

**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-008530**Date Inspected:** 16-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

<b>CWI Name:</b>	CWI: Wang Chuan Qing/Li Lin	<b>CWI Present:</b>	<b>Yes</b>	<b>No</b>	
<b>Inspected CWI report:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Approved WPS:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
		<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Bridge No:</b>	34-0006	<b>Component:</b>	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:

**SMAW Process:**

Tack welding of weld joint# 11B located on PCMK ND1 A6002-2. Welder is identified as 040392. ZPMC QC is identified as Wang Chuan Qing. The welding variables recorded by QC appeared to comply with the specified WPS no. B-P-2214-B-U5b-FCM.

**Bay# 11- Tower Assembly:**

This QA Inspector randomly observed the following work in progress:

**FCAW Process:**

Repair welding of weld Joint# 84A/B located on PCMK ESTL3-4 B/K. Welder is identified as 059525. ZPMC QC is identified as Cao Cheng. The welding variables recorded by QC appeared to comply with the specified WPS no. WPS-345-FCAW-2G 2(F)-Repair.

Repair welding of weld Joint# 84A/B located on PCMK ESTL3-4 B/K. Welder is identified as 202821. ZPMC QC is identified as Cao Cheng. The welding variables recorded by QC appeared to comply with the specified WPS no.

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# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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WPS-345-FCAW-2G 2(F)-Repair.

Weld buttering of Skin "A", west shaft lift#1 as per Weld Repair Report (WRR)# T-WR-1961 dated 08.16.09. Welder is identified as 068923. ZPMC QC is identified as Li Lin. The welding variables recorded by QC appeared to comply with the specified WPS no. WPS-345-FCAW-2(G) 2F Repair.

Weld buttering of Skin "A", west shaft lift#1 as per Weld Repair Report (WRR)# T-WR-1961 dated 08.16.09. Welder is identified as 068858. ZPMC QC is identified as Li Lin. The welding variables recorded by QC appeared to comply with the specified WPS no. WPS-345-FCAW-2(G) 2F Repair.

Weld buttering of Skin "A", west shaft lift#1 as per Weld Repair Report (WRR)# T-WR-1961 dated 08.16.09. Welder is identified as 071184. ZPMC QC is identified as Li Lin. The welding variables recorded by QC appeared to comply with the specified WPS no. WPS-345-FCAW-2(G) 2F Repair.

Weld buttering of Skin "A", west shaft lift#1 as per Weld Repair Report (WRR)# T-WR-1961 dated 08.16.09. Welder is identified as 066471. ZPMC QC is identified as Li Lin. The welding variables recorded by QC appeared to comply with the specified WPS no. WPS-345-FCAW-2(G) 2F Repair.

## SMAW Process:

Non critical repair welding of skin plate & stiffeners located on PCMK ESD1 FDSA4-2 D/D. Welder is identified as 040675. ZPMC QC is identified as Xu Jin Long. The welding variables recorded by QC appeared to comply with the specified WPS no. WPS-345-SMAW-2G 2(F)-Repair.

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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# WELDING INSPECTION REPORT

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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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