**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-013309
**Date Inspected:** 24-Mar-2010

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

**OSM Arrival Time:** 700
**OSM Departure Time:** 1900
**Location:** Shanghai, China

**CWI Name:** Yu Dong Ping, Tu Jun

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|---|---|---|---|---|---|---|---|
| **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:

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

BAY 10

NORTH TOWER LIFT 5, AB CORNER SEAM
SMAW welding of weld joint 39A located on NSD1-TL5-3B-F.
Welder IS identified as 500363. ZPMC QC is identified as Mr. Yu Zhi Lai.
The welding variables recorded by QC appeared to comply with WPS-B-T-3211-B-U4b.

NORTH TOWER LIFT 5, AE CORNER SEAM
SMAW welding of weld joint 40BB located on NSD1-TL5-3B-F.
Welder IS identified as 052930. 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.

NORTH TOWER LIFT 4, BC CORNER DIAGONAL PLATE
FCAW welding of weld joint 49 located on NSTL4-3B/L.

Welder IS identified as 068921. ZPMC QC is identified as Mr. Li Peng Fei.
The welding variables recorded by QC appeared to comply with WPS-B-T-2331-Tc-P4-F-2.

NORTH TOWER LIFT 4, CD CORNER DIAGONAL PLATE
FCAW welding of weld joint 20 located on NSTL4-3B/L.
Welder IS identified as 066283. ZPMC QC is identified as Mr. Li Peng Fei.
The welding variables recorded by QC appeared to comply with WPS-B-T-2332-Tc-P4-F-2.

BAY11

STRUT FLANGE PLATE
SAW welding of weld joint 1A located on ND1-STSA4-6-143M-1.
Welder is identified as 047304. ZPMC QC is identified as Mr. Mao Bin Bin.
The welding variables recorded by QC appeared to comply with WPS-B-T-4221-b-U3c-S-1.

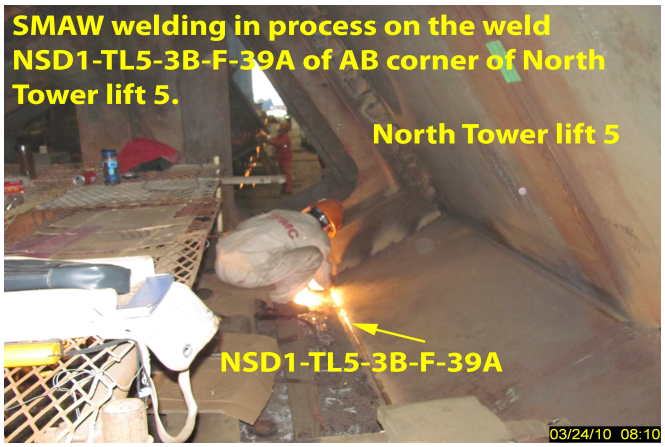
WEST TOWER LIFT 4, BC CORNER DIAGONAL PLATE
FCAW welding of weld joint 22 located on WSTL4-2B/L.
Welder IS identified as 070254. ZPMC QC is identified as Mr. Xu Jie.
The welding variables recorded by QC appeared to comply with WPS-B-T-2331-Tc-P4-F.

FCAW welding of weld joint 16 located on WSTL4-2B/L.
Welder IS identified as 066477. ZPMC QC is identified as Mr. Xu Jie.
The welding variables recorded by QC appeared to comply with WPS-B-T-2332-Tc-P4-F.

PHASED ARRAY ULTRASONIC TESTING (PAUT) TRAINING

This Quality Assurance (QA) Inspector attend the Phased Array Ulrasonic Testing (PAUT) training session organized by ASNT level III.

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



# WELDING INSPECTION REPORT

*( Continued Page 3 of 3 )*

**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 Skyler Guest : 15000422360, who represents the Office of Structural Materials for your project.

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|---|---|---|
| **Inspected By:** | Gaikwad,Umesh | Quality Assurance Inspector |
| **Reviewed By:** | Clifford,William | QA Reviewer |