

**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-006309**Date Inspected:** 22-Mar-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:** Yu Dongping / Li Hongfei**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, the Caltrans OSM Quality Assurance (QA) Inspector, "Victor" KS Narayan was present during the times noted above for observations relative to work performed.

Bay 11 – TOWER ASSEMBLY:

I. Lift 3 – Skin Plates' butt welding:

Weld process, SAW of butt weld joints located on PCMK: Lift 3-East Tower Skin "C/E" plate butt welds. The weld designation numbers and the welder was identified as follows.

ESD1-FCSA3-2B/C-8B-2 (CJP): The welder was identified as Li Xiaoqing and the welder number was identified as 044560.

ESD1-FCSA3-2B/C-26B-1, 26B-2 (CJP) & 31, 22 (PJP): The welder was identified as Qin Xiulan and the welder number was identified as 044550.

ESD1-FCSA3-2B/C-37 (PJP) & 34B (CJP): The welder was identified as Xia Wenying and the welder number was identified as 044558.

ESD1-FCSA3-2B/C-14 (PJP) & 17B (CJP): The welder was identified as Wu Aixiang and the welder number was identified as 040772.

ESD1-FESA3-2B/D-8A (CJP): The welder was identified as Yang Meizhan and the welder number was identified as 42195.

ESD1-FCSA3-2B/C-64A (CJP): The welder was identified as Cao Xiaohua and the welder number was identified as 056975.

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ESD1-FCSA3-2B/C-62A (CJP): The welder was identified as Zou Xiaohua and the welder number was identified as 207463.

The ZPMC CWIs were identified as Li Hongfei & Yu Dongping and the ABF representatives were identified as Zhang Jicai & Wang Chenjun. The welding variables recorded by QC appeared to comply with applicable WPS, WPS-B-T-2221-B-P3-S-Z for PJP weld joints & WPS-B-T-2221-B-U3C-S-Z for CJP weld joints.

### ULTRASONIC TESTING:

#### Bay 10 - Tower Assembly:

This QA Inspector performed 10% UT of area previously tested by ZPMC UT personnel. This QA Inspector generated a TL-6027 UT report on this date. The member was identified as Lift 1 – North / South Tower Shear Link plate “T” joints.

The weld designation numbers are as follows.

ND1-SA183-33M-2-1A/B  
SD1-SA183-38M-4-1A/B  
SD1-SA183-47.6M-2-1A/B

### MAGNETIC PARTICLE TESTING:

#### Bay 11 - Tower Assembly:

This QA Inspector performed 100 % VT (Visual Inspection) & 15% MT of area previously tested by ZPMC MT personnel. This QA Inspector generated a TL-6028 MT report on this date.

The members were identified as Lift 3 – West Tower Skin “D” plate CJP / PJP weld joints.

The weld designation numbers are as follows.

WSD1-FDSA3-2 G/C-1(2) - PJP  
WSD1-FDSA3-3A-1 - CJP  
WSD1-FDSA3-2 A/C-5A-2 – CJP

The members were identified as Lift 3 – East Tower Skin “E” plate CJP / PJP weld joints.

The weld designation numbers are as follows.

ESD1-FESA3-2A/D-21B, 17B-1, 17B-2, 12B, B8-2 (CJP weld joints)  
ESD1-FESA3-2A/D-24, 23, 20, 19, 15, 14, 11 (PJP weld joints)

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

### Summary of Conversations:

No relevant conversations.

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.

### Comments

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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 (134-825-70045), who represents the Office of Structural Materials for your project.

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

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