

**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-012568**Date Inspected:** 20-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Le Feng**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 Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

Tower Trial Assembly

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW):

Weld joint # 003 located on East Tower Lift-1 Bearing stiffener Plate ESD1 – SA233. Welder is identified as 066674. ZPMC Quality Control (QC) Inspector is identified as Yuan Hui Gang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2333 – Tc – P4 – F.

Weld joint # 025 located on East Tower Lift-1 Bearing stiffener Plate ESD1 – SA294F/G. Welder is identified as 070006. ZPMC Quality Control (QC) Inspector is identified as Yuan Hui Gang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2333 – Tc – P4 – F.

BAY 10

This QA Inspector observed the following work in progress:

---

---

# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

---

## Shielded Metal Arc Welding (SMAW):

Repair welding of a weld joint # 1B located on North Tower Lift-4 C/D corner NSTL4-3B/L. Welder is identified as 052930. ZPMC Quality Control (QC) Inspector is identified as Du Zhi Quin. The welding variables recorded by QC appeared to comply with the WPS – 345 – SMAW – 1G (1F) – Repair.

(See attached photo)

## Sub-Merged Arc Welding (SAW):

Weld joint # 38A located on South Tower Lift-5 B/C corner SSD1 – TL5 – 1B – F. Welder is identified as 050295. ZPMC Quality Control (QC) Inspector is identified as Jiang La Mei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3221 – C – U2b – S.

(See attached photo)

## BAY 11

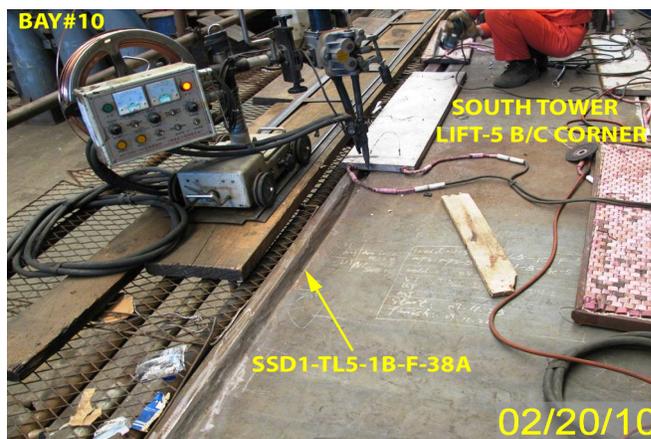
This QA Inspector observed the following work in progress:

## Sub-Merged Arc Welding (SAW):

Weld joint # 4-1B located on Strut Splice Plate ND1 – SA4 – 68 – 139M. Welder is identified as 040699. ZPMC Quality Control (QC) Inspector is identified as Mao Bin Bin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3221 – Tc – U5 – S – 1.

Weld joint # 2-1B located on Strut Splice Plate ND1 – SA4 – 68 – 127M. Welder is identified as 041716. ZPMC Quality Control (QC) Inspector is identified as Mao Bin Bin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3221 – Tc – U5 – S – 1.

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



## Summary of Conversations:

---

---

# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

---

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 - 15000422372, who represents the Office of Structural Materials for your project.

---

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

---