

**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-011947**Date Inspected:** 03-Feb-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:** Mr. An Qing Xiang**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 Strut Plate. The weld designations reviewed are as follows:

ED1-STSA3-2-89M-2-13,14,29,30,41,43,44,53,55

**Ultrasonic Testing:-****BAY # 10:-**

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an UT report for this date. The member is identified as South Tower DE Corner Back Fill Plate. The weld designations reviewed are as follows:

NSTL4-3C/L-32,91

NSTL4-3F/L-17,91

NSTL4-3G/L-19,89

NSTL4-3H/L-21,89

NSTL4-3I/L-20,87

NSTL4-3J/L-18,88

---

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

---

NSTL4-3K/L-20,86

IN PROCESS INSPECTION:-

BAY #10:-

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: ND1-STSA3-1-89M-1-26A/B located on Strut Plate. Welder is identified as 057258. ZPMC CWI is identified as Mr. Xu Le Feng. Welding was been performed against Critical Weld Repair Report T-CWR566 and UT report number: T787-UT-2533R1-2 .The welding variables recorded by QC appeared to comply with the WPS-485-SMAW-2G(2F)-FCM-Repair-1.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: SSTL4-1G/L-29 located on “AE” Corner Back Fill Plate. Welder is identified as 052493.ZPMC CWI is identified as Mr.Du zhiquan. The welding variables recorded by QC appeared to comply with the WPS-B-T-3213-B-U2a-1.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: SSTL4-1G/L-98 located on “AE” Corner Back Fill Plate. Welder is identified as 050289.ZPMC CWI is identified as Mr.Du zhiquan. The welding variables recorded by QC appeared to comply with the WPS-B-T-3213-B-U2a-1.

BAY #11:-

This QA inspector observed the following work in progress:

SAW welding of weld joint no: ESD1-TL5-2B/F-24A located on “DE” Corner Seam. Welder is identified as 044552.ZPMC CWI is identified as Mr.An Qing Xiang. The welding variables recorded by QC appeared to comply with the WPS-B-T-3221-C-U2b-S.

This QA inspector observed the following work in progress:

SAW welding of weld joint no: ESD1-TL5-2B/F-40B located on “DE” Corner Seam. Welder is identified as 040699.ZPMC QC is identified as Mr. An Qing Xiang. The welding variables recorded by QC appeared to comply with the WPS-B-T-3221-C-U2b-S.

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

**Summary of Conversations:**

No Relevant Conversation.

---

# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---



## 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 - 15000422360, who represents the Office of Structural Materials for your project.

---

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

---