

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
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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-007684**Date Inspected:** 04-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.

**Magnetic Particle Testing:**

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) & the weld designations reviewed are as follows:

**Bay 2**

Inspection part	Section	Inspection Area.
SEG1D-086		
SEG1F-005	OBG	Bay-2
SEG1E-334		
SEG1E-124		
SEG1F-002		
SEG1D-004		

**Bay 02**

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# WELDING INSPECTION REPORT

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## SEG 1AAE

ZPMC has one welders are using FCAW on stiffener welds SEG2F-025 of IAAW. Welder's identified as 207465. ZPMC QCI-CWI identified as Li Zhi Jiang. The welding variables recorded by QC appeared to comply with the WPS- B-T-2233-TC-U4C-F.

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## Bay 06

### SMAW

1)SMAW welding of weld joint NSD1-DPSA4-14B/B-12, 13. Welder is identified as 068924/068691. 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.

2)SMAW welding of weld joint NSD1-DPSA4-14B/B-16, 17. Welder is identified as 037932/066268. 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

### FCAW

1)FCAW welding of weld joint SSD1-1J/K -31, 32 located on South 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-2133.

2)FCAW welding of weld joint NSD1-FCSA4-1C/C -21B located on North Tower; Lift-4; Skin-C. Welder is identified as 052075. ZPMC QCI is identified as Li Ming. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-B-U3-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

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## WELDING INSPECTION REPORT

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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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