

**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-007502**Date Inspected:** 23-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Xing Xin**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-FDSA4-3A/C-12B, 13B located on North Tower; Skin-D; Lift-4. Welder is identified as 207745. ZPMC QCI-CWI is identified as Chen Ying Xin. The welding variables recorded by QC appeared to comply with the WPS- B-T-4221-B-U3C-S-3.

SMAW

SMAW welding of welds joint SSD1-FASA4-1E/E-99A located on South Tower; Skin-a; Lift-4. Welder is identified as 052930. ZPMC QCI is identified as Wang Chuan Quing. The welding variables recorded by QC appeared to comply with the WPS- B-T-3211-TC-U5b-1.

FCAW

FCAW welding of weld joint SSSL3-1F/K-67, 68 located on South Tower; Lift-3. Welder is identified as 053116/057244. ZPMC QCI-CWI is identified as Chen Ying Xin. The welding variables recorded by QC appeared

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# WELDING INSPECTION REPORT

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to comply with the WPS- B-T-2332-TC-P5-F.

Bay 11

SAW

Strut Connection Plates:

1)SAW welding of weld joint SD1-A6002-6-2B, A6002-6-4A, A6002-6-4B, A6002-7-2B, and A6002-8-2B. Welder is identified as 041716. ZPMC QCI-CWI is identified as Zhan Bo. The welding variables recorded by QC appeared to comply with the WPS- B-T-4221-B-U3C-S-1.

2)SAW welding of weld joint WSD1-FESA4-4A/F-8(B-2), 11, 12B, 15, 17B, 20, 22B. Welder is identified as 202756/044558/040634. ZPMC QCI-CWI is identified as Zhan Bo. The welding variables recorded by QC appeared to comply with the WPS- B-T-2221-B-U3C-S-2 & B-T-2221-B-P3-S-2.

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
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<b>Reviewed By:</b>	Clifford,William	QA Reviewer
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