

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
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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-008606**Date Inspected:** 07-May-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:** 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:** Tower**Summary of Items Observed:**

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

Bay#11

## Visual Inspection

This Q.A Inspector performed random Visual Inspection with the another QA inspector Umesh Gaikwad of the area previously tested and accepted by ZPMC Quality control personnel. The members are identified as the East Tower Lift 2. The welds Designation are as follows.

C/D Corner Diagonal stiffener to skin C and skin D

C/D Corner Diagonal stiffener to skin C and skin D

## Magnetic Particle Inspection

This Q.A Inspector performed Magnetic particle testing of approximately 15% with another QA Inspector Umesh Gaikwad of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (M.T) report for this date. The members are identified as the East Tower Lift 2. The welds Designation are as follows.

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# WELDING INSPECTION REPORT

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C/D Corner Diagonal stiffener to skin C and skin D

C/D Corner Diagonal stiffener to skin C and skin D

## Ultrasonic Inspection

This Q.A Inspector performed Ultrasonic testing of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (U.T) report for this date. The members are identified as the East Tower Lift 2. The welds Designation are as follows.

C/D Corner Diagonal stiffener – ESD1-TL7K/L-14, 28, 12, 30

This QA Inspector randomly observed the following work in progress

### BAY#10

FCAW welding process of weld joint 6 located on PCMK NSD1-FASA3-1E/E. Welder is identified as 048378 ZPMC QC is identified as Liu Zhongan. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P5-F.

FCAW welding process of weld joint 7 located on PCMK NSD1-FASA3-1E/E. Welder is identified as 053869 ZPMC QC is identified as Liu Zhongan. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P5-F.

SAW welding process of weld joint 5A located on PCMK NSD1-FASA4-1A/E. Welder is identified as 207745 ZPMC QC is identified as Lu Wei chao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-B-U3C-S-2.

### BAY#11

FCAW welding process of weld joint 52 located on PCMK WSD1-TCSA3-2B-C. Welder is identified as 062864 ZPMC QC is identified as You Q Guo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P5-F

FCAW welding process of weld joint 42 located on PCMK WSD1-TCSA3-2B-C. Welder is identified as 067500 ZPMC QC is identified as You Q Guo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P5-F

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

### Summary of Conversations:

No relevant conversations.

### 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

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## WELDING INSPECTION REPORT

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remedial efforts please contact Serge Sinevod 13482570045, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Utekar,Shrikant	Quality Assurance Inspector
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<b>Reviewed By:</b>	Clifford,William	QA Reviewer
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