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 #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-012066
Date Inspected: 06-Feb-2010

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 700
OSM Departure Time: 1900
Location: Shanghai, China

CWI Name:	Yu Dong Ping, Du Zhi Qun			**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 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:

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

BAY 10

SOUTH TOWER LIFT 5 C/D CORNER SEAM
SMAW welding of weld joint 39B located on SSD1-TL5-1B-F.
Welder is identified as 050289. ZPMC CWI is identified as Mr. Du Zhi Qun.
The welding variables recorded by QC appeared to comply with WPS-B-T-3212-Tc-U4b-1.

NORTH TOWER LIFT 5 GRILLAGE SADDLE BEAM REPAIR (T-CWR538, REV. 0)
SMAW welding of weld joint 4A/B(Repair) located on ND1-BPSA5-2-1.
Welder is identified as 057258. ZPMC CWI is identified as Mr. Li Lin .
The welding variables recorded by QC appeared to comply with WPS-485-SMAW-2G(2F)-REPAIR-1.

TOWER STRUT ANGLE CONNECTION PLATE (T-CWR561, REV. 0)
During random in process verification, this QA Inspector observed that SMAW welding on the base metal of

ED1-SA3-18-99M-3 of Tower Strut Angle Connection plate. Welder is identified as 040268. ZPMC CWI is identified as Mr. Gong Liang Zhu. The welding variables recorded by QC appeared to comply with WPS-485-SMAW-2G(2F)-FCM-REPAIR-1. Attached photographs provide additional details.

SOUTH TOWER LIFT 5 A/E CORNER BACKFILL PLATE AT 127M & 131M DIAPHRAGM
This QA inspector witnessed Ultrasonic Tesing (UT) performed by ZPMC NDT personnel on the weld joints of A/E corner backfill plate of South tower lift 4. The components are identified as Tower components. The weld designitions are as follows.

SSTL4-1H/L-30 (CLASS "A" INDICATION OBSERVED BY ZPMC)
SSTL4-1H/L-131 (ACCEPTED BY ZPMC)
SSTL4-1G/L-29, 98 (CLASS "A" INDICATION OBSERVED BY ZPMC)

NORTH TOWER LIFT 2
During eandom in process verification, this QA inspector observed the installation of Tower Strut plate on skin "A" of North Tower lift 5 at 65M diaphragm was in progress. Attached photographs provide additional details.

BAY 11

TOWER STRUT FLANGE
SAW welding of weld joint 3A located on ED1-STSA4-6-123M-1.
Welder is identified as 040699. ZPMC CWI is identified as Yu Dong Ping.
The welding variables recorded by QC appeared to comply with WPS-B-T-4221-B-U3c-S-1.

SAW welding of weld joint 3A located on ND1-STSA4-6-123M-1.
Welder is identified as 040699. ZPMC CWI is identified as Yu Dong Ping.
The welding variables recorded by QC appeared to comply with WPS-B-T-4221-B-U3c-S-1.

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

WELDING INSPECTION REPORT

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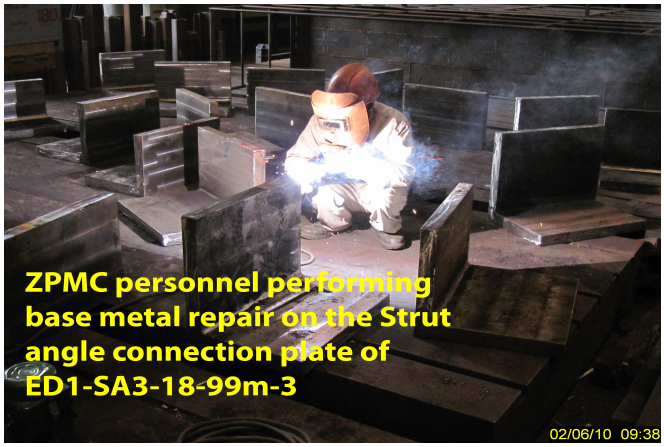

Summary of Conversations:

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.

Inspected By:	Gaikwad,Umesh	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer