

**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-008828**Date Inspected:** 02-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Qi Guo You, Xu Le Feng.**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 day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

Bay 10 Tower Strut

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% and Visual Testing (VT) of the area (strut stiffener fillet termination modification as per CT letter TC05.03.08-000021 for fabricated strut) previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT reports for this date. The members are identified as Tower Components. The weld designations reviewed are as follows.

ND1-A468-38M-2 Green Tag No. 6746R1  
ND1-A476-53M-2 Green Tag No. 6747R1  
ND1-A476-47.6M-2 Green Tag No. 6770R1  
ND1-A468-33M-2 Green Tag No. 6745R1  
ND1-A468-28M-2 Green Tag No. 6772R1  
ND1-A468-43M-2 Green Tag No. 6768R1  
ND1-A476-77M-2 Green Tag No. 6769R1  
ND1-A476-65M-2 Green Tag No. 6779R1  
ND1-A468-23M-2 Green Tag No. 6771R1

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ND1-A468-18M-2 Green Tag No. 6767R1

Bay 11 West Tower Lift 3 Triangle and Stiffener

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% and Visual Testing (VT) of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT reports for this date. The members are identified as Tower Components. The weld designations reviewed are as follows.

WSTL3-4B/K-2, 64  
WSTL3-4C/K-3, 72, 94, 101  
WSTL3-4D/K-3, 67  
WSTL3-4F/K-59, 74, 135, 150  
WSTL3-4G/K-71, 91, 96, 159  
WSTL3-4H/K-59, 74, 133, 150  
WSTL3-4I/K-68, 86, 94, 157  
WSTL3-4J/K-3, 62

Bay 11 East Tower Lift 3 C/D Corner (inside) except 89M~92.5M

This QA inspector performed Visual Testing (VT) of the area previously tested and accepted by ZPMC Quality Control personnel. The members are identified as Tower Components. The weld designations reviewed are as follows.

ESTL3-4B/K-83A

This Quality Assurance (QA) Inspector observed the following work in progress:

Bay 11

SMAW welding of weld joint 1A/B (Repair) located on SD1-A5002-34.  
Welder is identified as 046704. ZPMC QC is identified as Mr. Mao Bin Bin.  
The welding variables recorded by QC appeared to comply with WPS-485-SMAW-1G-REPAIR.

FCAW welding of weld joint 37 located on WSD1-FDSA4-4C/D.  
Welder is identified as 068858. ZPMC QC is identified as Mr. Li Hong Fei.  
The welding variables recorded by QC appeared to comply with WPS-B-T-4332-Tc-P5-F.

FCAW welding of weld joint 2A/B (Repair) located on ESD1-SPSA3-53.  
Welder is identified as 040775. ZPMC QC is identified as Mr. Shao Hai Lang.  
The welding variables recorded by QC appeared to comply with WPS-345-FCAW-2G REPAIR.

Strut Plate

SMAW welding of weld joint 9B located on SD1-A6002-12.

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Welder is identified as 040611. ZPMC QC is identified as Mr. Liu Dao Feng.

The welding variables recorded by QC appeared to comply with WPS-B-T-3212-Tc-U5b-1.

SMAW welding of weld joint 7A located on WD1-A6001-8.

Welder is identified as 040655. ZPMC QC is identified as Mr. Liu Ying.

The welding variables recorded by QC appeared to comply with WPS-B-T-3212-Tc-U5b-1.

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

### **Summary of Conversations:**

Only general conversation was held between QA and QC concerning this project.

### **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 Jim Simonis - 134-7246-3441, who represents the Office of Structural Materials for your project.

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