

**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-013304**Date Inspected:** 19-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:** Zhao Chen Sun**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:

**TOWER JETTY (TRIAL ASSEMBLY AREA)****EAST TOWER LIFT 1, SKIN D BEARING STIFFENER**

FCAW welding of weld joint 6 located on ESD1-SA296B/E.

Welder is identified as 040713. ZPMC CWI is identified as Mr. Zhao Chen Sun.

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

**WEST TOWER LIFT 1, SKIN C BEARING STIFFENER**

FCAW welding of weld joint 33 located on WSD1-SA294F/G.

Welder is identified as 070397. ZPMC QC is identified as Mr. Hegen.

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

**WEST TOWER LIFT 1, SKIN D BEARING STIFFENER**

FCAW welding of weld joint 32 located on WSD1-SA295B/E.

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Welder is identified as 054459. ZPMC QC is identified as Mr. Hegen.

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

### WEST TOWER LIFT 1, SKIN E BEARING STIFFENER

FCAW welding of weld joint 44 located on WSD1-SA225F/H.

Welder is identified as 068916. ZPMC QC is identified as Mr. Hegen.

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

### NORTH TOWER LIFT 1, SKIN C BEARING STIFFENER

FCAW welding of weld joint 31 located on NSD1-SA17F/G.

Welder is identified as 057266. ZPMC QC is identified as Mr. Liu Zhi.

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

### NORTH TOWER LIFT 1, SKIN E BEARING STIFFENER

FCAW welding of weld joint 57 located on NSD1-SA76F/H.

Welder is identified as 069043. ZPMC QC is identified as Mr. Liu Zhi.

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

### NORTH TOWER LIFT 1, SKIN B BEARING STIFFENER

FCAW welding of weld joint 20 located on NSD1-SA11.

Welder is identified as 053116. ZPMC QC is identified as Mr. Liu Zhi.

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

### SOUTH TOWER LIFT 1, SKIN C BEARING STIFFENER

FCAW welding of weld joint 66 located on SSD1-SA17F/G.

Welder is identified as 068924. ZPMC QC is identified as Mr. Fu Wei Mein.

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

### SOUTH TOWER LIFT 1, SKIN B BEARING STIFFENER

FCAW welding of weld joint 34 located on SSD1-SA18.

Welder is identified as 066825. ZPMC QC is identified as Mr. Fu Wei Mein.

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

### PHASED ARRAY ULTRASONIC TESTING (PAUT) TRAINING

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

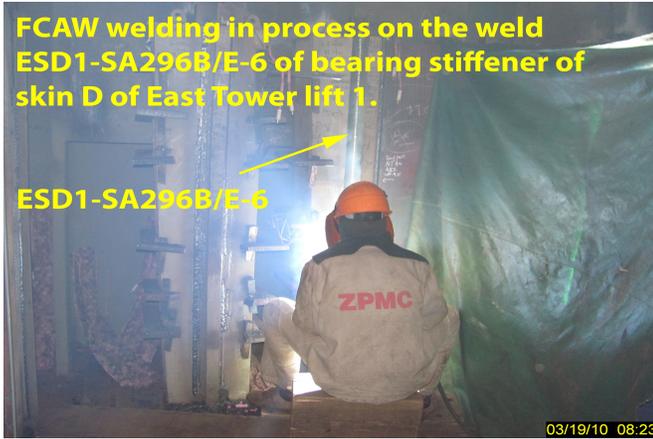
Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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## 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