

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

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-006285**Date Inspected:** 18-Apr-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:** Li Zhi jiang**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:** OBG & Tower Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Hiranch Patel, was present during the times noted above for observations relative to the work being performed.

**Bay #6**

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member is identified as Tower Components. The weld designations reviewed are as follows:

-(WSD1-DPSA4-15-1A(B)~ 8A(B))

-(NSD1-DPSA4-15-1A(B)~ 8A(B))

**Bay #2**

This QA inspector witness Magnetic Particle Testing performed by ZPMC QC, as below. The member is identified as OBG Components. The weld designations reviewed are as follows:

-(FB012-023)

-(FB010-028)

-(FB010-025)

-(FB009-022)

**Bay #2**

This QA inspector observed the following work in progress:

FCAW welding of weld joint Segment 1AW, SSD36-PP9.5-366 located on Segment 1AW. Welder is identified as 058245 (3G). ZPMC QC is identified as Wang Jie. The welding variables recorded by QC appeared to comply

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## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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with the Applicable WPS.

FCAW welding of weld joint Segment 1AW, SSD36A-PP9.5-247 located on Segment 1AW. Welder is identified as 062708 (3G). ZPMC QC is identified as Wang Jie. The welding variables recorded by QC appeared to comply with the Applicable WPS.

SMAW welding of weld joint Segment 1AW, SSD36A-PP9.5-273 located on Segment 1AW. Welder is identified as 066413 (3G). ZPMC QC is identified as Wang Jie. The welding variables recorded by QC appeared to comply with the Applicable WPS.

SMAW welding of weld joint Segment 1AW, CSD7-PP9.5-152 located on Segment 1AW. Welder is identified as 050433 (3G). ZPMC QC is identified as Wang Jie. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Bay #3

This QA inspector observed the following work in progress:

FCAW welding of weld joint FB016-032-045 located on FB016-032. Welder is identified as 044830 (3G). ZPMC QC is identified as Wang Jie. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Unless otherwise noted, all 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 Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Patel, Hiranch	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford, William	QA Reviewer

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