

**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-008186**Date Inspected:** 21-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:** Peng Guo**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, Dilip Chakrabarti was present during the times noted above for observations relative to the work being performed.

Bay# 10-Tower Assembly:

This QA Inspector randomly observed the following work in progress:

FCAW Process:

Welding of weld joint# 138 located on PCMK NSD1 A112 G/H. Welder is identified as 057244. ZPMC QC is identified as Shi Jing Wei. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-4333-TC-P5-F

Welding of weld joint# 139 located on PCMK NSD1 A112 G/H. Welder is identified as 057266. ZPMC QC is identified as Shi Jing Wei. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-4333-TC-P5-F

Welding of weld joint# 176 located on PCMK NSD1 A112 G/H. Welder is identified as 040338. ZPMC QC is identified as Shi Jing Wei. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-4333-TC-P5-F

Welding of weld joint# 177 located on PCMK NSD1 A112 G/H. Welder is identified as 050401. ZPMC QC is identified as Shi Jing Wei. The welding variables recorded by QC appeared to comply with the specified WPS no.

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B-T-4333-TC-P5-F

**SAW Process:**

Welding of weld joint# 81A located on PCMK SSSL3-1 B/K. Welder is identified as 052917. ZPMC QC is identified as Du Zhi Qun. The welding variables recorded by QC appeared to comply with the specified WPS no.

B-T-2221-C-U2b-S-2

Welding of weld joint# 81A located on PCMK SSSL3-1 B/K. Welder is identified as 209105. ZPMC QC is identified as Du Zhi Qun. The welding variables recorded by QC appeared to comply with the specified WPS no.

B-T-2221-C-U2b-S-2

Welding of weld joint# 81A located on PCMK SSSL3-1 B/K. Welder is identified as 050295. ZPMC QC is identified as Du Zhi Qun. The welding variables recorded by QC appeared to comply with the specified WPS no.

B-T-2221-C-U2b-S-2

Welding of weld joint# 81A located on PCMK SSSL3-1 B/K. Welder is identified as 040460. ZPMC QC is identified as Du Zhi Qun. The welding variables recorded by QC appeared to comply with the specified WPS no.

B-T-2221-C-U2b-S-2

**Bay# 11-Tower Assembly:**

This QA Inspector randomly observed the following work in progress:

**SAW Process:**

Welding of weld joint# 1A, located on PCMK ESD1 A435 A/C. Welder is identified as 044558. ZPMC QC is identified as Peng Guo. The welding variables recorded by QC appeared to comply with the specified WPS no.

B-T-4221-B-U3c-S-2

**FCAW Process:**

Welding of weld joint# 139 located on PCMK WSTL3-4 G/K. Welder is identified as 066479. ZPMC QC is identified as Yuan Wen Jie. The welding variables recorded by QC appeared to comply with the specified WPS no.

B-T-4333-TC-P4-F

Welding of weld joint# 139 located on PCMK WSTL3-4 J/K. Welder is identified as 066882. ZPMC QC is identified as Yuan Wen Jie. The welding variables recorded by QC appeared to comply with the specified WPS no.

B-T-4333-TC-P4-F

Welding of weld joint# 139 located on PCMK WSTL3-4 G/K. Welder is identified as 066484. ZPMC QC is identified as Yuan Wen Jie. The welding variables recorded by QC appeared to comply with the specified WPS no.

B-T-4333-TC-P4-F

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

**Summary of Conversations:**

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## WELDING INSPECTION REPORT

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No relevant conversation

### **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> | Chakrabarti,Dilip Kumar | Quality Assurance Inspector |
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| <b>Reviewed By:</b> | Clifford,William | QA Reviewer |
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