

**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-013279**Date Inspected:** 19-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**

NORTH TOWER LIFT 4, C/D CORNER SEAM REPAIR (T-CWR533, REV. 2, Y=10600)

FCAW welding of weld joint 1A/B(Repair) located on NSTL4-3B/L.

Welder is identified as 040434. ZPMC CWI is identified as Mr. Du Zhi Qun.

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

NORTH TOWER LIFT 4, C/D CORNER SEAM REPAIR (T-CWR533, REV. 2, Y=2280)

SMAW welding of weld joint 1A/B(Repair) located on NSTL4-3B/L.

Welder is identified as 052930. 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.

**BAY 10, NORTH TOWER LIFT 3~4, BC AND CD CORNER SPLICE ASSEMBLY**

# WELDING INSPECTION REPORT

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During random in process Quality Assurance (QA) inspection this QA inspector witnessed Magnetic Particle testing (MT) performed by ZPMC NDT technician on the weld joints of BC and CD corner splice assembly of North Tower lift 3~4. The components are identified as Tower components and the weld designation are identified as follows.

NSD1-SPSA4-16-1A/B, 2A/B

NSD1-SPSA4-15-1A/B, 2A/B

BAY 11

EAST TOWER LIFT 5, A/E CORNER SEAM

SMAW welding of weld joint 36A located on ESD1-TL5-2B/F.

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

The welding variables recorded by QC appeared to comply with WPS-B-T-3212-Tc-U5b-1.

SMAW welding of weld joint 3A located on ESD1-TL5-2B/F.

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

The welding variables recorded by QC appeared to comply with WPS-B-T-3212-Tc-U5b-1.

TOWER STRUT ANGLE CONNECTION PLATE

SAW welding of weld joint 1B located on ND1-SA4-68-139M-1.

Welder is identified as 042195. 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.

SAW welding of weld joint 1B located on ED1-SA4-68-143M-2.

Welder is identified as 041716. 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.



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# WELDING INSPECTION REPORT

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## 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.

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

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