

**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-008294**Date Inspected:** 01-Aug-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:** Du Zhi Qun**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 date Caltrans OSM Quality Assurance (QA) Inspector, Larry Viars was present during the times noted above for observations relative to the work being performed.

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This QA inspector performed Ultrasonic Testing (UT) verification 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 Tower Strut Plates and Skin Plate stiffener. The weld identification numbers are as follows:

ED1-A6003-4-6A/B, ED1-A6003-5-6A/B, ND1-A6002-14-5A/B, ND1-A6002-8-6A/B, ND1-A-6002-5-5A/B, ND1-A6002-1-5A/B, ND1-A6002-2-5A/B and NSD1-FBSA4-1 A/C-80A/B, 81A/B.

SMAW welding of North Tower Lift 4 Skin A longitudinal stiffener welds NSD1-FASA4-1 E/E- 132 and 132A. ZPMC welder was identified as 040269. ZPMC QC was identified as Du Zhi Qun. The welding appeared to be in conformance with welding procedure specifications, WPS-B-T-3211-TC-U5b-1 and WPS-B-T-3211-TC-P5.

SMAW repair welding of North Tower Lift 4 Skin A to E corner joint NSD1-A112 B/H-4 A/B. ZPMC welder was identified as 052930. ZPMC QC was identified as Du Zhi Qun. The welding appeared to be in conformance with welding procedure specification, WPS-345-SMAW-2G(2F)-Repair.

FCAW welding of North Tower Lift 4 Skin C longitudinal stiffener welds 005 and 006. ZPMC welders were identified as 054069 and 053116. ZPMC QC was identified as Du Zhi Qun. The welding appeared to be in

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conformance with welding procedure specification, WPS-B-T-2332-TC-P5-F.

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This QA Inspector observed the following work in progress: SAW welding of West Tower Lift 3 Corner joint WSTL3-4 B/K-81B. ZPMC welders were identified as 041716, 052642, 040669 and 047304. ZPMC QC was identified as Du Zhi Qun. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2221-C-U2b-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 occurred between QA and QC this date.

### 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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