

**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-009987**Date Inspected:** 20-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:** Zhan Bo**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 and OBG**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.

Bay 10-

Flux Cored Arc Welding (FCAW) repair of East Tower Lift 4 Skin B to C weld ESTL4-2-B/L-58A. ZPMC welder was identified as 046706. ZPMC QC is identified as Zhan Bo. The welding appeared to be in conformance with welding procedure specification, WPS-345-FCAW-1G (1F)-Repair.

Flux Cored Arc Welding (FCAW) repair of East Tower Lift 4 Skin B to C weld ESTL4-2-B/L-58B. ZPMC welder was identified as 042218. ZPMC QC is identified as Zhan Bo. The welding appeared to be in conformance with welding procedure specification, WPS-345-SMAW-4G (4F)-Repair.

Flux Cored Arc Welding (FCAW) of East Tower Lift 4 Fit Lug to diaphragm weld ESTL4-2-F/L-126, located on the 123 meter double diaphragm top plate. ZPMC welder was identified as 042218. ZPMC QC is identified as Zhan Bo. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-4133.

Bay 14-

This QA inspector performed Ultrasonic Testing (UT) verification of the areas previously tested and accepted by

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## WELDING INSPECTION REPORT

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ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members were identified as OBG Segment 10AE deck panel to edge panel joint SEG060\*-038.

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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