

**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-013228**Date Inspected:** 26-Mar-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>                   | Mr. Zhao Chen Sun/You Qi Guo | <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 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-SA294F/G-36 located on Skin C Bearing Stiffener. Welder is identified as 205649. ZPMC QC is identified as Mr. Xing shi shun. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F. Please see the attached picture.

This QA inspector observed the following work in progress:

FCAW welding of weld joint no: ESD1-SA294F/G-60 located on Skin C Bearing Stiffener. Welder is identified as 040713. ZPMC QC is identified as Mr. Xing shi shun. 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-73 located on Skin C Bearing Stiffener. Welder is identified as 059525. ZPMC QC is identified as Mr. Xing shi shun. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

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This QA inspector observed the following work in progress:

FCAW welding of weld joint no: ESD1-SA277F/H-33 located on Skin E Bearing Stiffener. Welder is identified as 040713.ZPMC QC is identified as Mr. Xing shi shun. 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-SA277F/H-30 located on Skin E Bearing Stiffener. Welder is identified as 049541.ZPMC QC is identified as Mr. Xing shi shun. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

## NORTH SHAFT LIFT 1:-

This QA inspector observed the following work in progress:

FCAW welding of weld joint no: NSD1-SA17F/G-27 located on Skin C Bearing Stiffener. Welder is identified as 066825.ZPMC QC is identified as Mr. Liu Zhu. 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: NSD1-SA33D/F-1 located on Skin A Bearing Stiffener. Welder is identified as 040367.ZPMC QC is identified as Mr. Liu Zhu. 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: NSD1-SA22B/E-38 located on Skin D Bearing Stiffener. Welder is identified as 066881.ZPMC QC is identified as Mr. Liu Zhu. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

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



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**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.

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

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