

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

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-010198**Date Inspected:** 13-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chan Ying Xin**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 COMPONENT**Summary of Items Observed:**

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

In process Inspection

Bay #10

This QA Inspector observed the following work in progress:

SMAW welding in the 2G position at weld joint ED1-A6001-6-8A located on East Tower Strut assembly .

Welder is identified as #040582.ZPMC QC is identified as Mr. Chan Ying Xin.The welding variables recorded by QC appeared to comply with WPS-B-T-3212-Tc-U5b-1 .

SMAW welding in the 2G position at weld joint ED1-A6003-8-12A located on East Tower Strut assembly .

Welder is identified as #052930.ZPMC QC is identified as Mr. Chan Ying Xin.The welding variables recorded by QC appeared to comply with WPS-B-T-2212-Tc-U5b .

SMAW welding in the 3F position at weld joint ED1-A6003-7-31 located on East Tower Strut assembly . Welder

is identified as #068250.ZPMC QC is identified as Mr. Chan Ying Xin.The welding variables recorded by QC appeared to comply with WPS-B-T-4113-1 .

SMAW welding in the 3F position at weld joint ED1-A6003-7-29 located on East Tower Strut assembly . Welder

is identified as #050038.ZPMC QC is identified as Mr. Chan Ying Xin.The welding variables recorded by QC

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appeared to comply with WPS-B-T-2113-1 .

SMAW welding in the 2G position at excavation area on weld joint ND1-A6002-4-10A/B located on Tower Strut assembly . Welder is identified as #052940.ZPMC QC is identified as Mr.Yu Zhi Lai.The welding variables recorded by QC appeared to comply with WPS-485-SMAW-2G (2F)-FCM-Repair-1 and repair procedure T-WR2322.

SMAW welding in the 2G position at excavation area on weld joint ND1-A6002-4-7A/B located on Tower Strut assembly . Welder is identified as #052493.ZPMC QC is identified as Mr.Yu Zhi Lai.The welding variables recorded by QC appeared to comply with WPS-485-SMAW-2G (2F)-FCM-Repair-1 and repair procedure T-WR2319.

FCAW in the 3G position of the South Tower Diaphragm to Skin connecting Plate 'C' weld No. SSTL4-1L/L-68. The welder is identified as #037907. ZPMC QC is identified as Mr. Du Zhiquan .The welding variables recorded by QC appear to comply with WPS-B-T-4333-Tc-P4-F.

FCAW in the 3G position of the South Tower Diaphragm to Skin connecting Plate 'C' weld No. SSTL4-1C/L-135. The welder is identified as #066164. ZPMC QC is identified as Mr. Du Zhiquan .The welding variables recorded by QC appear to comply with WPS-B-T-2333-Tc-P4-F.

### Ultrasonic Testing (UT)

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as East Tower Lift -III A/B corner welds .

The Weld Designations are as follow

ESTL3-4B/K-85A/B

### Visual Inspection

During random in-process visual inspection the QA inspector observed ZPMC personal repaired the weld area on Corner Angle Plate without any welding repair report. This QA Inspector informed to ZPMC QC Mr. Zhang Jaidi to provide Weld Repair Report for mention weld joint.

The Weld number is noted as ED1-A5007-23-1A/B.

For details see attached picture for details.

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

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## 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>	Bera,Subhasis	Quality Assurance Inspector
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<b>Reviewed By:</b>	Patterson,Rodney	QA Reviewer
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