**DEPARTMENT OF TRANSPORTATION**
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

# WELDING INSPECTION REPORT

**Resident Engineer:** Pursell, Gary
**Address:** 333 Burma Road
**City:** Oakland, CA 94607

**Report No:** WIR-010193
**Date Inspected:** 07-Oct-2009

**Project Name:** SAS Superstructure
**Prime Contractor:** American Bridge/Fluor Enterprises, a JV
**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

**OSM Arrival Time:** 645
**OSM Departure Time:** 1845
**Location:** Shanghai, China

**CWI Name:** Chen Li

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|---|---|---|---|---|---|---|---|---|
| **Inspected CWI report:** | ☐ Yes | ☑ No | ☐ N/A | **CWI Present:** | ☑ Yes | ☐ No | |
| **Electrode to specification:** | ☑ Yes | ☐ No | ☐ N/A | **Rod Oven in Use:** | ☑ Yes | ☐ No | ☐ N/A |
| **Qualified Welders:** | ☑ Yes | ☐ No | ☐ N/A | **Weld Procedures Followed:** | ☑ Yes | ☐ No | ☐ N/A |
| **Approved Drawings:** | ☑ Yes | ☐ No | ☐ N/A | **Verified Joint Fit-up:** | ☑ Yes | ☐ No | ☐ N/A |
| | | | | **Approved WPS:** | ☑ Yes | ☐ No | ☐ N/A |
| | | | | **Delayed / Cancelled:** | ☐ Yes | ☑ No | ☐ N/A |

**Bridge No:** 34-0006
**Component:** OBG and Tower COMPONENT

**Summary of Items Observed:**
On this date Caltrans OSM Quality Assurance(QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

In process Inspection
Bay #2
This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) in the 2F position of the OBG floor Beam assembly weld No. FB-3052-001-017/18. The welder is identified as #062438. ZPMC QC is identified as Mr.Yang Qing Feng .The welding variables recorded by QC appear to comply with WPS- B – T-2132-3.

Flux Core Arc Welding (FCAW) in the 2G position of the OBG Floor Beam assembly weld No. FB-3052-001-045. The welder is identified as #045276. ZPMC QC is identified as Mr. Yang Qing Feng.The welding variables recorded by QC appear to comply with WPS- B – T-2232-Tc-U4b-F.

Flux Core Arc Welding (FCAW) in the 2F position of the OBG Floor Beam assembly weld No. FB-3041-001-013/14. The welder is identified as #045203. ZPMC QC is identified as Mr.Yin Dong Hai.The welding variables recorded by QC appear to comply with WPS- B – T-2132-3.

Witness of Magnetic Particle Testing

# WELDING INSPECTION REPORT

*( Continued Page 2 of 2 )*

This QA inspector was instructed by task leader to carry out Witnessing of Magnetic Particle Testing which was carried by ZPMC QC Technicians at Floor Beam Assembly Weld. The QA Inspector observed one Transverse linier indications found by ZPMC QC on this date .

The weld designations reviewed is as follows:
FB-3003-001-004

Bay #6
This QA Inspector observed the following work in progress:

SMAW welding in the 2G position at excavation area on weld joint WD1-A305-65M-3-2A/B located on Tower Strut assembly . Welder is identified as #067707. ZPMC QC is identified as Zhang Bao Bo .The welding variables recorded by QC appeared to comply with WPS-485-SMAW-2G (2F)-FCM-Repair-1 and repair procedure T-WR2310.

South Tower Lift #1

This QA inspector was instructed by task leader to carry out Witnessing of Magnetic Particle Testing at lift 1 South Tower Diaphragm to Skin Connected welds . The MT indications found by ABF QC on this date were recorded onto a data sheet that Caltrans QA filled out.

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 Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

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| **Inspected By:** | Bera,Subhasis | Quality Assurance Inspector |
| **Reviewed By:** | Patterson,Rodney | QA Reviewer |