DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
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-012537
Date Inspected: 21-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: Mr.You Qi Guo

Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**CWI Present:**	☑ Yes	☐ No	
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☑ 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.

IN PROCESS INSPECTION:-
TOWER TRAIL ASSEMBLY AREA:-

EAST SHAFT LIFT 1:-

This QA inspector observed the following work in progress:
FCAW welding of weld joint no: ESD1-SA233-9 located on Skin B Interior Bearing Plate. Welder is identified as 040736.ZPMC CWI is identified as Mr. You Qi Guo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

This QA inspector observed the following work in progress:
FCAW welding of weld joint no: ESD1-SA294F/G-13 located on Skin C Interior Bearing Plate. Welder is identified as 066674.ZPMC CWI is identified as Mr. You Qi Guo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F. Please see the attached picture below.

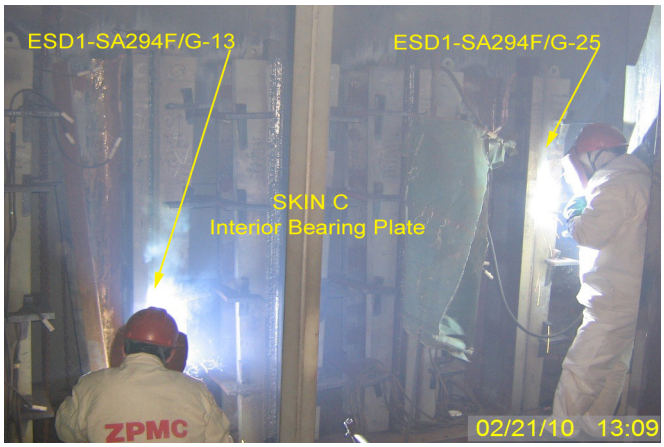
This QA inspector observed the following work in progress:
FCAW welding of weld joint no: ESD1-SA294F/G-25 located on Skin C Interior Bearing Plate. Welder is identified as 070006.ZPMC CWI is identified as Mr. You Qi Guo. The welding variables recorded by QC

appeared to comply with the WPS-B-T-2333-TC-P4-F. Please see the attached picture below.

NORTH SHAFT LIFT 1:-

This QA inspector observed the following work in progress:
ZPMC performed Weld metal repair of Bearing Plate located on Skin C (NSD1-SA17 F/G-37, 41, 44, 49, 55). The Weld metal repair area is approximately 50mm length. The material is A 709M Grade 345 Non-SPCM. Welder is identified as 040270.ZPMC QC is identified as Mr.Hegen. SMAW Welding was been performed. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G(4F)-Repair.Please see the attached picture below.

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



Summary of Conversations:
No Relevant Conversation.
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:	Pillai,Pandaram	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer