

**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-013271**Date Inspected:** 19-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:

This QA Inspector observed the following work in progress:

BAY 11:

SMAW Process:

This QA Inspector observed ZPMC qualified welding personnel identified as 040656, 046704. Perform Shielded Metal Arc Welding (SMAW) on Tower Strut. Joint identified as ND1-STSA4-6-135M-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.

This QA Inspector observed ZPMC qualified welding personnel identified as 040656, 046704. Perform Shielded Metal Arc Welding (SMAW) on Tower Strut. Joint identified as ND1-STSA4-6-135M-2-74B, 5A, 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-3212-Tc-U5b-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 040619. Perform Shielded Metal Arc

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## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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Welding (SMAW) on Tower Strut. Joint identified as ND1-STSA4-6-131M-1-10A, 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.

This QA Inspector observed ZPMC qualified welding personnel identified as 041271, 046709. Perform Shielded Metal Arc Welding (SMAW) on Tower Strut. Joint identified as ND1-STSA4-6-123M-2-9B, 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.

This QA Inspector observed ZPMC qualified welding personnel identified as 046709, 041271. Perform Shielded Metal Arc Welding (SMAW) on Tower Strut. Joint identified as ND1-STSA4-6-123M-2-73A, 6B, 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-3212-Tc-U5b-1.

Repair Welding, SMAW Process:

This QA Inspector observed ZPMC qualified welding personnel identified as 202323. Perform Shielded Metal Arc Welding (SMAW) on West Tower lift 4 D/E corner joint. Joint identified as WSTL4-2B/L-61B, ZPMC QC Identified as Mao Mao, with Critical welding repair report CWR-T-CWR606, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-4G (4F) Repair. For more information see below attach photo.

SAW Process:

This QA Inspector observed ZPMC qualified welding personnel identified as 044550. Perform Submerged Arc Welding (SAW) on Angle connection plate. Joint identified as SD1-SA4-56-139M-1, 2, 3, 4-1B, ZPMC CWI Identified as Yu Dong Ping, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-3221-Tc-U5-S-1.

BAY 10:

FCAW Process

This QA Inspector observed ZPMC qualified welding personnel identified as 057180, 052075. Perform Flux Core Arc Welding (FCAW) on Facade channel. Joint identified as ND1-SFSA3-19-3, 4, 7~10, 13~26, 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, WPS-B-T-2133. For more information see below attach photo.

SAW Process:

This QA Inspector observed ZPMC qualified welding personnel identified as 040460. Perform Submerged Arc Welding (SAW) on Facade plate. Joint identified as SD1-SFSA4-29A/B-9, ZPMC QC Identified as Li Peng Fei, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2221-B-L2c-S.

SAW Process:

This QA Inspector observed ZPMC qualified welding personnel identified as 040460. Perform Submerged Arc Welding (SAW) on Facade plate. Joint identified as SD1-SFSA4-32A/B-5, ZPMC QC Identified as Li Peng Fei,

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# WELDING INSPECTION REPORT

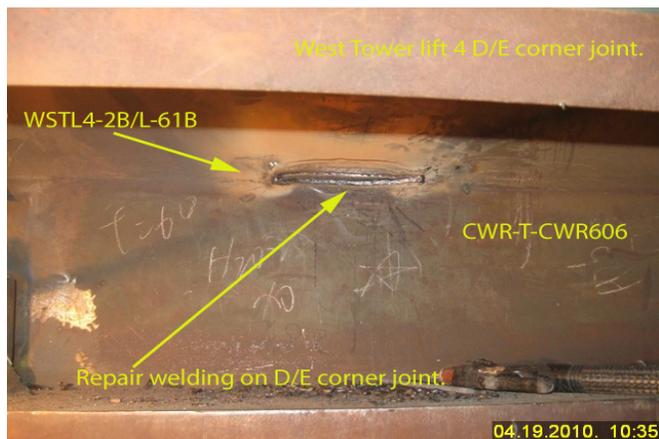
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The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2221-B-L2c-S.

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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**Inspected By:** Gaikwad,Shailesh

Quality Assurance Inspector

**Reviewed By:** Clifford,William

QA Reviewer

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