

**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-010049**Date Inspected:** 28-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:

SMAW welding of weld joint NSTL3-3G/K-55 located inside PCMK north tower, lift 3, bottom of double diaphragm 99M to A/E corner closure plate. Welder was identified as 050038. ZPMC QC was identified as CWI Wan Wen Zhong (QC1). The welding variables recorded by QC1 appeared to comply with WPS-B-T-3212-B-U2a-2.

SMAW welding of weld joint NSTL3-3G/K-142 located inside PCMK north tower, lift 3, top of double diaphragm 99M to A/E corner closure plate. Welder was identified as 052493. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-3212-B-U2a-2.

**Bay 11**

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

FCAW welding of weld joints ESTL4-2G/L-107, 108 located inside PCMK east tower, lift 4, skin A, top of double diaphragm 127M to stiffener. Welder was identified as 047701. ZPMC QC was identified as CWI Zhi Neng Zhang (QC2). The welding variables recorded by QC2 appeared to comply with WPS-B-T-4333-TC-P4-F.

---

---

# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---

---

FCAW welding of weld joints ESTL4-2I/L-97 located inside PCMK east tower, lift 4, skin A, top of double diaphragm 135M to stiffener. Welder was identified as 042218. ZPMC QC was identified as CWI Zhi Neng Zhang (QC2). The welding variables recorded by QC2 appeared to comply with WPS-B-T-4333-TC-P4-F.

Installation of lift 1/lift 2 splice plates A and B in west tower, lift 1 using temporary bolts.

Unless otherwise noted, all work 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 Serge Sinevod, 134-8257-0045, who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Goulet,George	Quality Assurance Inspector
----------------------	---------------	-----------------------------

---

<b>Reviewed By:</b>	Dawson,Paul	QA Reviewer
---------------------	-------------	-------------