

**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-009601**Date Inspected:** 11-Oct-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**CWI Name:** See below**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 Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector George Goulet was present during the times noted above for observations relative to the work being performed.

Bay 10

This QA Inspector randomly observed the following work in progress in Bay 10:

FCAW welding of weld joint SSTL4-1C/L-69, 67 located inside PCMK south tower, lift 4, skin C, stiffener to fit lug at bottom of 119M diaphragm. Welder was identified as 057180. ZPMC QC was identified as CWI Wang Chuan Qing (QC1). Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Inspector Sun Tian Liang, who was not a CWI. The welding variables recorded by QC1 and QC1's assistant appeared to comply with WPS-B-T-2333-TC-P4-F.

FCAW welding of weld joint SSTL4-1C/L-129, 135 located inside PCMK south tower, lift 4, skin C, stiffener to fit lug at top of 119M diaphragm. Welder was identified as 057244. ZPMC QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Inspector Sun Tian Liang, who was not a CWI. The welding variables recorded by QC1 and QC1's assistant appeared to comply with WPS-B-T-2333-TC-P4-F.

FCAW welding of weld joint SSTL4-1J/L-125, 129 located inside PCMK south tower, lift 4, skin C, stiffener to fit lug at top of 139M diaphragm. Welder was identified as 040533. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-2333-TC-P4-F.

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# WELDING INSPECTION REPORT

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FCAW welding of weld joint SSTL4-1J/L-124, 128 located inside PCMK south tower, lift 4, skin C, fit lug to top of 139M diaphragm. Welder was identified as 040343. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-4333-TC-P4-F.

FCAW welding of weld joint SSTL4-1H/L-124, 126 located inside PCMK south tower, lift 4, skin C, stiffener to fit lug. Welder was identified as 052075. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-2333-TC-P4-F.

FCAW welding of weld joint SSTL4-1H/L-123, 125 located inside PCMK south tower, lift 4, skin C, fit lug to diaphragm. Welder was identified as 053869. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-4333-TC-P4-F.

SMAW repair welding of weld joint NSTL3-3H/K-95, 96 located inside PCMK north tower, lift 3, skin B to skin C corner, angle stiffener to the top of 105.5M diaphragm. ZPMC QC was identified as Tu Jun (QC2). The welding variables recorded by QC2 appeared to comply with WPS-385-SMAW-4G(4F)-repair.

Bay 11

This QA Inspector randomly observed the following work in progress in Bay 11:

SMAW welding of various weld joints attaching lower and upper shaft rotator fenders on PCMK east tower, lift 4, skin D to skin E corner and skin E to skin A corner. Welder at the lower locations was identified as 053224. Welder at the lower locations was identified as 053310. ZPMC QC was identified as You Qi Guo (QC3). Assisting QC3 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Inspector Cao Cheng, who was not a CWI. The welding variables recorded by QC2's assistant appeared to comply with WPS-B-T-2113.

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

**Summary of Conversations:**

No relevant conversations except as noted above.

**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>	Goulet,George	Quality Assurance Inspector
<b>Reviewed By:</b>	Dawson,Paul	QA Reviewer

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