

**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 #: 04-0120F4Cty: 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-013263**Date Inspected:** 10-Apr-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**CWI Name:** 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 Shailesh 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 QA Inspector observed the following work in progress:

BAY 10

Repair Welding:

This QA Inspector observed ZPMC qualified welding personnel identified as 057258. Perform Shielded Metal Arc Welding (SMAW) on Skirt Plate I Ribs Build up 2 to 10mm. Joint identified as P 1795. ZPMC QC Identified as Jiang Xiao Bo. With Temporary welding repair report, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-3G (3F)-Repair.

BAY 11:

This QA Inspector observed ZPMC qualified welding personnel identified as 042195. Perform Submerged Arc Welding (SAW) on Angle connection plate. Joint identified as SD1-SA4-56-123M-1, 2, 3, 4-1B, ZPMC CWI Identified as Yu Dong Ping, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-3221-Tc-U5-S-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 040699. Perform Submerged Arc Welding (SAW) on Angle connection plate. Joint identified as SD1-SA4-56-119M-1, 2, 3, 4-1B, ZPMC CWI

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

Identified as Yu Dong Ping, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-3221-Tc-U5-S-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 044541. Perform Shielded Metal Arc Welding (SMAW) on West tower lift 4 A/E corner Back fill plate welding near 119M Top, double diaphragm. Joint identified as WSTL4-2C/L-115. ZPMC CWI Identified as Lilin, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-3212-B-U2a-2.

This QA Inspector observed ZPMC qualified welding personnel identified as 044551, 040614. Perform Shielded Metal Arc Welding (SMAW) on West tower lift 4 A/E corner Back fill plate welding near 123M Top and bottom, double diaphragm. Joint identified as WSTL4-2F/L-44, 109. ZPMC CWI Identified as Lilin, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-3213-B-U2a-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 044581. Perform Shielded Metal Arc Welding (SMAW) on West tower lift 4 A/E corner Back fill plate welding near 131M Top, double diaphragm. Joint identified as WSTL4-2H/L-68. ZPMC QC Identified as Shao Hao Long, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-3213-B-U2a-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 046709. Perform Shielded Metal Arc Welding (SMAW) on West tower lift 4 A/E corner Back fill plate welding near 135M Bottom double diaphragm. Joint identified as WSTL4-2I/L-70. ZPMC QC Identified as Shao Hao Long, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-3213-B-U2a-1

This QA Inspector observed ZPMC qualified welding personnel identified as 046706. Perform Flux Core Arc Welding (FCAW) on West tower lift 4 A/E corner Back fill plate welding. Joint identified as WSTL4-2G/L-111, 112. ZPMC QC Identified as Shao Hao Long, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-4333-Tc-P4-F, and WPS-B-T-4332-Tc-P4-F

This QA Inspector observed ZPMC qualified welding personnel identified as 040713. Perform Flux Core Arc Welding (FCAW) on Skirt Plate. Joint identified as WSD1-A-801B/D-21. ZPMC QC Identified as Xu Jin Long. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2132, and WPS-B-T-2133. For more information see below attach photo No-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 040759. Perform Flux Core Arc Welding (FCAW) on Skirt Plate. Joint identified as WD1-A597B/C-10. ZPMC QC Identified as Xu Jin Long. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2132.

During random Visual inspection This QA Inspector observed, ZPMC MT Inspector performing MT on West tower lift 4 Skin C Pad eye. For more information see below attach photo No. 2.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

---

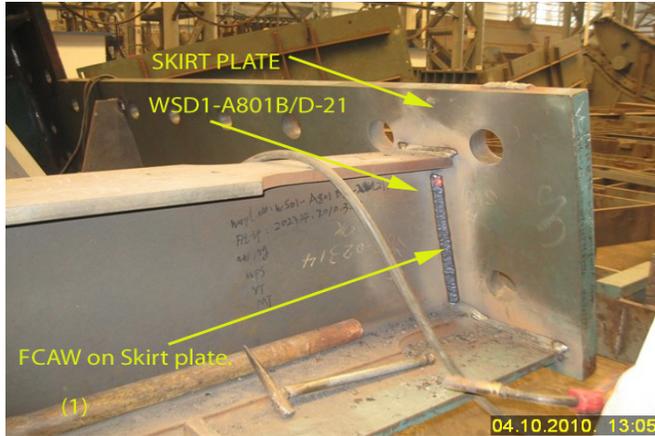
---

# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

---



## 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 phone: 15000422360, who represents the Office of Structural Materials for your project.

---

**Inspected By:** Gaikwad,Shailesh

Quality Assurance Inspector

---

**Reviewed By:** Clifford,William

QA Reviewer