

**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-009548**Date Inspected:** 11-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wang Chuan Qing**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:** OBG and Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Larry Viars was present during the times noted above for observations relative to the work being performed.

OBG Trial Assembly-

Caltrans QA Inspector observed the following work in progress:

ZPMC personnel applying primer to OBG segment 2BW side panels

ZPMC personnel grinding longitudinal diaphragm to bottom panel cope hole on OBG segment 1AE at panel point 8.5 on the cross beam side.

Bay 10-

This QA Inspector observed the following work in progress: Flux Cored Arc Welding (FCAW) of South Tower fit lug to stiffener weld, SSTL4-1 G/L-65 at the 127 meter diaphragm bottom plate. ZPMC welder was identified as 054069. ZPMC QC is identified as Wang Chuan Qing. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2333-TC-P4-F.

Flux Cored Arc Welding (FCAW) of South Tower fit lug to stiffener weld, SSTL4-1 C/L-135 at the 119 meter diaphragm bottom plate. ZPMC welder was identified as 053116. ZPMC QC is identified as Wang Chuan Qing.

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The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2333-TC-P4-F.

Shielded Metal Arc Welding (SMAW) repair of North Tower lift 4, Skin plate C longitudinal stiffener welds. The weld identifications are as follows: NSD1-FCSA4-1 B/C-5 and NSD1-FCSA4-1 C/C-20 ZPMC welder was identified as 053829. ZPMC QC is identified as Wang Chuan Qing. The welding appeared to be in conformance with welding procedure specification, WPS-345-SMAW-2G(2F)-Repair.

Bay 11-

This QA Inspector observed the following work in progress: Shielded Metal Arc Welding (SMAW) of West Tower Lift 1 Skin Plate C stiffener base material at tower base end. ZPMC welder was identified as 041271. ZPMC QC is identified as You Qi Guo. The welding appeared to be in conformance with welding procedure specification, WPS-345-SMAW-3G(3F)-Repair.

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

### Summary of Conversations:

Only general conversation occurred between QC and QA this date.

### 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 Eric Tsang, 150 0042 2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Viars,Larry	Quality Assurance Inspector
<b>Reviewed By:</b>	Dawson,Paul	QA Reviewer

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