

**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-011492**Date Inspected:** 23-Dec-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 11

This QA Inspector randomly observed the following work in progress in Bay 11:

FCAW repair welding of weld joint ESTL4-2B/L-58B located inside PCMK east tower, lift 4, skin B to skin C, at approximately 121.5M elevation. Welder was identified as 048810. ZPMC QC was identified as CWI Liu Xiao Zhong (QC1). Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC Fu Wei Min, who was not a CWI. The welding variables recorded by QC1's assistant appeared to comply with WPS-345-FCAW-2G(2F)-repair as listed on the unnumbered ZPMC repair report.

SAW welding of weld joint WSTL4-2B/L-60A located outside PCMK west tower, lift 4, skin A to skin E, between approximately 122.5M and 127M elevations. Welder was identified as 047304. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-2221-C-U2b-S-2. Also present at this location and appearing to be monitoring the welding operation was ABF Representative Wang Jiang Hua.

SAW welding of weld joint WSTL4-2B/L-60A located outside PCMK west tower, lift 4, skin A to skin E, between approximately 127M and 131.5M elevations. Welder was identified as 040634. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-2221-C-U2b-S-2.

---

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

---

Also present at this location and appearing to be monitoring the welding operation was ABF Representative Wang Jiang Hua.

SAW welding of weld joint WSTL4-2B/L-60A located outside PCMK west tower, lift 4, skin A to skin E, between approximately 138M and 141M elevations. Welder was identified as 041716. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-2221-C-U2b-S-2. Also present at this location and appearing to be monitoring the welding operation was ABF Representative Wang Jiang Hua.

SAW welding of weld joint WSTL4-2B/L-60A located outside PCMK west tower, lift 4, skin A to skin E, between approximately 141M and 144M elevations. Welder was identified as 044560. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-2221-C-U2b-S-2. Also present at this location and appearing to be monitoring the welding operation was ABF Representative Wang Jiang Hua.

Bay 10

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

SMAW repair welding of weld joint SSTL4-1B/L-5A located outside PCMK south tower, lift 4, skin B to skin C, 200mm long weld repair at approximately 138M elevation. Welder was identified as 052930. ZPMC QC was identified as CWI Wang Chuan Qing (QC2). The welding variables recorded by QC2 appeared to comply with WPS-345-SMAW-2G(2F)-repair as listed on ZPMC repair report #T-CWR511.

SMAW repair welding of weld joint SSTL4-1B/L-5B located inside PCMK south tower, lift 4, skin B to skin C, 400mm long weld repair at approximately 127.5M elevation. Welder was identified as 050289. ZPMC QC was identified as QC2. The welding variables recorded by QC2 appeared to comply with WPS-345-SMAW-2G(2F)-repair as listed on ZPMC repair report #T-CWR511.

SMAW repair welding of weld joint SSTL4-1B/L-5B located inside PCMK south tower, lift 4, skin B to skin C, 400mm long weld repair at approximately 127.5M elevation. Welder was identified as 040365. ZPMC QC was identified as QC2. The welding variables recorded by QC2 appeared to comply with WPS-345-SMAW-2G(2F)-repair as listed on ZPMC repair report #T-CWR511.

Unless otherwise noted, all work observed on this date 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 Serge Sinevod, 134-8257-0045, who represents the Office of Structural Materials for your project.

---

---

# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

---

---

<b>Inspected By:</b>	Goulet,George	Quality Assurance Inspector
----------------------	---------------	-----------------------------

---

<b>Reviewed By:</b>	Dawson,Paul	QA Reviewer
---------------------	-------------	-------------

---