

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

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-009632**Date Inspected:** 05-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	Wan Wen Zhong, Chen Ying Xin.			<b>CWI Present:</b>	<b>Yes</b>	<b>No</b>	
<b>Inspected CWI report:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Approved WPS:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
				<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Bridge No:</b>	34-0006			<b>Component:</b>	Tower		

**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

Bay 10 South Tower Lift 3 AE corner seam

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% and random Visual Testing (VT) of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT reports for this date. The members are identified as Tower Components. The weld designations reviewed are as follows.

SSTL3-1B/K-84A

Bay 11 Angle Plate

This QA inspector issued the Green Tag for the following components

ED1-SA183-28M-3

WD1-SA183-28M-4

ED1-SA183-33M-2

---

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 4 )

---

---

ED1-SA183-47.6M-2 Green Tag No. 9272

WD1-SA183-38M-3

WD1-SA183-33M-4

WD1-SA183-43M-1

ED1-SA183-18M-2

This Quality Assurance (QA) Inspector observed the following work in progress:

Bay 10

FCAW welding of weld joint 2A located on NSD1-SPSA3-70.

Welder is identified as 040261. ZPMC CWI is identified as Mr. Gong Liang Zhu.

The welding variables recorded by QC appeared to comply with WPS-B-T-2231-Tc-U5-F.

SMAW welding of weld joint 9B located on ED1-A6003-6.

Welder is identified as 053049. ZPMC CWI is identified as Mr. Chen Ying Xin.

The welding variables recorded by QC appeared to comply with WPS-B-T-3212-Tc-U5b-1.

SMAW welding of weld joint 5A (Repair) located on SSTL4-1B/L.

Welder is identified as 040581. ZPMC CWI is identified as Mr. Wan Wen Zhong.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G(4F)-REPAIR.

SAW welding of weld joint 2B located on ED1-STSA3-2-109M-1.

Welder is identified as 052917. ZPMC QC is identified as Mr. Yu Zhi Lai.

The welding variables recorded by QC appeared to comply with WPS-B-T-4221-B-U3c-S-1.

SAW welding of weld joint 6B located on ED1-STSA3-2-99M-1.

Welder is identified as 040252. ZPMC QC is identified as Mr. Yu Zhi Lai.

The welding variables recorded by QC appeared to comply with WPS-B-T-4221-B-U3c-S-1.

