

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

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-015304**Date Inspected:** 23-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>	Mr. An Qing Xiang/Qiu wen	<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 date Caltrans OSM Quality Assurance (QA) Inspector, Nagalingam Pandaram Pillai was present during the times noted above for observations relative to the work being performed

**IN PROCESS INSPECTION:-****Trail Assembly Area:-**

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: NSD1-SA166C/F-18 located on Doubler strut plate at 77M elevation. Welder is identified as 040365. ZPMC CWI is identified as Mr. Qiu wen. The welding variables recorded by QC appeared to comply with the WPS-B-T-4212-TC-U4c-4. Please see the attached picture.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: WSD1-SA340C/F-17 located on Doubler strut plate at 77M elevation. Welder is identified as 040690. ZPMC CWI is identified as Mr. Qiu wen. The welding variables recorded by QC appeared to comply with the WPS-B-T-4212-TC-U4c-4. Please see the attached picture.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: ESD1-SA300C/F-12 located on Doubler strut plate at 77M elevation. Welder is identified as 040610. ZPMC CWI is identified as Mr. Qiu wen. The welding variables recorded by QC appeared to comply with the WPS-B-T-4212-TC-U4c-4.

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This QA inspector observed the following work in progress:

SMAW welding of weld joint no: NSD1-SA166C/F-14 located on Doubler strut plate at 65M elevation. Welder is identified as 040582. ZPMC CWI is identified as Mr. Qiu wen. The welding variables recorded by QC appeared to comply with the WPS-B-T-3212-B-U2a-2.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: SSD1-SA164C/F-9 located on Doubler strut plate at 65M elevation. Welder is identified as 056364. ZPMC CWI is identified as Mr. Qiu wen. The welding variables recorded by QC appeared to comply with the WPS-B-T-3212-B-U2a-2.

Bay#10:-

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: SSD1-SPSA5-6-1B located on Lift 5 Interior Splice Plate. Welder is identified as 044511. ZPMC QC is identified as Mr. Lee feng fei. The welding variables recorded by QC appeared to comply with the WPS-B-T-3211-TC-U5b-1.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: NSD1-SPSA5-6-4B located on Lift 5 Interior Splice Plate. Welder is identified as 056200. ZPMC QC is identified as Mr. Lee feng fei. The welding variables recorded by QC appeared to comply with the WPS-B-T-3211-TC-U5b-1.

Bay#11:-

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: ESD1-SPSA5-7-1B located on Lift 5 Interior Splice Plate. Welder is identified as 046709. ZPMC QC is identified as Mr. Xu jie. The welding variables recorded by QC appeared to comply with the WPS-B-T-3211-TC-U5b-1. Please see the attached picture.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: WSD1-SPSA5-12-1B located on Lift 5 Interior Splice Plate. Welder is identified as 046704. ZPMC QC is identified as Mr. Xu jie. The welding variables recorded by QC appeared to comply with the WPS-B-T-3211-TC-U5b-1. Please see the attached picture

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: ESD1-SPSA5-12-3B located on Lift 5 Interior Splice Plate. Welder is identified as 040611. ZPMC QC is identified as Mr. Xu jie. The welding variables recorded by QC appeared to comply with the WPS-B-T-3211-TC-U5b-1.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: ESD1-SPSA5-7-1B located on Lift 5 Interior Splice Plate. Welder is identified as 040614. ZPMC QC is identified as Mr. Xu jie. The welding variables recorded by QC appeared to comply with the WPS-B-T-3211-TC-U5b-1.

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



## Summary of Conversations:

No Relevant Conversation.

## 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:** Pillai,Pandaram

Quality Assurance Inspector

**Reviewed By:** Clifford,William

QA Reviewer