

**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-015086**Date Inspected:** 20-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

<b>CWI Name:</b>	Zhao Chen Sun, Quiwen Tiny	<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes No N/A	<b>Rod Oven in Use:</b>	Yes	No N/A
<b>Electrode to specification:</b>	Yes No N/A	<b>Weld Procedures Followed:</b>	Yes	No N/A
<b>Qualified Welders:</b>	Yes No N/A	<b>Verified Joint Fit-up:</b>	Yes	No N/A
<b>Approved Drawings:</b>	Yes No N/A	<b>Approved WPS:</b>	Yes	No N/A
		<b>Delayed / Cancelled:</b>	Yes	No N/A
<b>Bridge No:</b>	34-0006	<b>Component:</b>	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:

Tower Assembly Yard

West Tower Lift 2, Doubler Strut Plate at 65M Elevation

SMAW welding of weld joint 20 located on WSD1-SA340C/F.

Welder is identified as 040690. ZPMC QC is identified as Mr. Li Jun.

The welding variables recorded by QC appeared to comply with WPS-B-T-4313-Tc-P4.

East Tower Lift 2, Doubler Strut Plate at 77M Elevation

SMAW welding of weld joint 13 located on ESD1-SA300C/F.

Welder is identified as 040610. ZPMC QC is identified as Mr. Fu Wei Mein.

The welding variables recorded by QC appeared to comply with WPS-B-T-4214-Tc-U4c.

North Tower Lift 2, Doubler Strut Plate at 77M Elevation

SMAW welding of weld joint 17 located on NSD1-SA166C/F.

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Welder is identified as 040365. ZPMC QC is identified as Mr. Fu Wei Mein.

The welding variables recorded by QC appeared to comply with WPS-B-T-4212-Tc-U4c-4.

West Tower Lift 2, 53M Elevation

During random in process inspection this QA Inspector observed that ZPMC personnel performing grinding on the tack weld areas of gusset plate on skin E of West Tower lift 2 at 53M elevation near AE corner. Attached photographs provide additional details.

BAY 10

North Tower Lift 5, Grillage Plate

SMAW welding of weld joint 24B located on NSD1-TL5-3B-F.

Welder is identified as 052930. ZPMC QC is identified as Mr. Li Peng Fei.

The welding variables recorded by QC appeared to comply with WPS-B-T-3213-B-U3b.

SMAW welding of weld joint 41A located on NSD1-TL5-3B-F.

Welder is identified as 052493. ZPMC QC is identified as Mr. Li Peng Fei.

The welding variables recorded by QC appeared to comply with WPS-B-T-3213-B-U3b.

Unless otherwise noted, all work observed on this date appeared to generally comply with 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 Micheal Ng: 159-2184-5703, who represents the Office of Structural Materials for your project.

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**Inspected By:** Gaikwad,Umesh

Quality Assurance Inspector

**Reviewed By:** Clifford,William

QA Reviewer