

**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-005521**Date Inspected:** 28-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:** 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.

**Magnetic Particle Testing:****Bay 10**

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

NSD1 – SA 22 A / E – 5 to 12, 18 to 25, SA 180 C / E -17 to 20, SA 180 D / E 15 to 18 NORTH TOWER; SKIN-D; LIFT-1; Stiffener to Bottom plate. Green tag number 2564 Completed.

NSD1 – SA 171 A / D 3 A / B NORTH TOWER; SKIN-C; LIFT-2; MT completed.

NSD1 – SA 171 C / D 25 A / B, 26A / B, 47A / B, 48A / B NORTH TOWER; SKIN-C; LIFT-2; MT completed.

**BAY 11****SAW - FCM – Materials:**

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## WELDING INSPECTION REPORT

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1)SAW welding of weld joint WD1- A 467 -33M - 2 - 23A, A 467 - 38M - 1 - 24A, A 467 - 38M - 2 - 24A, A 467 - 38M - 1 - 23A, A 467 -38M - 2 - 23A located on; PCMK A 859 to P 202. Welder is identified as 042195. ZPMC QC is identified as Xu Le 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 -18M - 1 - 2A, A 468 - 18M - 1 - 7A, A 468 - 23M - 1 - 12A, A 468 - 23M - 1 - 7A, A 468 - 28M - 1 - 12A located on; PCMK P 234 to P 12. Welder is identified as 040634. ZPMC QC is identified as Xu Le 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 Xu Li Feng. The welding variables recorded by QC appeared to comply with the B - T - 4221 - B - U3C - S - 1.

4)SAW welding of weld joint ND1- A 476 -47.6M - 1 - 4B, A 476 - 53M - 1 - 4B, A 476 - 65M - 1 - 4B, located on; PCMK A 476 to P 50. Welder is identified as 042195. ZPMC QC is identified as Xu Li Feng. The welding variables recorded by QC appeared to comply with the B - T - 4221 - B - U3C - S - 1.

NON - FCM

3) SAW welding of weld joint WSD1-SA 384 - A / D -14A located on; SKIN -B LIFT-2. Welder is identified as 056975. ZPMC QC is identified as An Qing Xiang / Xu Le Feng. The welding variables recorded by QC appeared to comply with the B - T - 2221 - B - U3C - S - 2.

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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**Inspected By:** Rao,Gady

Quality Assurance Inspector

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# WELDING INSPECTION REPORT

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**Reviewed By:** Clifford, William

QA Reviewer