

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-009820**Date Inspected:** 17-Oct-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:** Wang Chuan Ging , Li Jia**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/OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shrikant Utekar 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

This QA Inspector randomly observed the following work in progress.

**STRUT**

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 040491 performing Shielded Metal Arc Welding process for the weld 61 located on PCMK ESD1-A6001-3. ZPMC QC Mr. Liu Zhong monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2113.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 040582 performing Shielded Metal Arc Welding process for the weld 8A located on PCMK ESD1-A6003-2. ZPMC QC Mr. Liu Zhong monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-485-SMAW-2G (2F) Repair.

**SOUTH TOWER LIFT #4**

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 052075 performing Flux Core Arc Welding process for the weld joint SSTL4-1H/L -85 located on PCMK South tower lift #4. ZPMC QC Mr. Liu

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## WELDING INSPECTION REPORT

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Zhong Au monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 040345 performing Flux Core Arc Welding process for the weld joint SSSL4-1I/L -07 located on PCMK South tower lift #4. ZPMC QC Mr. Liu Zhong Au monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133.

### NORTH TOWER LIFT #3

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 052930 performing Shielded Metal Arc Welding process for the weld joint NSTL3-3B/K -83 located on PCMK North tower lift #4 corner weld between skin A and skin B. ZPMC QC Mr. Wang Chuan Ging monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F) Repair.

### TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress.

### OBG SEGMENT 1AAW- 1AW

This Quality Assurance (QA) Inspector observed ZPMC qualified welders 049769, 048659, 054467 performing Shielded Metal Arc Welding process for the weld OBW1A-004 (outside) on the excavated area located on PCMK side panel splice weld between OBG segment 1AAW and 1AW cross beam side. The Y location measured approximately 700mm to 4000mm from edge panel towards bottom panel. ZPMC QC Mr. Wang Li Yang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F) Repair-1. The critical weld repair report identified as B-CWR845.

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.

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

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