

**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-011697**Date Inspected:** 19-Jan-2010**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

|                                    |                                    |           |            |                                  |                  |           |            |
|------------------------------------|------------------------------------|-----------|------------|----------------------------------|------------------|-----------|------------|
| <b>CWI Name:</b>                   | Lin Li, Liu Zhong An, Yu Dong Ping |           |            | <b>CWI Present:</b>              | <b>Yes</b>       | <b>No</b> |            |
| <b>Inspected CWI report:</b>       | <b>Yes</b>                         | <b>No</b> | <b>N/A</b> | <b>Rod Oven in Use:</b>          | <b>Yes</b>       | <b>No</b> | <b>N/A</b> |
| <b>Electrode to specification:</b> | <b>Yes</b>                         | <b>No</b> | <b>N/A</b> | <b>Weld Procedures Followed:</b> | <b>Yes</b>       | <b>No</b> | <b>N/A</b> |
| <b>Qualified Welders:</b>          | <b>Yes</b>                         | <b>No</b> | <b>N/A</b> | <b>Verified Joint Fit-up:</b>    | <b>Yes</b>       | <b>No</b> | <b>N/A</b> |
| <b>Approved Drawings:</b>          | <b>Yes</b>                         | <b>No</b> | <b>N/A</b> | <b>Approved WPS:</b>             | <b>Yes</b>       | <b>No</b> | <b>N/A</b> |
|                                    |                                    |           |            | <b>Delayed / Cancelled:</b>      | <b>Yes</b>       | <b>No</b> | <b>N/A</b> |
| <b>Bridge No:</b>                  | 34-0006                            |           |            | <b>Component:</b>                | Tower Components |           |            |

**Summary of Items Observed:**

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

This QA Inspector observed the following work in progress:

Bay 10, South Tower, lift 5, A/E Corner Seam (Inside).

SMAW welding of weld joint SSD1-TL5-1B-F-36B; located on Bay 10, South Tower. Welders are identified as 040365, 050289; ZPMC Quality Control Inspector (QC) is identified as Liu Zhong An. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS:

WPS-B-T-3212-TC-U5B-1.

Bay 10, South Tower, lift 5, A/B Corner Seam (Inside).

SMAW welding of weld joint SSD1-TL5-1B-F-37B; located on Bay 10, South Tower. Welders are identified as 057258; ZPMC Quality Control Inspector (QC) is identified as Liu Zhong An. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-3212-TC-U3B-1.

Bay 11, East Tower.

SMAW welding of weld joint ED1-SA4-68-135M-1-1A & ED1-SA4-68-135M-2-1A ; located on Bay 11, East Tower. Welders are identified as 040655; ZPMC Quality Control Inspector (QC) is identified as Yu Dong Ping. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS:

WPS-B-T-3211-TC-U5B-1.

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Bay 11, East Tower.

SMAW welding of weld joint ED1-SA4-68-131M-8-1A; located on Bay 11, East Tower. Welders are identified as 040669; ZPMC Quality Control Inspector (QC) is identified as Yu Dong Ping. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-3211-TC-U5B-1.

Bay 11, North Tower.

SMAW welding of weld joint ND1-SA4-68-131M-1-1A & ED1-SA4-68-131M-2-1A ; located on Bay 11, East Tower. Welders are identified as 040669, 040656; ZPMC Quality Control Inspector (QC) is identified as Yu Dong Ping. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-3211-TC-U5B-1.

Bay 11, East Tower, Lift 4, A/E Corner Seam (Outside).

SMAW Repair welding of weld ESTL4-2B/L-60A (WRR # T-WR3019); located on Bay 11, East Tower, Lift 4. Welders are identified as 040733; ZPMC Quality Control Inspector (QC) is identified as Lin Li. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-345-SMAW-2G(2F)-REPAIR.

Bay 10, North Tower, Lift 2, Pad eyes.

Pad eyes on skin C & D (near CD & BC Corner) found relocated between 53M & 65M Double Diaphragm, ZPMC As well As Caltrans have already completed NDT requirement on these Pad eyes. The attached photographs provide additional detail.

This QA Inspector carried out NDE on following

Bay 11, West Tower, Lift 2, GRATING SUPORTS.

This QA inspector performs Random Visual Testing (VT) of area previously tested and accepted by ZPMC Quality Control personnel(Notification # 005079), FOR GREEN TAG. The members are identified as GRATING SUPORTS.

