

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

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-008932**Date Inspected:** 17-Sep-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/OBG**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 #10

This QA Inspector randomly observed the following work in progress.

FCAW welding process of weld joint 019 located on PCMK NSTL3-3K/K. Welder is identified as 040533ZPMC QC is identified as Wang Hao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U2A-F-1.

FCAW welding process of weld joint 017 located on PCMK NSTL3-3K/K. Welder is identified as 040343ZPMC QC is identified as Wang Hao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U2A-F-1.

FCAW welding process of weld joint 043 located on PCMK NSTL3-3K/K. Welder is identified as 053869ZPMC QC is identified as Wang Hao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U2A-F-1.

FCAW welding process of weld joint 022 located on PCMK NSTL3-3K/K. Welder is identified as 052075ZPMC QC is identified as Wang Hao. The welding variables recorded by QC appeared to comply with the

---

---

# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---

---

WPS-B-T-2233-B-U2A-F-1.

FCAW welding process of weld joint 046 located on PCMK NSTL3-3K/K. Welder is identified as 053870ZPMC QC is identified as Wang Hao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U2A-F-1.

FCAW welding process of weld joint 09 located on PCMK SSD1-FCSA3-1-C/C. Welder is identified as 050041ZPMC QC is identified as Jiang Xi Bo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

BAY#09

## MAGNETIC PARTICLE INSPECTION

This Caltrans QA inspectors performed Magnetic particle inspection verification of OBG deck panel U rib tack welds previously tested and accepted by ZPMC. The following panels were tested:

DP3046-001-010 through 010,

DP3009-001-001 through 008

BAY # 10

## VISUAL INSPECTION

This Caltrans QA Inspector performed visual inspection on triangular plate weld joint with skin D and C of north tower lift Three. Weld designation is as follows.

NSTL3-3D/K-1, 2

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

---

<b>Inspected By:</b>	Utekar,Shrikant	Quality Assurance Inspector
----------------------	-----------------	-----------------------------

---

<b>Reviewed By:</b>	Clifford,William	QA Reviewer
---------------------	------------------	-------------