

**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-007557**Date Inspected:** 29-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:** 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.

Bay 06

SMAW

SMAW welding of weld joint WSD1-DPSA4-12B/B-12, 13. Welder is identified as 068924/066268. ZPMC QCI-CWI is identified as Zou Liu Hai. The welding variables recorded by QC appeared to comply with the WPS-B-T-3312-TC-P5.

Bay 10

SAW

1) SAW welding of weld joint NSD1-FBSA4-1A/C-16A located on North Tower; Lift-4; Skin-B; skin to skin welds. Welder is identified as 201750. ZPMC QCI-CWI is identified as Wang Hao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-B-U3C-S-2.

FCAW- North Shaft; Lift-1

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1)FCAW welding of weld joint NSD1-A166H/J-85 located on North Shaft; Lift-1. Welders identified as 052930. ZPMC QCI-CWI is identified as Chen Ying Xin. The welding variables recorded by QC appeared to comply with the WPS-B-T-3213-B-U2a-1.

2)FCAW welding of weld joint NSD1-A166C/J-226 located on North Shaft; Lift-1. Welders identified as 056200. ZPMC QCI-CWI is identified as Chen Ying Xin. The welding variables recorded by QC appeared to comply with the WPS-B-T-3213-B-U2a-1.

3)FCAW welding of welds joint SSD1-FESA4-1F/F-2, 3 located on South Tower; Lift-4; Skin-E, Skin to stiffener welds. Welders identified as 050041/203977. ZPMC QCI-CWI is identified as Li Ming. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P5-F.

4)FCAW welding of welds joint NSD1-FESA4-3F/F-61A located on North Tower; Lift-4; Skin-E; stiffener to stiffener welds. Welders identified as 052075. ZPMC QCI-CWI is identified as Shi Jing Wei. The welding variables recorded by QC appeared to comply with the WPS-B-T-4231-B-U3-F.

Bay 11

SAW

SAW welding of weld joint WSD1-FASA4-2A/E-2B located on West Tower; Lift-4; Skin-A; Skin to Skin welds. Welder is identified as 040634. ZPMC QCI-CWI is identified as Cao Cheng. The welding variables recorded by QC appeared to comply with the WPS- B-T-2221-B-U3C-S-2.

FCAW

1)FCAW welding of weld joint ESD1-FASA4-2E/E-80A, 70A; 10A, located on East Tower; Lift-4; Skin-A. Welder is identified as 053316/040713/040775. ZPMC QCI-CWI is identified as Liu Xiao Zhong. The welding variables recorded by QC appeared to comply with the WPS- B-T-2231-TC-U5-F.

2)FCAW welding of weld joint ESD1-FDSA4-2D/D-2, 3, 5, 6 located on East Tower; Lift-4; Skin-D; Skin to stiffener welds. Welder is identified as 070212/066484/069043. ZPMC QCI-CWI is identified as Zhan Bo. The welding variables recorded by QC appeared to comply with the WPS- B-T-2332-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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<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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