

**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-005145**Date Inspected:** 11-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:** Zhao Chen Sun**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 the date CALTRANS OSM Quality Assurance (QA) Inspector, Dilip Chakrabarti was present during the times noted above for observations relative to the work being performed.

Bay# 6-Tower Assembly

This QA Inspector randomly observed the following work in progress:

**SMAW Process:**

Welding of weld joint BB3 located on PCMK NSD 1-SA 104. Welder is identified as 048880. ZPMC QC is identified as Sun Zi Wang. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3312-TC-P5

Welding of weld joint BB-4 located on PCMK NSD 1-SA 104. Welder is identified as 048659. ZPMC QC is identified as Sun Zi Wang. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3312-TC-P5

Welding of weld joint BB-1 located on PCMK WSD 1-SA 424. Welder is identified as 066028. ZPMC QC is identified as Liu Zhi. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3312-TC-P5

Welding of weld joint BB-2 located on PCMK WSD 1-SA 424. Welder is identified as 066481. ZPMC QC is identified as Liu Zhi. The welding variables recorded by QC appeared to comply with the specified WPS no.

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# WELDING INSPECTION REPORT

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B-T-3312-TC-P5

FCAW Process:

Welding of weld joint 7-8 located on PCMK SSD1 DP SA3 . Welder is identified as 054460. ZPMC QC is identified as Liu Zhi. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2132-2.

Welding of weld joint 11-8 located on PCMK ESD1 DP SA3. Welder is identified as 053609. ZPMC QC is identified as Liu Zhi. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2132-2.

Welding of weld joint 15-8 located on PCMK ESD1 DP SA3 . Welder is identified as 202842. ZPMC QC is identified as Liu Zhi. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2132-2.

OBG Assembly  
For Green Tag

Sl #	Section#	Weld#	Green Tag#	Location
1.	SP 731-001	013,014,015,016,	003983	9CW
2.	SP 585-001	013,014,015,016	003984	9CE
3.	SP 626-001	012	003989	9DE
4.	SP 493-001	015,016,017,018	003988	9CW

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

**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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**Inspected By:** Chakrabarti,Dilip Kumar Quality Assurance Inspector

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**Reviewed By:** Clifford,William QA Reviewer

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