- 1) GGSA-32PLAN-W53M-LOT-1 TO 6. (LOT : 1 TO 6)
- 2) GGSA-34PLAN-W53M-LOT-1 TO 6. (LOT : 1 TO 7)
- 3) GGSA-36PLAN-W56M-LOT-1 TO 6. (LOT : 1 TO 17)
- 4) GGSA-38PLAN-W59M-LOT-1 TO 6. (LOT : 1 TO 12)
- 5) GGSA-40PLAN-W62M-LOT-1 TO 6. (LOT : 1 TO 14)
- 6) GGSA-42PLAN-W65M-LOT-1 TO 6. (LOT : 1 TO 3)
- 7) GGSA-44PLAN-W65M-LOT-1 TO 6. (LOT : 1 TO 3)
- 8) GGSA-46PLAN-W68M-LOT-1 TO 6. (LOT : 1 TO 14)
- 9) GGSA-48PLAN-W71M-LOT-1 TO 6. (LOT : 1 TO 12)
- 10)GGSA-50PLAN-W74M-LOT-1 TO 6. (LOT : 1 TO 13)
- 11)GGSA-52PLAN-W77M-1-1 TO 6.
- 12)GGSA-54PLAN-W77M-1-1 TO 6.
- 13)GGSA-56PLAN-W80.75M-LOT-1 TO 6. (LOT : 1 TO 10)

GREEN TAG # 12030.

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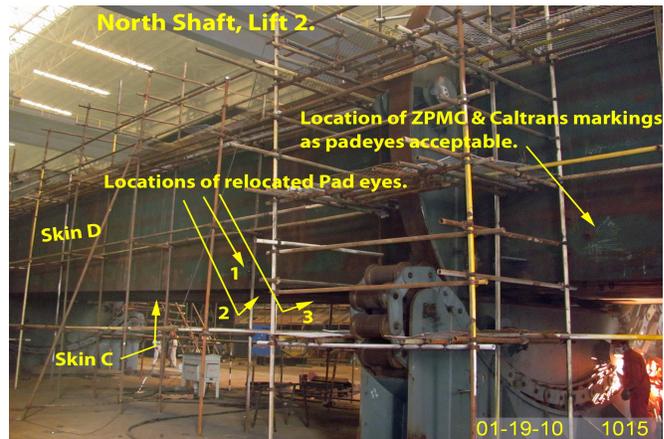
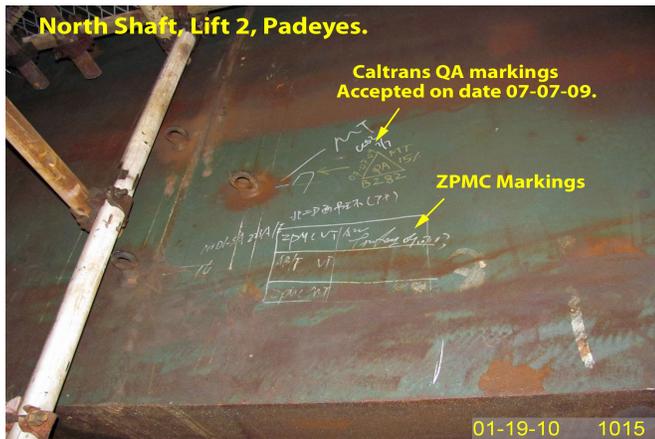
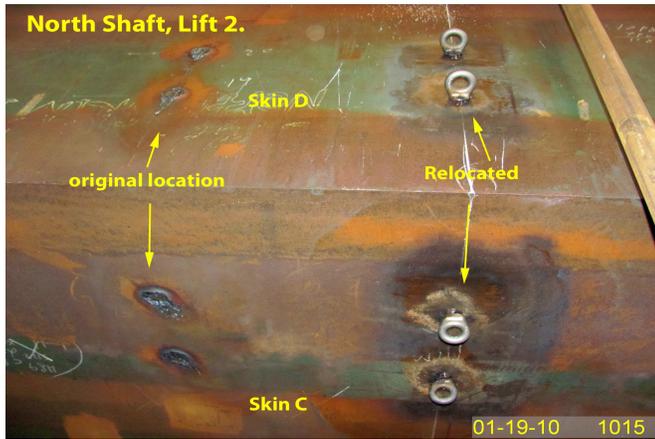
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Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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

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**Inspected By:** Juvekar,Amit

Quality Assurance Inspector

**Reviewed By:** Clifford,William

QA Reviewer