

**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-013546**Date Inspected:** 30-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

<b>CWI Name:</b>	Li Lin			<b>CWI Present:</b>	Yes	No	
<b>Inspected CWI report:</b>	Yes	No	N/A	<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A	<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A	<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A	<b>Approved WPS:</b>	Yes	No	N/A
				<b>Delayed / Cancelled:</b>	Yes	No	N/A
<b>Bridge No:</b>	34-0006			<b>Component:</b>	Tower Components		

**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

BAY#11

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 005636

Visual Inspection Testing (VT)

This QA inspector performed VT of the area previously tested and accepted by ZPMC Quality Control personnel. The member is identified as Tower Component. The identified component and weld designations reviewed are as follows:

EAST TOWER LIFT 4 FITLUG OF SKIN 'D' &amp; 'E'

ESTL4 - 2C/L - 117; 118; 119

EAST TOWER LIFT 4 BACK FILL PLATE WITH SKIN 'D' &amp; 'E'

ESTL4 - 2G/L - 120; 122

EAST TOWER LIFT 4 DIAPHRAGM &amp; STIFFENER &amp; SKIN 'D' &amp; 'E'

ESTL4 - 2F/L - 128; 124; 115; 116

ESTL4 - 2G/L - 70; 54; 127; 117; 112

EAST TOWER LIFT 4 BACK FILL PLATE BUTT JOINT OF D/E CORNER

ESTL4 - 2C/L - 125

---

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

---

ESTL4 – 2G/L – 57

EAST TOWER LIFT 4 WEB PLATE WITH SKIN ‘E’

ESTL4 – 2G/L – 51; 52

EAST TOWER LIFT 4 CONNECTION PLATE OF SKIN ‘D’

ESTL4 – 2G/L – 65; 59

### Magnetic Particle Testig (MT)

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member is identified as Tower Component. The weld designation reviewed as follows:

EAST TOWER LIFT 4 FITLUG OF SKIN ‘D’ & ‘E’

ESTL4 – 2C/L – 117; 118; 119

EAST TOWER LIFT 4 BACK FILL PLATE WITH SKIN ‘D’ & ‘E’

ESTL4 – 2G/L – 120; 122

EAST TOWER LIFT 4 DIAPHRAGM & STIFFENER & SKIN ‘D’ & ‘E’

ESTL4 – 2F/L – 128; 124; 115; 116

ESTL4 – 2G/L – 70; 54; 127; 117; 112

EAST TOWER LIFT 4 WEB PLATE WITH SKIN ‘E’

ESTL4 – 2G/L – 51; 52

EAST TOWER LIFT 4 CONNECTION PLATE OF SKIN ‘D’

ESTL4 – 2G/L – 65; 59

### Ultrasonic Testing (UT)

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member is identified as Tower Component. The weld designations reviewed are as follows:

EAST TOWER LIFT 4 BACK FILL PLATE BUTT JOINT OF D/E CORNER

ESTL4 – 2C/L – 125

ESTL4 – 2G/L – 57

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 005638

### Visual Inspection Testing (VT)

This QA inspector performed VT of the area previously tested and accepted by ZPMC Quality Control personnel. The member is identified as Tower Component. The identified component and weld designations reviewed are as follows:

EAST TOWER LIFT 4 FITLUG OF SKIN ‘D’ & ‘E’

ESTL4 – 2G/L – 55; 119

EAST TOWER LIFT 4 FITLUG OF SKIN ‘D’ & ‘E’ 123M DIAPHRAGM

ESTL4 – 2G/L – 133; 125; 123; 113

EAST TOWER LIFT 4 FITLUG OF SKIN ‘D’ & ‘E’ 127M DIAPHRAGM

ESTL4 – 2G/L – 68; 63; 30; 48; 114; 128; 131; 133

EAST TOWER LIFT 4 BACK FILL PLATE BUTT JOINT OF D/E CORNER

ESTL4 – 2F/L – 60

---

---

## WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

---

### Magnetic Particle Testig (MT)

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member is identified as Tower Component. The weld designation reviewed as follows:

EAST TOWER LIFT 4 FITLUG OF SKIN 'D' & 'E'

ESTL4 – 2G/L – 55; 119

EAST TOWER LIFT 4 FITLUG OF SKIN 'D' & 'E' 123M DIAPHRAGM

ESTL4 – 2G/L – 133; 125; 123; 113

EAST TOWER LIFT 4 FITLUG OF SKIN 'D' & 'E' 127M DIAPHRAGM

ESTL4 – 2G/L – 68; 63; 30; 48; 114; 128; 131; 133

### Ultrasonic Testing (UT)

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member is identified as Tower Component. The weld designations reviewed are as follows:

EAST TOWER LIFT 4 BACK FILL PLATE BUTT JOINT OF D/E CORNER

ESTL4 – 2F/L – 60

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

### Summary of Conversations:

No Relevant Conversations.

### 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>	Kumar,Sandeep	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

---