

**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-009295**Date Inspected:** 12-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Yu Dong Ping.**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, Amit K. Juvekar, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Bay11, South Tower, Struts.

SMAW welding of weld joint SD1-A6002-18-9A located on Bay11, South Tower. Welder is identified as 047470; ZPMC Quality Control Inspector (QC) is identified as Yu Dong Ping. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-3212-TC-U5B-1.

Bay11, West Tower.

SMAW Repair welding of weld joint WD1-A6003-7-3A/B (WRR # 2132) located on Bay11, West Tower. Welder is identified as 040656; ZPMC Quality Control Inspector (QC) is identified as Yu Dong Ping. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-SL345-SL485-SMAW-1G(1F)-Repair.

Assembly Area (Heavy Dock), East Shaft, Lift 2, 53M & 65M.

Drilling holes on Doubler Plate between Double Diaphragm on Skin A.

Assembly Area (Heavy Dock), East Shaft, Lift 1, 23M.

Drilling holes on Doubler Plate between Double Diaphragm on Skin A.

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# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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Bay 11, North Tower, Lift 4, Skin A.

During inprogress Visual Inspection this QA Inspector observed Cracke like Indications on Tack Welds on the Doubler Plates to Skin Plate Weld joints. ZPMC QA Ken has been informed about this. Since ZPMC have not carried out any inspection on the above mentioned part untill Caltrans QA found above mentioned Indications; so NO Incident report has been written about this. The attached photographs provide additional detail.

This QA Inspector carried out NDE on following:

Bay 11, Tower Struts.

This QA inspector performs Random Visual Testing (VT), Magnetic Particle Testing (MT) of area previously tested and accepted by ZPMC Quality Control personnel, FOR GREEN TAG. This QA Inspector generated an MT report (TL-6028) for this date. The members are identified as

- 1) WD1-A467-18M-2.
- 2) WD1-A467-38M-1.

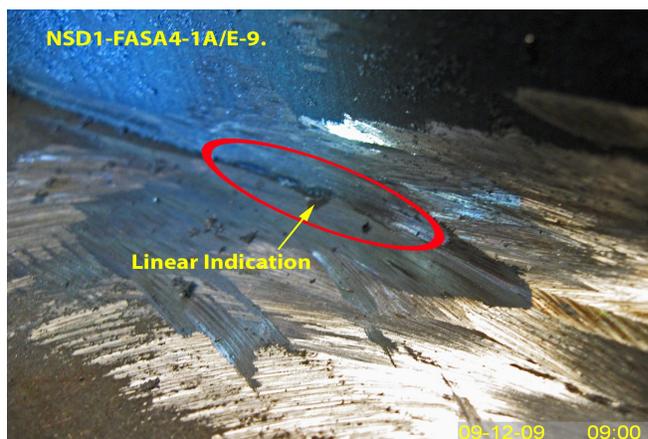
GREEN TAG # 1)6724R1  
2)6732R1

These Struts have been Rejected on date 09-06-09. QA Inspector found "Transverse linear indication" on the weld Identified as WD1-A467-38-1-88. But notification provided by ZPMC did not mentioned this; however QA Inspector checked for the Transverse Indictions found in earlier Inspection & Foud welds satisfactory.

Bay 11, East Tower, Lift 3, Triangular Plate with Diagonal Stiffener of CD Corner.

This QA inspector performs Random Visual Testing (VT), Magnetic Particle Testing (MT) of area previously tested and accepted by ZPMC Quality Control personnel, FOR GREEN TAG. This QA Inspector generated an MT report (TL-6028) for this date. The members are identified as ESTL3-4-D/K-1,2.

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



# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )



## 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.

**Inspected By:** Juvekar,Amit

Quality Assurance Inspector

**Reviewed By:** Clifford,William

QA Reviewer