

**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-008082**Date Inspected:** 02-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Ma Yun, Chen Ying Xin.**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**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

Bay 10 North Tower Lift 1

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% and Visual Testing (VT) of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT reports for this date. The members are identified as Tower Components. The weld designations reviewed are as follows.

Fit Lug on skin B at 23M, 28M and 33M Diaphragm

23M, 28M and 33M Diaphragm with skin B welds

38M Diaphragm with skin B welds

This Quality Assurance (QA) Inspector observed the following work in progress:

Bay 10

FCAW welding of weld joint 2A located on NSD1-SPSA3-62.

Welder is identified as 040345. ZPMC QC is identified as Mr. Chen Ying Xin.

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The welding variables recorded by QC appeared to comply with WPS-B-T-2231-Tc-U5-F-1.

### Shear Link Plate

SAW welding of weld joint 4A located on ND1-A6002-15.

Welder is identified as 050295. ZPMC QC is identified as Mr. Lu Wei Chao.

The welding variables recorded by QC appeared to comply with WPS-B-T-4221-B-U3c-S-1.

SAW welding of weld joint 2B located on ND1-A6002-18.

Welder is identified as 207745. ZPMC QC is identified as Mr. Yuan Hui Gang.

The welding variables recorded by QC appeared to comply with WPS-B-T-4221-B-U3c-S-1.

### North Tower Lift 1 Corner Seam A/E

FCAW welding of weld joint 73B (Repair) located on NSD1-A166E/J.

Welder is identified as 040261. ZPMC QC is identified as Mr. Sun Tian Liang.

The welding variables recorded by QC appeared to comply with WPS-345-FCAW-2G-REPAIR.

SMAW welding of weld joint 73B (Repair) located on NSD1-A166E/J.

Welder is identified as 052930. ZPMC QC is identified as Mr. Sun Tian Liang.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G-REPAIR.

### South Tower Lift 3 Skin A

FCAW welding of weld joint 5 located on SSD1-FASA3-1A/E.

Welder is identified as 057180. ZPMC QC is identified as Jiang La Mei.

The welding variables recorded by QC appeared to comply with WPS-B-T-2133.

SMAW welding of weld joint 6 located on SSD1-FASA3-1A/E.

Welder is identified as 056200. ZPMC QC is identified as Jiang La Mei.

The welding variables recorded by QC appeared to comply with WPS-B-P-2114.

### Skirt Plate

SAW welding of weld joint 72 located on ND1-A713B/E.

Welder is identified as 051413. ZPMC QC is identified as Mr. Lu Wei Chao.

The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-L2c-S-2.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### 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> | Gaikwad,Umesh | Quality Assurance Inspector |
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| <b>Reviewed By:</b> | Clifford,William | QA Reviewer |
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