

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-011525**Date Inspected:** 18-Jan-2010**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:** Zhao Chen Sun.**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 day CALTRANS OSM Quality Assurance (QA) Inspector Shailesh Gaikwad 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:

This QA Inspector observed the following work in progress:

**BAY 10**

This QA Inspector observed ZPMC qualified welding personnel identified as 040365. Perform Shielded Metal Arc Welding (SMAW) on South Tower Lift 5 A/E corner joint. Joint identified as SSD1-TL5-1B-F-36B, ZPMC QC Identified as Wang Hao. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-3212-Tc-U5b-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 057258. Perform Shielded Metal Arc Welding (SMAW) on South Tower Lift 5 A/B corner joint. Joint identified as SSD1-TL5-1B-F-37B, ZPMC QC Identified as Wang Hao. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-3211-Tc-U4b-1.

**Repair Welding:**

This QA Inspector observed ZPMC qualified welding personnel identified as 056200. Perform Shielded Metal Arc Welding (SMAW) on South Tower Lift 4 D/E corner joint. Joint identified as SSSL4-1B/L-2A/B, ZPMC QC

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## WELDING INSPECTION REPORT

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Identified as Tang Xingshan with Critical welding report, CWR-T-CWR475. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-1G(1F)Repair.

### Repair Welding:

This QA Inspector observed ZPMC qualified welding personnel identified as 052493, 040582. Perform Shielded Metal Arc Welding (SMAW) on South Tower Lift 4 A/E corner joint. Joint identified as SSSL4-1B/L-3A/B, ZPMC QC Identified as Tang Xingshan with Critical welding report, CWR-T-CWR512. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-2G (2F) Repair.

### Tower Trial Assembly:

This QA Inspector observed ZPMC qualified welding personnel identified as 053486. Perform Flux Core Arc Welding (FCAW) on West Tower. Joint identified as WSD1-SA225F/H-27, Skin E, ZPMC QC Identified as Hegen. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2333-Tc-P4-F.

This QA Inspector observed ZPMC qualified welding personnel identified as 047701. Perform Flux Core Arc Welding (FCAW) on West Tower. Joint identified as WSD1-SA225F/H-33, Skin E, ZPMC QC Identified as Hegen. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2333-Tc-P4-F.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

### Summary of Conversations:

Only general conversation was held between QA and QC concerning this projec

### 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 Skyler Guest phone: 15000422360, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Gaikwad,Shailesh	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

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