

**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-007889**Date Inspected:** 12-Jul-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	Xu Xian Ping		
<b>Inspected CWI report:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A

<b>CWI Present:</b>	Yes	No	
<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved WPS:</b>	Yes	No	N/A
<b>Delayed / Cancelled:</b>	Yes	No	N/A

**Bridge No:** 34-0006**Component:** OBG and TOWER Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Sandeep Kumar was present during the times noted above for observations relative to the work being performed.

**BAY 1**

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint # 002 located on Cross Beam CB201A-007. Welder is identified as 054460. ZPMC QC is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U4b – F.

**BAY 2****Ultrasonic Testing**

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member is identified as OBG Component. The weld designations reviewed are as follows:

1. FB023 – 008 – 148
2. FB023 – 009 – 148
3. FB012 – 033 – 043
4. FB020 – 006 – 146; 148

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5. FB028 – 010 – 148

6. FB016 – 039 – 045

## BAY 3

### 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 members are identified as OBG Components. The weld designations reviewed are as follows:

1. FB020 – 008 – 127; 077; 114; 107; 087; 137; 145; 132; 072; 148

### Green Tags

The following green tags issued for OBG components after completing the NDT requirements are:

1. SSD13/13A – PP095 / FB003 – 201 / FB006 – 179 / FB004 – 044 – Green Tag # 009647

2. SSD19/19A – PP095 / FB003 – 199 / FB006 – 186 / FB013 – 044 – Green Tag # 009646

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #039 located on Floor Beam FB023 – 010. Welder is identified as 208035. ZPMC QC is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

FCAW process welding of weld joint #126 located on Floor Beam FB020 – 009. Welder is identified as 044790. ZPMC QC is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – Tc – U4b – F.

## BAY 5

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #005 located on Traveler Rail TR6C– PP52. Welder is identified as 205390. ZPMC QC is identified as Xu Hong Min. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – Tc – U4c – F.

FCAW process welding of weld joint #005 located on Traveler Rail TR6A– PP52. Welder is identified as 205390. ZPMC QC is identified as Xu Hong Min. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – Tc – U4c – F.

FCAW process welding of weld joint #003 located on Traveler Rail TR1B– PP49. Welder is identified as 205390. ZPMC QC is identified as Xu Hong Min. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – Tc – U4c – F.

## BAY 6

This QA Inspector observed the following work in progress:

SMAW process welding of weld joint #10B located on WD1 – A305 – 53M – 1. Welder is identified as 066459.

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ZPMC QC is identified as Zhao Chen Sun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2212 – Tc – U5b – 1.

SAW process welding of weld joint #11 – 1A located on ND1 – SA658 – 53M. Welder is identified as 054458. ZPMC QC is identified as Zhao Chen Sun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3221 – TC – U5 – S – 1.

SMAW process welding of weld joint #52 located on WD1 – A305 – 53M – 2. Welder is identified as 066456. ZPMC QC is identified as Zhao Chen Sun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2112.

SMAW process welding of weld joint #2A located on WD1 – A305 – 53M – 1. Welder is identified as 068918. ZPMC QC is identified as Zhao Chen Sun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2212 – Tc – U5b – 1.

SMAW process welding of weld joint #49 located on WD1 – A305 – 53M – 2. Welder is identified as 066459. ZPMC QC is identified as Zhao Chen Sun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2112.

SMAW process welding of weld joint #8B located on WD1 – A305 – 53M – 1. Welder is identified as 069894. ZPMC QC is identified as Zhao Chen Sun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2212 – Tc – U5b – 1.

SMAW process welding of weld joint #53 located on WD1 – A305 – 53M – 2. Welder is identified as 068918. ZPMC QC is identified as Zhao Chen Sun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2112.

### BAY 7

This QA Inspector observed the following work in progress:

FCAW process of weld joint #003 located on Side Plate SP3022 – 001. Welder is identified as 058174. ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – B – P – T – 2231 – B – U2 – F.

FCAW process of weld joint #066 located on Side Plate SP3022 – 001. Welder is identified as 058174. ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – B – P – T – 2233 – B – U2 – F.

### BAY 11

#### 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 members are identified as Tower Components. The weld designations reviewed are as follows:

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1. WSD1 – TL6 E/L – 067
2. WSD1 – TL6 F/L – 158

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 Eric Tsang - 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Kumar,Sandeep	Quality Assurance Inspector
<b>Reviewed By:</b>	Prue,Erik	QA Reviewer

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