

**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-013302**Date Inspected:** 07-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:** Yu Dong Ping, Tu Jun**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:

BAY11

**TOWER STRUT ANGLE CONNECTION PLATE**

SMAW welding of weld joint 1B located on WD1-SA4-56-131M-1.

Welder is identified as 040667. ZPMC CWI is identified as Yu Dong Ping.

The welding variables recorded by QC appeared to comply with WPS-B-T-3211-Tc-U5b-1.

**TOWER SKIRT PLATE**

FCAW welding of weld joint 9 located on WD1-A597B/C.

Welder is identified as 040609. ZPMC QC is identified as Mr. Xu Jin Long.

The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

FCAW welding of weld joint 1 located on ED1-A435B/L.

Welder is identified as 040759. ZPMC QC is identified as Mr. Xu Jin Long.

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The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

WEST TOWER LIFT 4, AE CORNER REPAIR (T-CWR611, REV. 0, Y=22500)

SMAW welding of weld joint 60A/B(Repair) located on WSTL4-2B/L.

Welder is identified as 040655. ZPMC QC is identified as Mr. Zhao Mao Mao.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G(2F)-REPAIR.

BAY10

FACADE PLATE

SMAW welding of weld joint 11 located on ED1-SFSA3-117-1.

Welder is identified as 040268. ZPMC QC is identified as Mr. Zhu Zhong Jie.

The welding variables recorded by QC appeared to comply with WPS-B-P-2112.

NORTH TOWER LIFT 4, FIT LUG AT AE CORNER

FCAW welding of weld joint 35 located on NSTL4-3K/L.

Welder is identified as 052075. ZPMC QC is identified as Mr. Li Peng Fei.

The welding variables recorded by QC appeared to comply with WPS-B-T-2333-Tc-P4-F.

FCAW welding of weld joint 33 located on NSTL4-3K/L.

Welder is identified as 052075. ZPMC QC is identified as Mr. Li Peng Fei.

The welding variables recorded by QC appeared to comply with WPS-B-T-4333-Tc-P4-F.

NORTH TOWER LIFT 5, CD CORNERSEAM

SMAW welding of weld joint 37A located on NSD1-TL5-3B-F.

Welder is identified as 052493. ZPMC CWI is identified as Mr. Tu Jun.

The welding variables recorded by QC appeared to comply with WPS-B-T-3212-C-U2.

This QA Inspector witnessed Magnetic Particle Testing (MT) performed by ZPMC NDT personnel on the weld joints of ND1-BPSA5-1-2 of Tower Grillage plate. The attached photographs provide additional detail.

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

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

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