

**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-009321**Date Inspected:** 23-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:** Du Zhi Qun, Chen Ying Xin.**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 Angle Plate

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% and random 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.

WD1-SA250-18M-1

WD1-SA250-18M-2

WD1-SA250-23M-1

WD1-SA250-28M-2

WD1-SA250-33M-2

WD1-SA250-38M-1

WD1-SA250-38M-2

WD1-SA250-43M-2

WD1-SA250-53M-1

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WD1-SA250-65M-2  
ED1-SA250-28M-1  
ED1-SA250-28M-2  
ED1-SA250-38M-1  
ED1-SA250-38M-2  
ED1-SA250-43M-1  
ED1-SA250-47.6M-1  
ED1-SA250-53M-2  
ED1-SA250-65M-2

Bay 10 North Tower Lift 3

This QA inspector performed random 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.

Fit lug on skin C  
All diaphragm with skin C  
NSD1-FCSA3-1A/C-9~26 (skin C stiffener little angle plate)

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

Bay 10

FCAW welding of weld joint 1A located on SSD1-SPSA3-4.  
Welder is identified as 048784. ZPMC QC is identified as Mr. Gong Liang Zhu.  
The welding variables recorded by QC appeared to comply with WPS-B-T-2231-Tc-U5b-F.

FCAW welding of weld joint 1A located on NSD1-SPSA3-4.  
Welder is identified as 040261. ZPMC QC is identified as Mr. Gong Liang Zhu.  
The welding variables recorded by QC appeared to comply with WPS-B-T-2231-Tc-U5b-F.

SMAW welding of weld joint 9B located on ED1-A6001-2.  
Welder is identified as 053049. ZPMC QC is identified as Mr. Chen Ying Xin.  
The welding variables recorded by QC appeared to comply with WPS-B-T-3212-Tc-U5b-1.

SMAW welding of weld joint 19 located on ED1-A6003-6.  
Welder is identified as 069894. ZPMC QC is identified as Mr. Chen Ying Xin.  
The welding variables recorded by QC appeared to comply with WPS-B-T-2113.

SAW welding of weld joint 1A located on NSD1-A112A/H.  
Welder is identified as 052917. ZPMC QC is identified as Mr. Yu Zhi Lai.  
The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-U3c-S-2.

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## EAST TOWER LIFT 1 JETTY AREA

FCAW welding of weld joint 92 located on ED1-SA294F/G.

Welder is identified as 040736. ZPMC QC is identified as Mr. Wang Xiao Bing.

The welding variables recorded by QC appeared to comply with WPS-B-T-2331-Tc-P4-F-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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