

**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-010099**Date Inspected:** 15-Nov-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:** Li Ming**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/Tower**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:

OUTSIDE YARD

OBG SEGMENT 7AW

**MAGNETIC PARTICLE INSPECTION**

This Q.A Inspector performed Magnetic particle Testing of approximately 15% of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (M.T) report for this date. The members are identified as the Corner assembly the welds Designation are as follows.

CSD2-PP47.5-41, 37, 38, 33, 34, 35, 29, 32, 31, 25, 27, 28, 23, 24, 19, 21, 15, 17, 18, 009, 010, 011, 003, 001, 002.

CSD2-PP48.5-125, 126, 121, 124, 117, 118, 119, 120, 114, 116, 111, 112, 109, 107, 108, 103, 105, 099, 101, 093, 087, 088, 095, 085, 090.

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## WELDING INSPECTION REPORT

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This QA Inspector randomly observed the following work in progress.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 050041 performing Flux Core Arc Welding process for the weld joint 2B located on PCMK NSD1-SPSA4-15. ZPMC QC Mr. Li Ming monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-B-U5-F.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 053870 performing Flux Core Arc Welding process for the weld joint 3A located on PCMK SSD1-SPSA4-24. ZPMC QC Mr. Li Ming monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-TC-U5-F.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 048777 performing tack welding with SMAW process for the corner weld between skin C and skin D of north tower lift 4. ZPMC QC Li Peng Fei monitoring this welding. The welding variable recorded by QC appeared to comply with the WPS-B-T-2212-TC-U5B.

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 Eric Tsang +(86) 150.0042.2372, 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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