

**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-007685**Date Inspected:** 05-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.
MT of Base Material Of holes on A00 / A41	OBG	Bay-2

**Bay 02****SEG 1AAW**

ZPMC has two welders are using FCAW on stiffener welds SEG1F-024 & SEG 1E-046 of IAAW. Welder's identified as 045209/06208. ZPMC QCI-CWI identified as Li Zhi Jiang/Chen xi. The welding variables recorded

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## WELDING INSPECTION REPORT

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by QC appeared to comply with the WPS- B-T-2233-TC-U4C-F.

Bay 10

SAW

SAW welding of weld joint NSD1-FDSA4-3A/C-6B located on North Tower; Lift-4; Skin-D; skin to skin welds. Welder is identified as 042197. ZPMC QCI is identified as Wan Wen Zhong. The welding variables recorded by QC appeared to comply with the WPS- B-T-2221-B-U3C-S-2.

FCAW

FCAW welding of weld joint SSD1-1J/K -31, 32 located on South Tower; Lift-3. Welder is identified as 050041. ZPMC QCI is identified as Li Ming. The welding variables recorded by QC appeared to comply with the WPS-B-T-4333-TC-S-3.

Bay 11

SAW

SAW welding of weld joint WD1-FESA4-4A/F-21A, 23A located on West Tower; Lift-4; Skin-E. Welder is identified as 042195. ZPMC QCI is identified as Zhan Zhi Neng. The welding variables recorded by QC appeared to comply with the WPS- B-T-4221-B-U3C-S-3.

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

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