

**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-005613**Date Inspected:** 26-Feb-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**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**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector Larry Viars was present during the times noted above for observations relative to the work being performed.

**Bay 11-**

This QA inspector performed Ultrasonic Testing (UT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as lift 1 east tower skin A and B longitudinal stiffener welds. The weld identification numbers are as follows, ESD1-SA49 A/D- 024, 025, ESD1-SA107F/J -015, 018, 022, 025, ESD1-SA107-014, 017, 020, ESD1-E/J-014, 017, 020 and ESD1-SA107D/J-014, 018, 022.

This QA inspector performed Magnetic Particle Testing (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 members are identified as lift 1 east tower skin A and B longitudinal stiffener welds. The weld identification numbers are as follows, ESD1-SA107 D/J- 012, 013, 016, 017, 019, 020, ESD1-SA237 A/F- 018, 019, ESD1-SA107-012, 013, 016, 017, 019, 020, ESD1-SA107 E/J 012, 013, 016, 017, 019, ESD1-SA233- A/F 006, 007, 008, 009, 010, 011, 012, 013, ESD1-SA49-032, 033, 034, 035, 036, 037, 038, 039, and ESD1-SA107 F/J 012, 013, 016, 017, 019, 020.

This QA inspector signed green tag # 4088 for Skin A and 4089 for skin B longitudinal stiffeners along with ZPMC and ABF QC after verification of visual and non destructive testing by all three parties.

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# WELDING INSPECTION REPORT

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**Summary of Conversations:**

As identified within the contents of this report.

**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>	Viars,Larry	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer

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