

**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-005322**Date Inspected:** 22-Jan-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Yang**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, Luis Hutchins, was present during the times noted above for observations relative to the work being performed.

**Inprogress welding:**

FCAW welding of welds joint NSD1-SA 17 F / G 82,81,76,75,70,69,64,36,35,39,40,63,58,57,52,51,46, and 45 located on SKIN – C, Lift - 1.

Welder is identified as 066751 / 067499 / 068918 / 068864 / 066165 / 070046. ZPMC QC is identified as Liu Yang. The welding variables recorded by QC appeared to comply with the B-T-2332-TC-P5-F.

**Magnetic Particle Testing:**

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6028 report for this date. The member(s) & the weld designations reviewed are as follows:

NSD1 – SA welds for the North Tower stiffener to bottom plate. MT Completed.

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

**Summary of Conversations:**

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No significant conversations held during the course of inspection.

## **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>	Hutchins,Luis	Quality Assurance Inspector
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<b>Reviewed By:</b>	Clifford,William	QA Reviewer
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