

**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-010041**Date Inspected:** 24-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:** See below**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 Inspector George Goulet was present during the times noted above for observations relative to the work being performed.

Bay 10

This QA Inspector randomly observed the following work in progress in Bay 10:

SMAW repair welding of weld joint NSTL3-3B/K-84B located outside PCMK north tower, lift 3, skin A to skin E, approximately 16M from bottom of lift 3. Welder was identified as 052493. ZPMC QC was identified as Chen Ying Xin (QC1). The welding variables recorded by QC1 appeared to comply with WPS-345-SMAW-2G(2F)-repair listed on the ZPMC unnumbered repair order.

FCAW repair welding of weld joint NSTL3-3B/K-84A located inside PCMK north tower, lift 3, skin A to skin E, at the top of 99M double diaphragm. Welder was identified as 040261. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-345-FCAW-2G(2F)-repair listed on the ZPMC unnumbered repair order.

FCAW repair welding of weld joint NSTL3-3D/K-51 located on PCMK north tower, top of 89M double diaphragm corner closure plate. Welder was identified as 050038. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-3212-B-U2a-2.

FCAW welding of weld joint SSSL4-1B/L-4B located inside PCMK south tower, lift 4, skin A to skin B, between

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## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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the bottom of lift 4 and single diaphragm 116.33M single diaphragm. Welder was identified as 052075. ZPMC QC was identified as Liu Zhong An (QC2). The welding variables recorded by QC2 appeared to comply with WPS-B-T-2231-B-U4b-F.

FCAW welding of weld joint SSTL4-1B/L-3B located inside PCMK south tower, lift 4, at skin A to skin E, inside 127M double diaphragm. Welder was identified as 040343. ZPMC QC was identified as QC2. The welding variables recorded by QC appeared to comply with WPS-B-T-3212-TC-U4b-F.

FCAW welding of weld joint SSTL4-1B/L-5B located inside PCMK south tower, lift 4, skin B to skin C, between the top of 123M double diaphragm and bottom of 127M double diaphragm. Welder was identified as 050041. ZPMC QC was identified as QC2. The welding variables recorded by QC2 appeared to comply with WPS-B-T-2232-TC-U4b-F.

FCAW welding of weld joint SSTL4-1L/L-4B located inside PCMK south tower, lift 4, skin A to skin B. Welder was identified as 050289. ZPMC QC was identified as QC2. The welding variables recorded by QC2 appeared to comply with WPS-B-T-3211-B-U4b.

### 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, 134-8257-0045, who represents the Office of Structural Materials for your project.

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

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