

**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-013277**Date Inspected:** 16-Feb-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, Li Lin**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 4, FIT LUG ON SKIN E

FCAW welding of weld joint 94 located on SSTL4-1J/L.

Welder is identified as 066733. ZPMC CWI is identified as Mr. Liu Zhong An.

The welding variables recorded by QC appeared to comply with WPS-B-T-2333-Tc-P4-F.

FCAW welding of weld joint 95 located on SSTL4-1K/L.

Welder is identified as 066733. ZPMC CWI is identified as Mr. Liu Zhong An.

The welding variables recorded by QC appeared to comply with WPS-B-T-4333-Tc-P4-F.

FCAW welding of weld joint 28 located on SSTL4-1F/L.

Welder is identified as 066477. ZPMC CWI is identified as Mr. Gong Liang Zhu.

The welding variables recorded by QC appeared to comply with WPS-B-T-2333-Tc-P4-F.

# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

FCAW welding of weld joint 97 located on SSSL4-1G/L.

Welder is identified as 066477. ZPMC CWI is identified as Mr. Gong Liang Zhu.

The welding variables recorded by QC appeared to comply with WPS-B-T-4333-Tc-P4-F.

## NORTH TOWER LIFT 4, B/C CORNER SEAM REPAIR

SMAW welding of weld joint 5A/B(Repair) located on NSTL4-3B/L.

Welder is identified as 057258. ZPMC CWI is identified as Mr. Du Zhi Qun.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G(2F)-REPAIR.

## SOUTH TOWER LIFT 4, BASE METAL REPAIR

During random in process Visual Inspection this Quality Assurance (QA) Inspector observed that ZPMC personnel performing base metal repair welding on skin A of South Tower lift 4. Welder is identified as 056364. ZPMC QC is identified as Jiang La Mei. The welding variables recorded by QC appeared to comply with WPS-485-SMAW-2G(2F)-REPAIR-1. Attached photographs provide additional details.

## BAY 11

## WEST TOWER LIFT 4, B/C CORNER SEAM REPAIR (T-CWR569, REV. 0, Y=6500)

SMAW welding of weld joint 58A/B(Repair) located on WSTL4-2B/L.

Welder is identified as 066038. ZPMC CWI is identified as Mr. Li Lin.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G(2F)-REPAIR.

## TOWER STRUT ANGLE CONNECTION PLATE

SAW welding of weld joint 1B located on ED1-SA4-68-135M-6.

Welder is identified as 040699. ZPMC QC is identified as Mr. Mao Bin Bin.

The welding variables recorded by QC appeared to comply with WPS-B-T-3221-Tc-U5-S-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with 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 : 15000422360, who represents the Office of Structural Materials for your project.

---

|                      |                  |                             |
|----------------------|------------------|-----------------------------|
| <b>Inspected By:</b> | Gaikwad,Umesh    | Quality Assurance Inspector |
| <b>Reviewed By:</b>  | Clifford,William | QA Reviewer                 |

---