

**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-013311**Date Inspected:** 11-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:** 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:

## East Tower Lift 5

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated UT report for this date. The members are identified as Tower Components. The weld designations reviewed are as follows.

ESD1-TL5-2B/F-20A/B

ESD1-TL5-2B/F-21A/B

## Tower Lift 4 Strut Plate

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated UT report for this date. The members are identified as Tower Components. The weld designations reviewed are as follows.

ND1-SA4-68-131M-3-1A/B

---

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

---

ND1-SA4-68-131M-4-1A/B  
ND1-SA4-68-131M-5-1A/B  
ND1-SA4-68-131M-6-1A/B  
ND1-SA4-68-131M-7-1A/B  
ND1-SA4-68-131M-8-1A/B

West Tower Lift 4, Padeyes on skin C, D, E (GREEN TAG NO. 12493)

This QA inspector performed green tagging for the following components. The components are identified as Padeyes on skin C, D, E of West Tower lift 4. The weld designations are identified as follows.

WSD1-FDSA4-4A/D-25~36  
WSD1-FCSA4-2A/C-88~99  
WSD1-FESA4-4A/F-28~39, 44~47

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

BAY 10

NORTH TOWER LIFT 5, CD CORNER

SAW welding of weld joint 37A located on NSD1-TL5-3B-F.

Welder is identified as 209051. ZPMC QC is identified as Mr. Li Peng Fei.

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

BAY11

STRUT ANGLE CONNECTION PLATE

SMAW welding of weld joint 1B located on WD1-SA4-56-139M-1.

Welder is identified as 040656. ZPMC CWI is identified as Yu Dong Ping.

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-SA4-56-143M-1.

Welder is identified as 040614. ZPMC CWI is identified as Yu Dong Ping.

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

PADEYE ON TOWER SKIRT PLATE

SMAW welding of weld joint 34 located on WD1-A597A/C.

Welder is identified as 040655. ZPMC QC is identified as Mr. Li Bin.

The welding variables recorded by QC appeared to comply with WPS-B-P-2112-PADEYE.

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

---