

**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-009561**Date Inspected:** 05-Oct-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:** Wang Chuan Qing**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.

**OBG Trial Assembly:**

Caltrans QA performed Magnetic Particle Testing (MT) of 1AAW to 1AW Deck Panel transverse splice weld, OBW1-001. Magnetic Particle Testing was performed on excavation areas of Transverse Indications found with Ultrasonic Testing. A total of 19 transverse linear indications were observed from Y location 21940 mm to 23500 mm during inspection. Indications ranged from 2 to 7 mm in length.

**Bay 10-**

This QA Inspector observed the following work in progress: Flux Cored Arc Welding (FCAW) welding of South Tower Lift 3, 89 meter bottom diaphragm fit lug to stiffener weld, SSTL3-1 C/K-51. ZPMC welder was identified as 053869. ZPMC QC is identified as Wang Chuan Qing. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2333-TC-P4-F.

FCAW welding of South Tower Lift 3, 99 meter top diaphragm to fit lug weld, SSTL3-1 G/K-139. ZPMC welder was identified as 052075. ZPMC QC is identified as Wang Chuan Qing. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-4333-TC-P4-F.

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## WELDING INSPECTION REPORT

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SMAW welding of South Tower Lift 4, Skin Plate B to C weld , SSTL4-1 B/L-5A . Welding was performed at areas that will covered when the tower is placed in support rings. ZPMC welder was identified as 056200. ZPMC QC is identified as Li Peng Fei. The welding appeared to be in conformance with welding procedure specification, WPS-345-SMAW- 4G (4F)-Repair.

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

**Summary of Conversations:**

Only general conversation occurred between QC and QA this date.

**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>	Dawson,Paul	QA Reviewer

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