

**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-008201**Date Inspected:** 07-Aug-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:** Li Lin**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:

Final VT:

This QA inspector performed Final Visual Testing (FVT) of entire welded area, previously tested and accepted by ZPMC Quality Control personnel of the member and weld designated are as follows:

Sl #	Section #	Weld #	Green Tag #	Location
1.	NSD1- A112 H/H	6 to 10, 16 to 20	NA	NA
2.	NSD1- A166 J/J	15 to 28, 41 to 52	NA	NA
3.	NSD1 A166 C/J	257A	NA	NA
4.	NSD1 A166 E/J	73B	NA	NA
5.	NSD1- A112 E/H	121, 241	NA	NA
6.	NSD1- A112 F/H	76, 77	NA	NA
7.	NSD1- A112 G/H	138, 139, 271, 272	NA	NA
8.	NSD1- A112 D/H	11, 12, 25, 26	NA	NA
9.	NSD1- A112 C/H	1, 2	NA	NA
10.	NSD1- A166 C/J	129, 130, 254, 255	NA	NA

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11. NSD1- A166 D/J 131, 132, 256, 257 NA NA
12. NSD1- A166 E/J 127, 128, 247, 248 NA NA
13. NSD1- A166 F/J 120 121, 237, 238 NA NA
14. NSD1- A166 G/J 120, 121, 237, 238 NA NA
15. NSD1- A166 H/J 119, 120, 224, 225 NA NA

### Magnetic Particle Testing (MT):

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6028 MT report on this date. The member and the weld designations are as follows:

### Sl # Section # Weld # Green Tag # Location

1. NSD1- A112 G/H 139 NA NA
2. NSD1- A112 D/H 25 NA NA
3. NSD1- A166 C/J 255 NA NA
4. NSD1- A166 D/J 131 NA NA
5. NSD1- A166 E/J 127 NA NA
6. NSD1- A166 F/J 237 NA NA
7. NSD1- A166 G/J 120 NA NA
8. NSD1- A166 H/J 225 NA NA

### Bay# 11- Tower Assembly:

This QA Inspector randomly observed the following work in progress:

### SAW Process:

Welding of weld joint# 1A located on PCMK WD1 A5001-27, 28, 29, 30. Welder is identified as 042195. ZPMC QC is identified as Chen Hong Yun. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3221-TC-U5-S-1.

Welding of weld joint# 1A located on PCMK SD1 A5012-17, 18, 19, 20. Welder is identified as 041716. ZPMC QC is identified as Chen Hong Yun. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3221-TC-U5-S-1.

Welding of weld joint# 82B located on PCMK WSTL3-4 B/K. Welder is identified as 044558. ZPMC QC is identified as Li Lin. 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# 82B located on PCMK WSTL3-4 B/K. Welder is identified as 044560. ZPMC QC is identified as Li Lin. 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# 82B located on PCMK WSTL3-4 B/K. Welder is identified as 044550. ZPMC QC is identified as Li Lin. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2221-C-U2b-S-2.

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Welding of weld joint# 82B located on PCMK WSTL3-4 B/K. Welder is identified as 056975. ZPMC QC is identified as Li Lin. 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# 82B located on PCMK WSTL3-4 B/K. Welder is identified as 202756. ZPMC QC is identified as Li Lin. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2221-C-U2b-S-2.

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

**Summary of Conversations:**

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

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