

**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-013287**Date Inspected:** 09-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**CWI Name:** Yu Dong Ping, Tu Jun**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:

Bay 11 East Tower Lift 5

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% and random Visual Testing (VT) of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT reports for this date. The members are identified as Tower Components. The weld designations reviewed are as follows.

ESD1-TL5-2B/F-16A/B, 39A/B (C/D CORNER SEAM)

ESD1-TL5-2C/F-7A/B, 8A/B (BUTT JOINT OF SKIN)

ESD1-TL5-2E/F-25A/B (BUTT JOINT OF SKIN)

This Quality Assurance (QA) Inspector observed the following work in progress:

Bay 10

SOUTH TOWER LIFT 5

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## WELDING INSPECTION REPORT

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SAW welding of weld joint 21B located on SSD1-TL5-1B-F.

Welder is identified as 040414. ZPMC QC is identified as Mr. Wang Hao.

The welding variables recorded by QC appeared to comply with WPS-B-T-3221-B-U3c-S-1.

### SOUTH TOWER LIFT 5, C/D CORNER

SAW welding of weld joint 39A located on SSD1-TL5-1B-F.

Welder is identified as 040460. ZPMC CWI is identified as Mr. Deng Zhi Bing.

The welding variables recorded by QC appeared to comply with WPS-B-T-3221-C-U2b-S.

### BAY 11

#### TOWER STRUT FLANGE PLATE

SAW welding of weld joint 3A located on ED1-STSA4-6-131M-1.

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-4221-B-U3c-S-1.

SAW welding of weld joint 3A located on ND1-STSA4-6-127M-2.

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-4221-B-U3c-S-1.

#### STRUT ANGLE CONNECTION PLATE

SMAW welding of weld joint 1A located on WD1-SA4-56-119M-2.

Welder is identified as 041271. ZPMC QC is identified as Mr. Liu Dao Feng.

The welding variables recorded by QC appeared to comply with WPS-B-T-3211-Tc-U5b-1.

SMAW welding of weld joint 1A located on WD1-SA4-56-119M-4.

Welder is identified as 040667. ZPMC QC is identified as Mr. Liu Dao Feng.

The welding variables recorded by QC appeared to comply with WPS-B-T-3211-Tc-U5b-1.

#### PHASED ARRAY ULTRASONIC TESTING (PAUT) TRAINING

This QA inspector attend the Phased Array Ultrasonic Testing (PAUT) training session organized by ASNT level III.

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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**Inspected By:** Gaikwad, Umesh

Quality Assurance Inspector

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**Reviewed By:** Clifford, William

QA Reviewer