

**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-012622**Date Inspected:** 15-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**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 and OBG Components**Summary of Items Observed:**

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

**Bay 10**

This QA Inspector randomly observed no apparent welding related work being performed in Bay 10.

**Bay 11**

This QA Inspector randomly observed the following work in progress in Bay 11:

SMAW fitting and tack welding of weld joint ND1-STSA4-6-135M-1-213B located on PCMK north tower, lift 4, sstrut plate. Welder was identified as 219269. ZPMC QC was identified as CWI Yu Dong Ping (QC1). Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC CAWI Liu Dao Feng (CAWI). The welding variables recorded by CAWI appeared to comply with WPS-B-T-4211-B-U3c-1. Also present at this location and appearing to be monitoring the welding related operations was ABF Representative Xie Yan.

**Heavy Dock**

This QA Inspector randomly observed the following work in progress on the Heavy Dock:

FCAW welding of weld joint WSD1-SA279-25 located outside PCMK west tower, lift 1 base, skin B, shear plate stiffener to connection plate. Welder was identified as 068919. ZPMC QC was identified as CWI You Qi Guo

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(QC2). Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC He Gen, who was not a CWI. The welding variables recorded by QC2's assistant appeared to comply with WPS-B-T-2333-TC-P4-F. Also present at this location and appearing to be monitoring the welding related operations were ABF Representatives Li Ke Wei and Kang Yi.

FCAW welding of weld joint WSD1-SA225F/H-28 located outside PCMK west tower, lift 1 base, skin E, shear plate stiffener to connection plate. Welder was identified as 066481. ZPMC QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC He Gen, who was not a CWI. The welding variables recorded by QC2's assistant appeared to comply with WPS-B-T-2333-TC-P4-F. Also present at this location and appearing to be monitoring the welding related operations were ABF Representatives Li Ke Wei and Kang Yi.

FCAW welding of weld joint WSD1-SA225F/H-49 located outside PCMK west tower, lift 1 base, skin E, shear plate stiffener to connection plate. Welder was identified as 068493. ZPMC QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC He Gen, who was not a CWI. The welding variables recorded by QC2's assistant appeared to comply with WPS-B-T-2333-TC-P4-F. Also present at this location and appearing to be monitoring the welding related operations were ABF Representatives Li Ke Wei and Kang Yi.

FCAW welding of weld joints WSD1-SA225F/H-15, 17 located outside PCMK west tower, lift 1 base, skin E, shear plate stiffener to connection plate. Welder was identified as 070022. ZPMC QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC He Gen, who was not a CWI. The welding variables recorded by QC2's assistant appeared to comply with WPS-B-T-2333-TC-P4-F. Also present at this location and appearing to be monitoring the welding related operations were ABF Representatives Li Ke Wei and Kang Yi.

FCAW welding of weld joint ESD1-SA233-21 located outside PCMK east tower, lift 1 base, skin B, shear plate stiffener to connection plate. Welder was identified as 068206. ZPMC QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC He Gen, who was not a CWI. The welding variables recorded by QC2's assistant appeared to comply with WPS-B-T-2333-TC-P4-F. Also present at this location and appearing to be monitoring the welding related operations were ABF Representatives Li Ke Wei and Kang Yi.

FCAW welding of weld joint ESD1-SA233-27 located outside PCMK east tower, lift 1 base, skin B, shear plate stiffener to connection plate. Welder was identified as 066484. ZPMC QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC He Gen, who was not a CWI. The welding variables recorded by QC2's assistant appeared to comply with WPS-B-T-2333-TC-P4-F. Also present at this location and appearing to be monitoring the welding related operations were ABF Representatives Li Ke Wei and Kang Yi.

FCAW welding of weld joint NSD1-SA76F/H-39 located outside PCMK north tower, lift 1 base, skin E, shear plate stiffener to connection plate. Welders were identified as 053869, 040533. ZPMC QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC He Gen, who was not a CWI. The welding variables recorded by QC2's assistant appeared to comply with

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WPS-B-T-2333-TC-P4-F. Also present at this location and appearing to be monitoring the welding related operations were ABF Representatives Li Ke Wei and Kang Yi.

The tower access elevator was not manned after 2030 hours and it appeared that no work was being performed at the lift1/ lift 2 joints of either of the towers.

OBG segments 5E, 5W, and CB4 were located near the end of the heavy dock. No work was observed being performed on either OBG segments 5E, 5W, or CB4.

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

**Summary of Conversations:**

No significant 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, 150-0042-2360, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Goulet,George	Quality Assurance Inspector
<b>Reviewed By:</b>	Dawson,Paul	QA Reviewer

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