

**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-008840**Date Inspected:** 31-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**CWI Name:** CWI: Liu Xiao Zhong**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 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# 11- Tower Assembly:

This QA Inspector randomly observed the following work in progress:

FCAW Process:

Welding of weld Joint# 34 located on PCMK WSD1 FASA4-2 A/E. Welder is identified as 066471. ZPMC QC is identified as Liu Xiao Hong . The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2332-TC-P4-F.

Welding of weld Joint# 12 located on PCMK WSD1 FASA4-2 A/E. Welder is identified as 068882. ZPMC QC is identified as Liu Xiao Hong . The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2332-TC-P4-F.

TOWER milling area:

This QA Inspector randomly observed the following work in progress:

Magnetic Particle Testing (MT):

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6028 MT report on this date.

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The member and the weld designations are as follows:

Sl # Section # Weld # Green Tag # Location

1. WSD1 A115 J/J 36,37,40 NA NA
2. WSD1 A115 D/J 87 NA NA
3. WSD1 A115 C/J 118 NA NA
4. WSD1 A115 E/J 95 NA NA
5. WSD1 A423 G/H 228 NA NA
6. WSD1 A423 H/H 1,12 NA NA

Final VT:

This QA inspector performed Final Visual Testing (FVT) of entire welded area, previously tested and accepted by ZPMC Quality Control personnel of the member and weld designated are as follows:

Sl # Section # Weld # Green Tag # Location

1. WSD1 A115 J/J 7,8,9,10,11,12,13,14 NA NA  
30,35,36,37,38,40
2. WSD1 A115 D/J 86,87,217,218 NA NA
3. WSD1 A115 C/J 118,119,204,205 NA NA
4. WSD1 A115 E/J 95,212,213 NA NA
5. WSD1 A423 G/H 228,229,271,272 NA NA
6. WSD1 A423 H/H 1,2,3,4,11,12,13,14 NA NA

Ultrasonic Testing (UT):

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6027 UT report on this date.

The member and the weld designations are as follows:

Sl # Section # Weld # Green Tag # Location

1. WSD1 A115 J/J 10,14,38 NA NA
2. WSD1 A423 H/H 12,13 NA NA

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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**Inspected By:** Chakrabarti,Dilip Kumar

Quality Assurance Inspector

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**Reviewed By:** Clifford, William

QA Reviewer