

**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-011594**Date Inspected:** 08-Dec-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:** Li Huajie**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 and 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 #14

This QA Inspector observed the following work in progress:

FCAW in the 1G position for the OBG Corner Assembly ,Side plate to Edge plate , weld No. CA-92-003. The welder is identified as #201215. ZPMC QC is identified as Mr. Xu Tao. The welding variables recorded by QC appear to comply with WPS-B-T-2231-Tc-U4b-F .

FCAW in the 1G position for the OBG Corner Assembly ,Side plate to Edge plate , weld No. CA-92-004. The welder is identified as #058245. ZPMC QC is identified as Mr. Xu Tao. The welding variables recorded by QC appear to comply with WPS-B-T-2231-Tc-U4b-F .

SAW in the 1G position for the OBG segment, Side plate SP685B to Side plate SP507B , weld No. SEG-071A-008. The welder is identified as #045265. ZPMC QC is identified as Mr. Zhong Gao Hui. The welding variables recorded by QC appear to comply with WPS-B-T-2221-B-L2c-S-2 .

SMAW in the 4F position for the OBG segment 10CW, Deck plate to Edge plate, weld No. SEG-063E-153. The

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## WELDING INSPECTION REPORT

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welder is identified as #067610. ZPMC QC is identified as Mr.Zhong Gao Hui. The welding variables recorded by QC appear to comply with WPS-B-P-2114-FCM-1 .

SAW in the 1G position for the OBG segment, Bottom plate BP3007A to Bottom plate BP3008A , weld No. SEG-3003A-005. The welder is identified as #045265. ZPMC QC is identified as Mr.Xu Tao. The welding variables recorded by QC appear to comply with WPS-B-T-2221-B-L2c-S-2 .

### 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 Tee Joint at Tower Strut Plate.

The Weld Designations are as follow

SD1-A6002-010-007, 008,009,010,011 and 012

SD1-A6002-012-007, 008,009,010,011 and 012

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 butt and corner joint of Segment 8AW.

The Weld Designations are as follow

SEG -043A-006,007,008 and 039

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 butt ,Tee and corner joint of Segment 8BE.

The Weld Designations are as follow

SEG -046A-005 and 006

SEG -046B-002 and 014

SEG -046C-006 and 026

SSD19-PP65-108,132,135 and 138

SSD19A-PP65-128,131,134 and 106

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

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## WELDING INSPECTION REPORT

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remedial efforts please contact Eric Tsang 150-0042-2372, 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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