

**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-013268**Date Inspected:** 15-Apr-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:** Du Zhi Qun**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 Shailesh 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

This QA Inspector performed randomly Visual Inspection Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL- 6027 (UT) report for this date. The member is identified as Lift 4 Tower Strut. The weld designations reviewed are as follows.

WD1-STSA4-5-139M-1-21A/B, 22A/B

SD1-STSA4-5-139M-1-21A/B, 22A/B

WD1-STSA4-5-135M-1-21A/B, 22A/B

SD1-STSA4-5-139M-1-1A/B, 3A/B WD1-STSA4-5-139M-1-1A/B, 3A/B SD1-STSA4-5-143M-1-1A/B, 3A/B

WD1-STSA4-5-143M-1-1, 2, 3, 4A/B WD1-STSA4-5-127M-1-2A/B, 4A/B SD1-STSA4-5-131M-1-2A/B, 4A/B

WD1-STSA4-5-131M-1-2A/B, 4A/B SD1-STSA4-5-135M-1-2A/B, 4A/B WD1-STSA4-5-135M-1-2A/B, 4A/B

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NDT Notification No-005528

This QA Inspector observed the following work in progress:

BAY 11:

This QA Inspector observed ZPMC qualified welding personnel identified as 044560. Perform Submerged Arc Welding (SAW) on Grillage Beam plate. Joint identified as WSD1-TL5-4B/F-10A, ZPMC QC Identified as Xu Jie Long. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-3221 –B-U3c-S-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 040754. Perform Flux Core Arc Welding (FCAW) on Skirt plate. Joint identified as WSD1-A809B/B-3. ZPMC QC Identified as Shao Hai Long, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2132.

This QA Inspector observed ZPMC qualified welding personnel identified as 203269. Perform Flux Core Arc Welding (FCAW) on Skirt plate. Joint identified as WSD1-A801B/D-25. ZPMC QC Identified as Shao Hai Long, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2133.

This QA Inspector observed ZPMC qualified welding personnel identified as 040655. Perform Shielded Metal Arc Welding (SMAW) on Skirt plate Pad eye. Joint identified as WSD1-A801-B/D-32,33,23,24,22,21,31,34,35,36,37. ZPMC QC Identified as Shao Hai Long, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2113Pad eye.

This QA Inspector observed ZPMC qualified welding personnel identified as 044541, 044551. Perform Shielded Metal Arc Welding (SMAW) on Tower Strut. Joint identified as ED1-STSA4-6-127M-2-10A, ZPMC QC Identified as Mao Bin Bin, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2212-Tc-U5b-1. For more information see below attach photo No-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 040614, 040667. Perform Shielded Metal Arc Welding (SMAW) on Tower Strut. Joint identified as ND1-STSA4-6-123M-2-10A, ZPMC QC Identified as Mao Bin Bin, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2212-Tc-U5b-1. For more information see below attach photo No-1.

BAY 10

Repair Welding:

This QA Inspector observed ZPMC qualified welding personnel identified as 056200, 052493. Perform Shielded Metal Arc Welding (SMAW) on South Tower 146M connect plate stiffener, SSD1-SPSA5-16-LS5-9, SSD1-SPSA5-13-LS5-4. Build up 6~8mm. Item identified as 146M Connect plate, ZPMC QC Identified as Yuan Hai Gang, with Critical welding repair report, CWR-T-CWR612. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-485-SMAW-2G (2F) Repair-1.

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# WELDING INSPECTION REPORT

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This QA Inspector observed ZPMC qualified welding personnel identified as 040349, 052075. Perform Flux Core Arc Welding (FCAW) on Facade channel plate. Joint identified as WD1-SFSA3-30-1,2,3,4,5,6,7,27,28,31,35,39, 40. ZPMC QC Identified as Zhu Zhong Jie, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2132. For more information see below attach photo No-2.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the 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 Skyler Guest phone: 15000422360, who represents the Office of Structural Materials for your project.

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

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