

**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-014747**Date Inspected:** 04-Jun-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:** Zhu 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 # 2B located on Lift-5 Splice Plate Stiffener SSD1 – SPSA5 – 16. Welder is identified as 050289. ZPMC Quality Control (QC) Inspector is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3211 – Tc – U5b – 1.

Weld joint # 1A located on Lift-5 Splice Plate Stiffener SSD1 – SPSA5 – 19. Welder is identified as 052930. ZPMC Quality Control (QC) Inspector is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3211 – Tc – U5b – 1. (See attached photo)

**BAY#11**

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

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Weld joint # 34B located on Lift-5 East tower grillage plate WSD1 – TL5 – 4B/F. Welder is identified as 040619. ZPMC Quality Control (QC) Inspector is identified as Xu Jin Long. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3213 – B – U3b.

Weld joint # 39 located on Tower Strut ED1 – STSA4 – 6 – 139M – 2. Welder is identified as 041271. ZPMC Quality Control (QC) Inspector is identified as Mao Bin Bin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2112. (See attached photo)

Weld joint # 11A located on Lift-5 East tower grillage plate WSD1 – TL5 – 4B/F. Welder is identified as 040619. ZPMC Quality Control (QC) Inspector is identified as Xu Jin Long. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3213 – B – U3b.

Weld joint # 42 located on Tower Strut ED1 – STSA4 – 6 – 139M – 2. Welder is identified as 046709. ZPMC Quality Control (QC) Inspector is identified as Mao Bin Bin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 4113 – 1.

## MEASUREMENTS ON TOWER STRUTS

This QA Inspector carried out the measurements on Tower Struts to check the Bolt hole to edge of the strut distance. Measurements were recorded on the data sheet and submitted to the assigned task leader. The identified component designations reviewed are as follows

### TOWER STRUTS

1. WD1 – A467 – 38M – 1
2. ND1 – A468 – 28M – 2
3. ND1 – A468 – 23M – 1
4. ND1 – A468 – 38M – 2
5. ND1 – A468 – 43M – 1

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



## Summary of Conversations:

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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 Michael Ng - 15921845703, who represents the Office of Structural Materials for your project.

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

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