

**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-007569**Date Inspected:** 02-Jul-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:** Wan Wen Zhong**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 02

SEG 1AAE

ZPMC had three welders that completed the A side of weld SEG2-001 (outer) which is located at the bottom corner of the south side of 1AAE and ZPMC started to air arc the back side of this weld.

One welder is using FCAW on stiffener welds SEG2F-026, SEG2D-088 and SDG2E-334 of 1AAE.

SEG 1AAW

One welder completed a SMAW weld repair of the upper section of weld SEG1D-001 which is the north east corner of 1AAW.

ZPMC has one person completing FCAW welds SEGIF-022, SEGIC-001, SEG1E-214, 333. Weldner identified as stencil number 045175; ZPMC-CWI identified as Chen Xi. These welds are for a strand stiffener.

ZPMC is fitting up and grinding a strand stiffener on the east end of 1AAW.

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Bay 10

SAW

1)SAW welding of weld joint NSD1-FCSA4-1A/C-53A, 54A, 55A located on North Tower; Lift-4; Skin-C; skin to skin welds. Welder is identified as 050295. ZPMC QCI is identified as Shi Jing Wei. The welding variables recorded by QC appeared to comply with the WPS- B-T-2221-B-U3C-S-2.

2)SAW welding of weld joint NSD1-FBSA4-1A/C-51A located on North Tower; Lift-4; Skin-B; stiffener to stiffener in welds. Welder is identified as 051413. ZPMC QCI 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

1)FCAW welding of weld joint NSD1-SPSA3-62-2A located on North Tower. Welder is identified as 040345. ZPMC QCI is identified as Wan Wen Zhong. The welding variables recorded by QC appeared to comply with the WPS- B-T-2231-TC-U5-F.

North Tower–Lift-2

2)FCAW welding of weld joint NSD1-TL8E/L-127 located on North Tower; Lift-2. Welder is identified as 203977. ZPMC QCI is identified as Wan Wen Zhong. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P4-F.

3)FCAW welding of weld joint NSD1-TL8C/L-89 located on North Tower; Lift-2. Welder is identified as 050041. ZPMC QCI is identified as Wan Wen Zhong. The welding variables recorded by QC appeared to comply with the WPS- B-T-4332-TC-P4-F.

4)FCAW welding of weld joint NSTL3-3I/K-105, 107 located on North Tower; Lift-3. Welder is identified as 054069. ZPMC QCI is identified as Li Ming. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

Bay 11

FCAW

1)FCAW welding of weld joint ESD1-FDSA4-2D/D-16,17 located on East Tower; Lift-4; Skin-D. Welder is identified as 066484/070212. ZPMC QCI-CWI is identified as Zhan Zhi Neng. 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.

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# WELDING INSPECTION REPORT

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## 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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