

**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-005332**Date Inspected:** 23-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**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

SAW welding of weld joint NSD1- A 163 A / D – 2A, located on PCMK SKIN – B ; L IFT - 2. Welder is identified as 207745. ZPMC QC is identified as Zhu Feng / Liu Yang. The welding variables recorded by QC appeared to comply with the B – T – 2221 – B – U3C - S – 2.

FCAW

1) FCAW welding of welds joint NSD1-SA 166 E / F 31B & SA 166 D / F - 25B, 29B located on SKIN – A, Lift - 2. Welder is identified as 067752 / 067275 / 067138. ZPMC QC is identified as Tu Jun / 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 17 F / G 39, 40, 51, 52, 63, 64, 75, 76 located on SKIN – C, Lift - 1. Welder is identified as 037944 / 066251 / 070046 / 066165 / 068918 / 066751 / 066481 / 068864. ZPMC QC is identified as Tu Jun / Liu Yang. The welding variables recorded by QC appeared to comply with the B – T – 2231 – TC – U5 - F.

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# WELDING INSPECTION REPORT

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BAY 11

SAW -FCM – Materials:

1)SAW welding of weld joint WD1- A 467 –18M – 1 – 9A, A 467 – 18M – 2 – 9A, A 467 – 23M – 1 – 9A, A 467 – 18M – 2 – 10B, A 467 –18M – 1 – 10B 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 ND1- A 468 –23M – 1 – 2B, A 468 – 28M – 1 – 2B, A 468 – 18M – 1 – 2B, located on; PCMK A 468 to P 50. Welder is identified as 041716. 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.

3)SAW welding of weld joint ND1- A 468 –23M – 1 – 4B, A 468 – 28M – 1 – 4B, A 468 – 18M – 1 – 4B, located on; PCMK A 468 to P 50. Welder is identified as 041716. 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

FCAW welding of welds joint WSD1-SA 340 E / F 1B, 3, 4B, 9B, 33B located on SKIN – A, Lift - 2. Welder is identified as 066279 / 068852 / 062782. ZPMC QC is identified as Peng Guo / Xu Le Feng. The welding variables recorded by QC appeared to comply with the B-T-2231- TC – U5 – F & B – T – 2331 – 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
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

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