

**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-005230**Date Inspected:** 18-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:** Liu Yang / Xu Le Feng.  
**Inspected CWI report:** Yes No N/A  
**Electrode to specification:** Yes No N/A  
**Qualified Welders:** Yes No N/A  
**Approved Drawings:** Yes No N/A

**CWI Present:** Yes No  
**Rod Oven in Use:** Yes No N/A  
**Weld Procedures Followed:** Yes No N/A  
**Verified Joint Fit-up:** 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 - FCM – Materials:

SAW welding of weld joint ND1- A 467 – 33M – 4 – 10A, A 467 – 33M – 3 – 9B, A 467 – 38M – 3 – 10A, A467 – 38M – 4 – 9B, A467 – 38M – 4 – 10A, located on PCMK P 859 – 1A to P 202 - 1. Welder is identified as 201750. ZPMC QC is identified as Wu Ming Kia / Liu Yang. The welding variables recorded by QC appeared to comply with the B – T – 4221 – B – U3C - S – 1.

NON - FCM

1) SAW welding of weld joint NSD1-SA 223 A / E -2B, located on; SKIN-D; LIFT-2. Welder is identified as 040489. ZPMC QC is identified as Liu Liang / Liu Yang. The welding variables recorded by QC appeared to comply with the B-T -2221-B-U3C-S- 2.

2) SAW welding of weld joint NSD1-SA 171 C / D -26A, 47A located on SKIN-C; LIFT-2. Welder is identified as 052917. ZPMC QC is identified as Liu Liang / Liu Yang. The welding variables recorded by QC appeared to comply with the B-T -2221-B-U3C-S- 2.

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## FCAW

1) FCAW welding of welds joint NSD1-SA 109 – 2A, located on PCMK SA 109 to P709. Welder is identified as 048378. ZPMC QC is identified as Jin Dong Liang / Liu Yang. The welding variables recorded by QC appeared to comply with the B-T-2231-TC-U5-F.

2) FCAW welding of welds joint NSD1-SA 166 D / F 21, 22 located on SKIN – A, Lift - 2. Welder is identified as 066399 / 067499. ZPMC QC is identified as Jin Dong Liang / Liu Liang / Liu Yang. The welding variables recorded by QC appeared to comply with the B-T-2332-TC-P5-F.

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### SAW - FCM – Materials:

1)SAW welding of weld joint WD1- A 467 –38M – 2 – 10B, A 467 – 38M – 1 – 10B, A 467 – 33M – 2 – 10B, A 467 – 38M – 1 – 9A, located on; PCMK A 859 – 1A to P 202. Welder is identified as 042195. ZPMC QC is identified as Yu Dong Ping / Xu Li Feng. The welding variables recorded by QC appeared to comply with the B – T – 4221 – B – U3C -S – 1.

2)SAW welding of weld joint WD1- A 467 –23M – 1 – 11B, A 467 – 18M – 2 – 11B, A 467 – 18M – 1 – 11B, located on; PCMK A 467 – 1A to P 1107 – 1A. Welder is identified as 040634. ZPMC QC is identified as Yu Dong Ping / Xu Li Feng. The welding variables recorded by QC appeared to comply with the B – T – 4221 – B – U3C - S – 1.

## FCAW

1) FCAW welding of welds joint WSD1-SA 279 – 36,38,40,42,44,46,48,50 located on PCMK ; SKIN – B, LIFT - 1. Welder is identified as 068918 / 066825 / 066360 / 067037. ZPMC QC is identified as Xiao Yun. The welding variables recorded by QC appeared to comply with the B-T-2332-TC-P5-F.

2) FCAW welding of welds joint WSD1-SA 274 – 67, 72, 74, 76 located on PCMK ; SKIN – C, LIFT - 1. Welder is identified as 068919 / 066695. ZPMC QC is identified as Li Hong Fei / Xu Le Feng. 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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