

**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-012052**Date Inspected:** 20-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

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

**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh 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:

BAY 10 NORTH TOWER LIFT 2, ELEVATOR SUPPORT ON SKIN D (GREEN TAG NO. 11594)

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 members are identified as Tower Components. The weld designations reviewed are as follows.

Z69-0-B/F-14-1-N (VT ONLY)  
Z69-0-B/F-14-2-N (VT ONLY)  
Z69-0-B/F-15-1-N (VT ONLY)  
Z69-0-B/F-15-2-N (VT ONLY)  
Z69-0-B/F-16-1-N (VT ONLY)  
Z69-0-B/F-16-2-N (VT ONLY)  
Z69-0-B/F-17-1-N (VT ONLY)  
Z69-0-B/F-17-2-N (VT ONLY)  
Z69-0-B/F-18-1-N (VT ONLY)  
Z69-0-B/F-18-2-N (VT ONLY)

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Z69-0-B/F-19-1-N (VT AND MT)  
Z69-0-B/F-19-2-N (VT AND MT)  
Z69-0-B/F-20-1-N (VT ONLY)  
Z69-0-B/F-20-2-N (VT ONLY)  
Z69-0-B/F-21-1-N (VT AND MT)  
Z69-0-B/F-21-2-N (VT AND MT)  
Z69-0-B/F-23-1-N (VT ONLY)  
Z69-0-B/F-23-2-N (VT ONLY)  
Z69-0-B/F-24-1-N (VT ONLY)  
Z69-0-B/F-24-2-N (VT ONLY)  
Z69-0-B/F-25-1-N (VT ONLY)  
Z69-0-B/F-25-2-N (VT ONLY)

### BAY 10 NORTH TOWER LIFT 3, SKIN C INTERIOR SPLICE PLATE

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 members are identified as Tower Components. The weld designations reviewed are as follows.

SPSA3-66 (BUTTERING AREA 12mm LENGTH) GREEN TAG NO. 10684R1

This Quality Assurance (QA) Inspector observed the following work in progress:

Bay 11

### STRUT WEB PLATE

SAW welding of weld joint 7A located on ND1-SA4-6-135M-1.

Welder is identified as 040699. ZPMC QC is identified as Mr. Mao Mao Bin.

The welding variables recorded by QC appeared to comply with WPS-B-T-4221-B-U3c-S-1.

BAY 10

### SOUTH TOWER LIFT 5 A/E CORNER SEAM

SMAW welding of weld joint 36B located on SSD1-TL5-1B/F.

Welder is identified as 040365. ZPMC QC is identified as Mr. Deng Zhi Bing.

The welding variables recorded by QC appeared to comply with WPS-B-T-3212-Tc-U5b-1.

### SOUTH TOWER LIFT 5 A/B CORNER SEAM

SMAW welding of weld joint 37B located on SSD1-TL5-1B/F.

Welder is identified as 057258. ZPMC QC is identified as Mr. Deng Zhi Bing.

The welding variables recorded by QC appeared to comply with WPS-B-T-3211-B-U3b-1.

### SOUTH TOWER LIFT 5 D/E CORNER SEAM

SMAW welding of weld joint 24B located on SSD1-TL5-1B/F.

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Welder is identified as 040582. ZPMC QC is identified as Mr. Deng Zhi Bing.  
The welding variables recorded by QC appeared to comply with WPS-B-T-3211-Tc-U4b-1.

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

**Summary of Conversations:**

Only general conversation was held between QA and QC concerning this project.

**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.

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

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