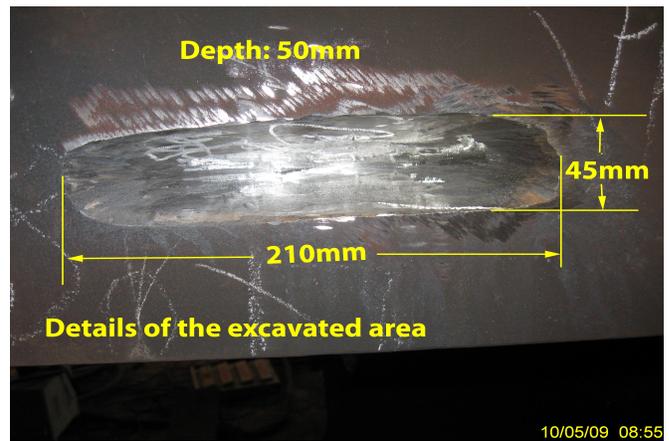
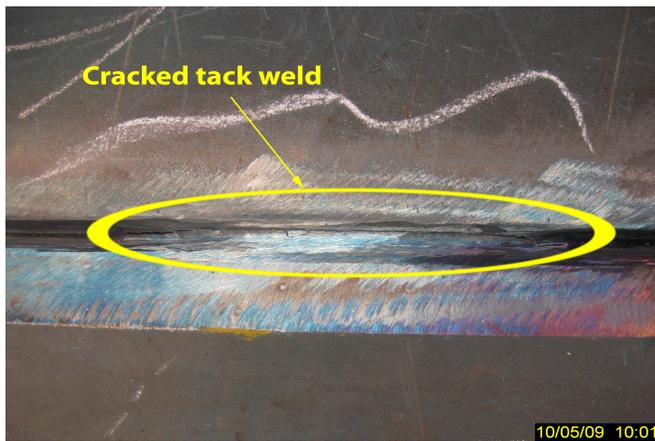
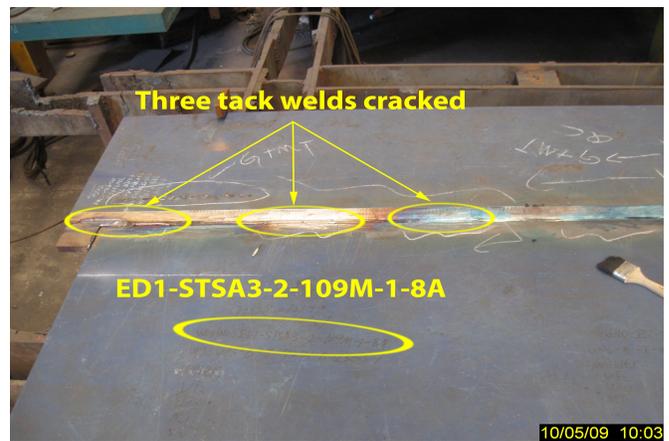
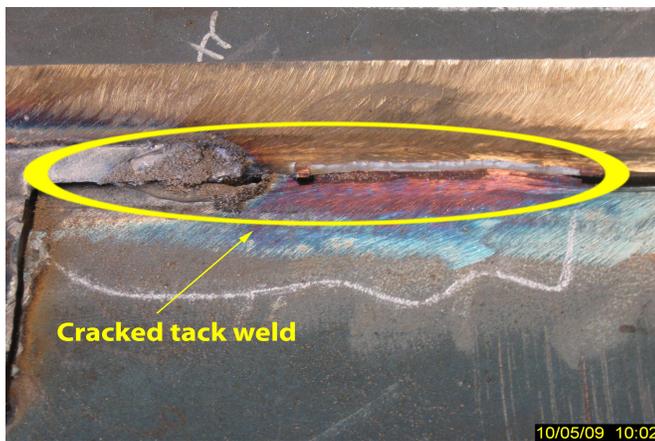
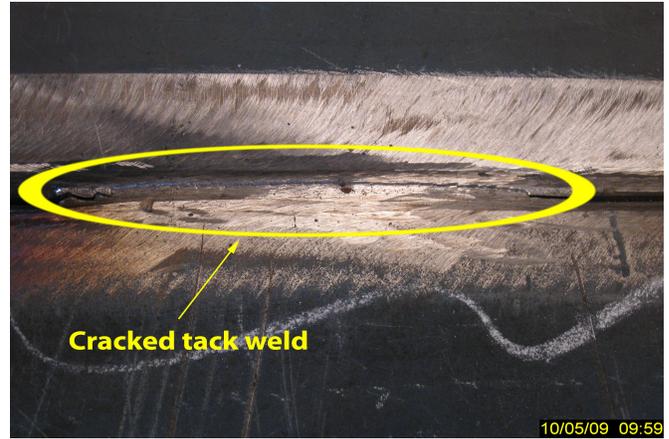
During random Visual Testing (VT), Caltrans Quality Assurance (QA) Inspector observed crack on the tack weld of weld ED1-STSA3-2-109M-1-8A of Strut plate. The attached picture provide additional details.

During random visual inspection, Caltrans Quality Assurance (QA) Inspector observed the excavated area on AE corner seam of West tower lift 3 weld # WSTL3-4B/K-81A/B. This area had been rejected by ultrasonically by ZPMC NDT personnel. The attached photographs provide additional detail.

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

# WELDING INSPECTION REPORT

( Continued Page 3 of 4 )



## Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

## 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.

---

---

# WELDING INSPECTION REPORT

*( Continued Page 4 of 4 )*

---

---

<b>Inspected By:</b>	Gaikwad,Umesh	Quality Assurance Inspector
----------------------	---------------	-----------------------------

<b>Reviewed By:</b>	Clifford,William	QA Reviewer
---------------------	------------------	-------------