

**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-005141**Date Inspected:** 05-Jan-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**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 OSM Quality Assurance (QA) Inspector, Gady Rao, was present during the times noted above for observations relative to the work being performed.

Bay 10

**SAW**

Strut Connection Plate Angle: FCM – Materials:

1) SAW welding of weld joint ND1-SA 183 –33M – 4 - 1B located on ; PCMK P286 to SA 183. Welder is identified as 040460. ZPMC QC is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the B – T – 3221 – TC – U5 - S – 1.

SAW welding of weld joint NSD1-SA 61 G / G -3, 9 & NSD1 - SA 61 A / G – 11,14,16A,10A, 13A, 17A located on; SKIN-E; LIFT-2; PCMK P 129 to P 35 to P486. Welder is identified as 201750 / 207745. ZPMC QC is identified as Chen Shou Hau. The welding variables recorded by QC appeared to comply with the B-T -2221-B-U3C-S- 2 & B - T - 2321 - B - P3 - S - 2.

**FCAW**

Doubler Plate Welding: FCM Material:

1) FCAW welding of weld joint NSD1-SA 159 B / J –2, 6, 15, 20 & NSD1-SA 33 A / F – 11 located on SKIN - A; LIFT – 1. Welders are identified as 053869 / 040533 / 052075 / 054069 / 040338 / 057180 / 040343 / 050041 066251 / 053474. ZPMC QC is identified as Zhang Hueng / Lin Yang. The welding variables recorded by QC appeared to comply with the B-T-4332- TC –P4-F.

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## SMAW

Strut Connection Plate Angle: FCM – Materials:

SMAW welding of weld joint ND1-SA 183 - 43M -4 – 1A, SA 183 -43M - 1 – 1A, located on; PCMK P286 to SA183; Welder is identified as 057286 / 056134. ZPMC QC is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the B – T – 3211 – TC – U5B - 1.

## BAY 11

## SAW

FCM – Materials:

1)SAW welding of weld joint WD1-SA 468 – 43M – 1 – 7B; 43M - 1 – 8B, 43M - 1 – 12B, ND1 – SA476 - 47. 6M – 1 – 7A, 47.6M – 1 – 8B, 53M – 1 – 8B, located on PCMK P234 to P12. Welder is identified as 042195 . ZPMC QC is identified as Zhu Zhang Hai. The welding variables recorded by QC appeared to comply with the B-T -4221-B-U3C-S-2.

## NON - FCM

2) SAW welding of weld joint WSD1-SA 298 G / G – 2 & SA 298 A / G 6B, 8, 9B, located on; SKIN – E; LIFT – 2. Welder is identified as 047304 / 040741. ZPMC QC is identified as Zhang Zhi Neng. The welding variables recorded by QC appeared to comply with the B-T -2221-B-U3C-S-2 & B – T – 2321 – B – P3 – S – 2.

## FCAW

1)FCAW welding of weld joint WSD1-SA 294 A / G – 19,20 located on SKIN-C; LIFT-1; Welder is identified as 040736 / 066401. ZPMC QC is identified as Zhang Zhi Neng.. The welding variables recorded by QC appeared to comply with the B-T-2332-TC-P5-F.

2) FCAW welding of weld joint WSD1-SA 97 – 2A, 4A located on SKIN-A; PCMK P 686 to SA 97; Welder is identified as 067079 / 067949. ZPMC QC is identified as Zhang Zhi Neng.. The welding variables recorded by QC appeared to comply with the B-T-2231-TC-U5-F.

3)FCAW welding of weld joint WSD1-SA 294 A / G – 13, 14, 19, 20, 23, 24 located on SKIN-C; LIFT-1; Welder is identified as 068929 / 066401/ 068206 / 068916 / 066168 / 066165 . ZPMC QC is identified as Chen Shou Hua. The welding variables recorded by QC appeared to comply with the B-T-2332-TC-P5-F.

4)FCAW welding of weld joint WSD1-SA 77 A / E – 54, 55, 57, 58 located on SKIN-C; LIFT-1; Welder is identified as 066825 / 066687 / 066477 / 066163. ZPMC QC is identified as Huang Li. The welding variables recorded by QC appeared to comply with the B-T-2332-TC-P5-F.

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

### **Summary of Conversations:**

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 Serge Sinevod 134-8257-0045., who represents the Office of Structural Materials for your project.

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