance with welding procedure specification, WPS-B-P-2214-B-U2.

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 Eric Tsang, 150 0042 2372, 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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