

**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-007941**Date Inspected:** 20-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**CWI Name:** XU XIAN PING**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:** OBG and Tower COMPONENT**Summary of Items Observed:**

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

In process Inspection

BAY #6

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 2F position of the Tower Strut assembly weld No.

WD1-A305-65M-2-52&amp;53 . Welder is identified as # 066481. The welding variables recorded by QC appear to comply with WPS- B – T-2112.

Shielded Metal Arc Welding (SMAW) in the 3F position of the Tower Strut assembly weld No. WD1

WD1-A305-77M-3-23&amp;27 . Welder is identified as # 066268. The welding variables recorded by QC appear to comply with WPS- B – T-4113-1.

Submerged Arc Welding (SAW) in the 1G position of the OBG Cross Beam assembly weld No.

CB-202D-009-002 . Welder is identified as # 053748. The welding variables recorded by QC appear to comply with WPS- B – T-2221-B-L3C-S2.

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Submerged Arc Welding (SAW) in the 1G position of the OBG Cross Beam assembly weld No. CB-202E-009-001 . Welder is identified as # 054458. The welding variables recorded by QC appear to comply with WPS- B – T-2221-B-L3C-S2.

BAY #7

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) in the 3G position of the OBG Side Plate assembly weld No. SP-3011-001-075&076 . The welder is identified as #053609. The welding variables recorded by QC appear to comply with WPS- B – T-2233-B-U2-F.

Flux Core Arc Welding (FCAW) in the 1G position of the OBG Side Plate assembly weld No. SP-3056-001-080 . The welder is identified as #220069. The welding variables recorded by QC appear to comply with WPS- B – T-2231-B-U2-F.

### Magnetic Particle Testing

This Quality Insurance Inspector (QA) performed 15% verification Magnetic Particle Testing (MT) for OBG Side plate ,bottom plat and Tower Diaphragm. This QA inspector generated a (MT) report for this date. This weld was previously tested and accepted by ZPMC QC MT technicians.

The weld designations reviewed are as follows:

### OBG COMPONENT

SP3014-001-061~072  
SP3014-001-037~048  
SP3014-001-025~036

BP3006-001-001~012

BP3005-001-001~012

### TOWER COMPONENT

NSD1-DPSA4-16-9&10(116M)  
SSD1-DPSA4-16-9&10(116M)  
WSD1-DPSA4-16-9&10(116M)  
ESD1-DPSA4-16-9&10(116M)

### Visual Inspection For Green Tagging

This QA inspector performed Visual Inspection for OBG Bottom and Side Plate and Tower Diaphragm which

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were previously accepted by ZPMC Quality Control personnel and ABF QA personnel .

The member(s) are identified as

## OBG COMPONENT

Plate No. Green Tagging No.

SP3014            9407

BP3006           9406

BP3005    9405

## TOWER COMPONENT

DIAPHRAGM No.      Green Tagging No.

NSD1-DPSA4-16-9&10(116M) 005851

SSD1-DPSA4-16-9&10(116M) 005854

WSD1-DPSA4-16-9&10(116M) 005852

ESD1-DPSA4-16-9&10(116M) 005852

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 150-0042-2372, who represents the Office of Structural Materials for your project.

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