

**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-011135**Date Inspected:** 21-Dec-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Chen 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**Summary of Items Observed:**

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

**Magnetic Particle Testing:-****BAY #10:-**

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an MT report for this date. The member is identified as Tower Spare Strut Plate. The weld designations reviewed are as follows:-

ED1-A6003-1-7B,8B,9A,10A,24,27,29,33,35,40,44,52,60.

ND1-A6002-17-7A,8A,9A,11A,21,23,33,42,44.

**IN PROCESS INSPECTION:-****BAY #10:-**

This QA inspector observed the following work in progress:

FCAW Welding of weld joint no:-NSD1-SPSA4-24-2A/B located on Interior Splice Plate. Welder is identified as 040261. ZPMC CWI is identified as Mr. Chen Ying Xin. Welding was been performed against Welding Repair Report T-WR2840 and UT report number- T787-UT-2531. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-1G(1F)-Repair.

**BAY #11:-**

This QA inspector observed the following work in progress:

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## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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FCAW welding of weld joint no: WSD1-SPSA4-3-3B located on Interior Splice Plate. Welder is identified as 040723.ZPMC QC is identified as Mr.Li Jun. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-TC-U5-F.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: SD1-STSA3-1-89M-1-37 located on Strut Plate. Welder is identified as 040611. ZPMC CWI is identified as Mrs. Yu dong ping. The welding variables recorded by QC appeared to comply with the WPS-B-T-2112.

This QA inspector observed the following work in progress:

FCAW welding of weld joint no: ESTL4-2C/L-5 located on Skin C to Triangle Plate. Welder is identified as 059525.ZPMC CWI is identified as Mr.Li Lin. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

This QA inspector observed the following work in progress:

SAW welding of weld joint no: WSTL4-2B/L-57A located on CD Corner Seam. Welder is identified as 040699. ZPMC CWI is identified as Mr.Yu Liang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-C-U2b-S-2.

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

**Summary of Conversations:**

No Relevant Conversation.

**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>	Pillai,Pandaram	Quality Assurance Inspector
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<b>Reviewed By:</b>	Clifford,William	QA Reviewer
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