

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

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-008289**Date Inspected:** 25-Jul-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

**CWI Name:** Liu Zhong An  
**Inspected CWI report:** Yes No N/A  
**Electrode to specification:** Yes No N/A  
**Qualified Welders:** Yes No N/A  
**Approved Drawings:** Yes No N/A

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

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

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

## Bay 10-

This QA inspector performed Ultrasonic Testing (UT) and Magnetic Particle Testing (MT) of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT and MT report for this date. The members was identified West Tower Lift 2. The weld identification number was WSD1-TL6 B/L 1 A/B between Double diaphragm at the 53 and 65 meter mark.

FCAW welding of longitudinal stiffener to skin B welds for North Tower Lift 4. ZPMC welders were identified as 052075 and 057244. ZPMC QC was identified as Liu Zhong An. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2332-TC-P5-F.

## Bay 11-

This QA Inspector observed the following work in progress: SAW welding of weld joint WSTL3-4 B/K-84B located on the West Tower Lift 3. ZPMC welders were identified as 062611 and 058015. ZPMC QC is identified as Liu Zhong An. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2221-C-U2b-S.

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# WELDING INSPECTION REPORT

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Bay 12-

This QA inspector performed Ultrasonic Testing (UT) of the areas previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members were identified as OBG USPL1. The weld identification numbers are as follows: USPL1-150-001, 002, USPL1-159-001, 002 USPL1-168-001, 002 and USPL1-175-001-002.

QA Inspectors Hall, Dawson and Viars observed ZPMC QC personnel performing Radiography of Deck Panel Butt splice welds. It was noted that multiple exposures were taken at the same location without moving the X ray tube head on several different welds. QA recorded radiography of Deck panel weld DP3009-001-022.

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

### Summary of Conversations:

As identified within the contents of this report.

### 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>	Viars,Larry	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer

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