

**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-012575**Date Inspected:** 27-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.

BAY 10

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 005236

Ultrasonic Testing (UT)

This QA inspector performed 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 Component. The weld designations reviewed are as follows:

TOWER SPARE STRUT

ED1 – A6001 – 2 – 7; 8; 9; 10; 11; 12 (A/B) – Green Tag#11720

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW):

Weld joint # 39B located on South Tower Lift-5 C/D corner SSD1 – TL5 – 1B – F. Welder is identified as 052930. ZPMC Quality Control (QC) Inspector is identified as Du Zhi Qun. The welding variables recorded by

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QC appeared to comply with the WPS – B – T – 3211 – Tc – U4b – 1.

Weld joint # 52A/24A located on South Tower Lift-5 D/E corner SSD1 – TL5 – 1B – F. Welder is identified as 050289. ZPMC Quality Control (QC) Inspector is identified as Du Zhi Qun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3211 – Tc – U4b – 1.

Weld joint # 37 located on Skirt Plate SD1 – A440E/E. Welder is identified as 066258. ZPMC Quality Control (QC) Inspector is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2314 – B – P3. (See attached photo)

BAY 11

This QA Inspector observed the following work in progress:

Sub-Merged Arc Welding (SAW):

Weld joint # 1-5A located on Strut Plate ND1 – SA4 – 10 – 119M. Welder is identified as 041716. ZPMC Quality Control (QC) Inspector is identified as Fu Wei Min. The welding variables recorded by QC appeared to comply with the WPS – B – T – 4221 – Tc – U5 – S – 1.

Shielded Metal Arc Welding (SMAW):

Repair welding of a weld joint # 59A according to the weld repair report #T-WR-3071 located on West Tower Lift-4 A/B corner WSTL4-2B/L. Welder is identified as 040733. ZPMC Quality Control (QC) Inspector is identified as Shao Hai Lang. The welding variables recorded by QC appeared to comply with the WPS – 345 – SMAW – 2G (2F) – Repair.

Repair welding of a weld joint # 61B according to the weld repair report #T-WR-3072 located on West Tower Lift-4 D/E corner WSTL4-2B/L. Welder is identified as 048532. ZPMC Quality Control (QC) Inspector is identified as Shao Hai Lang. The welding variables recorded by QC appeared to comply with the WPS – 345 – SMAW – 2G (2F) – Repair. (See attached photo)

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

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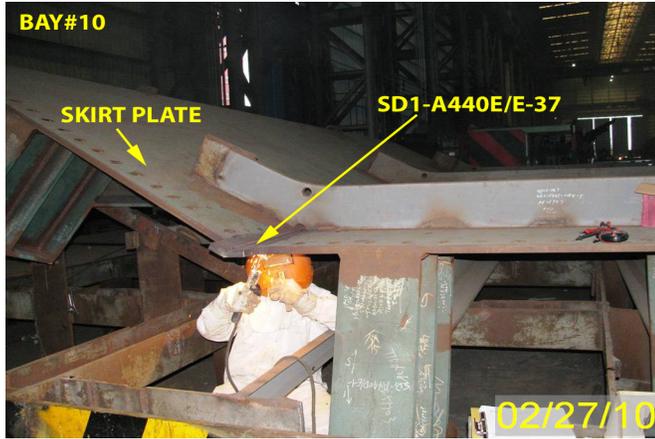
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## Summary of Conversations:

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

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**Inspected By:** Kumar,Sandeep

Quality Assurance Inspector

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**Reviewed By:** Clifford,William

QA Reviewer