

**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-013518**Date Inspected:** 03-Mar-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**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

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW):

Weld joint # 02 located on Skirt Extension Block SSD1 – SA447 – 2. Welder is identified as 500373. ZPMC Quality Control (QC) Inspector is identified as Jiang Xiang Bo. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2312 – Tc – P4.

Sub-Merged Arc Welding (SAW):

Weld joint # 6B located on Grillage Plate NSD1 – TL5 – 3B – F. Welder is identified as 052917. ZPMC Quality Control (QC) Inspector is identified as Yu Zhi Zai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3221 – B – U3c – S – 1.

Surface Welding by Flux Core Arc Welding (FCAW):

Due to the reduction in length after Heat Straightening. Surface welding / Weld build up being performed according to the weld repair report #T-WR3075 located on Bottom plate A803 of Skirt Plate # NSD1-A803A/B.

---

---

# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

---

Welder is identified as 054069. ZPMC Quality Control (QC) Inspector is identified as Jiang Xiang Bo. The welding variables recorded by QC appeared to comply with the WPS – 345 – FCAW – 2G (2F) – Repair. (See attached Photo)

BAY 11

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW):

Repair welding of a weld joint # 3A according to the weld repair report #T-WR-3077 located on East Tower Lift-5 A/E corner ESD1 – TL5 – 2B/F. Welder is identified as 046704. ZPMC Quality Control (QC) Inspector is identified as Shao Hai Lang. The welding variables recorded by QC appeared to comply with the WPS –485 – SMAW – 2G (2F) – Repair – 1. (See attached photo)

Repair welding of a weld joint # 61A 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 053916. ZPMC Quality Control (QC) Inspector is identified as Xu Jin Long. The welding variables recorded by QC appeared to comply with the WPS – 345 – SMAW – 2G (2F) – Repair.

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



## 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.

---

Inspected By: Kumar,Sandeep

Quality Assurance Inspector

---

---

# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

---

**Reviewed By:** Clifford, William

QA Reviewer