

**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-011182**Date Inspected:** 06-Jan-2010**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>	Chen Ying Xin, An Qing Xiang			<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 11 TOWER STRUT**

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as Tower Components. The weld designations reviewed are as follows.

SD1-STSA3-1-99M-1-9, 10, 11, 12, 25, 26

**BAY 10 TOWER STRUT**

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.

ED1-STSA3-2-89M-1 GREEN TAG NO. 11694

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## WELDING INSPECTION REPORT

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

Bay 10

### TOWER STRUT

SMAW welding of weld joint 15 located on ND1-STSA3-1-89M-1.

Welder is identified as 040268. ZPMC CWI is identified as Mr. Chen Ying Xin.

The welding variables recorded by QC appeared to comply with WPS-B-T-2113.

### NORTH TOWER LIFT 5 BEARING PLATE REPAIR

SMAW welding of weld joint 4A/B (Repair) located on ND1-BPSA5-2-1.

Welder is identified as 052930. ZPMC QC is identified as Jiang La Mei.

The welding variables recorded by QC appeared to comply with WPS-485-SMAW-2G(2F)-REPAIR.

BAY 11

### EAST TOWER LIFT 4 CORNER DIAGONAL PLATE TO SKIN

FCAW welding of weld joint 16 located on ESTL4-2B/L.

Welder is identified as 048810. ZPMC CWI is identified as Mr. Liu Zhong An.

The welding variables recorded by QC appeared to comply with WPS-B-T-2332-Tc-P4-F.

### WEST TOWER LIFT 4 CORNER SEAM

SMAW welding of weld joint 4A located on WSTL4-2L/L.

Welder is identified as 040690. ZPMC CWI is identified as Mr. Liu Xiao Zhong.

The welding variables recorded by QC appeared to comply with WPS-B-T-3211-Tc-U4b-1.

### TOWER STRUT REPAIR (T-CWR525)

SMAW welding of weld joint 11A/B (Repair) located on WD1-STSA3-2-99M-1.

Welder is identified as 040733. ZPMC QC is identified as Mr. Mao Bin Bin.

The welding variables recorded by QC appeared to comply with WPS-485-SMAW-2G(2F)-FCM-REPAIR-1.

### EAST TOWER LIFT 5 A/B CORNER SEAM

SMAW welding of weld joint 9B located on ESD1-TL5-2B/F.

Welder is identified as 040611. ZPMC QC is identified as Mr. Li Bin.

The welding variables recorded by QC appeared to comply with WPS-B-T-3211-Tc-U4b-1.

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

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

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for your project.

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