

**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-010666**Date Inspected:** 05-Dec-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**CWI Name:** Du Zhi Qun**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**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 11 EAST TOWER LIFT 2 GRATING BRACKETS**

This QA inspector performed random Visual Testing (VT) of the area previously tested and accepted by ZPMC Quality Control personnel. The members are identified as Tower Components. The weld designations reviewed are as follows.

GGSA-50PLAN-E74M-1~13-(1, 2, 3, 4, 5, 6)

GGSA-52PLAN-E77M-1-(1, 2, 3, 4, 5, 6)

GGSA-54PLAN-E77M-1-(1, 2, 3, 4, 5, 6)

GGSA-56PLAN-E80.75M-1~6, 8, 9, 10-(1, 2, 3, 4, 5, 6)

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

Bay 10

SMAW welding of weld joint 61A located on ED1-STSA3-2-89M-2.

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Welder is identified as 040582. ZPMC CWI is identified as Mr. Du Zhi Qun.  
The welding variables recorded by QC appeared to comply with WPS-B-T-3212-Tc-U5b-1.

FCAW welding of weld joint 15 located on SSD1-A434A/D.  
Welder is identified as 057180. ZPMC QC is identified as Mr. Lu Wei Chao.  
The welding variables recorded by QC appeared to comply with WPS-B-T-2332-Tc-P4.

SMAW welding of weld joint 38 located on ND1-A6002-18.  
Welder is identified as 040268. ZPMC CWI is identified as Mr. Du Zhi Qun.  
The welding variables recorded by QC appeared to comply with WPS-B-T-4113-1.

SMAW welding of weld joint 2 located on ND1-BPSA5-1-2.  
Welder is identified as 066236. ZPMC QC is identified as Jiang La Mei.  
The welding variables recorded by QC appeared to comply with WPS-B-T-3312-Tc-P5.

SMAW welding of weld joint 11B located on ED1-STSA3-2-109M-2.  
Welder is identified as 052493. ZPMC QC is identified as Mr. Yu Zhi Lai.  
The welding variables recorded by QC appeared to comply with WPS-B-T-3212-Tc-U5b-1.

SMAW welding of weld joint 3A(Repair) located on NSD1-TL5-3E/F.  
Welder is identified as 056200. ZPMC QC is identified as Mr. Sun Tian Liang.  
The welding variables recorded by QC appeared to comply with WPS-485-SMAW-1G(1F)-FCM-REPAIR-1.

### SOUTH TOWER LIFT 4 PADEYE ON SKIN E

SMAW welding of weld joint 44 located on SSD1-FESA4-1A/F.  
Welder is identified as 040581. ZPMC QC is identified as Mr. Li Peng Fei.  
The welding variables recorded by QC appeared to comply with WPS-B-P-2114-PADEYE.

### NORTH TOWER LIFT 4 B/C CORNER SEAM

FCAW welding of weld joint 5B located on NSTL4-3B/L.  
Welder is identified as 040533. ZPMC QC is identified as Mr. Li Peng Fei.  
The welding variables recorded by QC appeared to comply with WPS-B-T-2231-Tc-U4b-F.

### NORTH TOWER LIFT 4 A/E CORNER SEAM

FCAW welding of weld joint 3B located on NSTL4-3B/L.  
Welder is identified as 053869. ZPMC QC is identified as Mr. Li Peng Fei.  
The welding variables recorded by QC appeared to comply with WPS-B-T-2232-Tc-U4b-F.

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

### Summary of Conversations:

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

### Comments

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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>	Gaikwad,Umesh	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

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