**DEPARTMENT OF TRANSPORTATION**
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

# WELDING INSPECTION REPORT

**Resident Engineer:** Pursell, Gary
**Address:** 333 Burma Road
**City:** Oakland, CA 94607

**Report No:** WIR-014137
**Date Inspected:** 23-Apr-2010

**Project Name:** SAS Superstructure
**Prime Contractor:** American Bridge/Fluor Enterprises, a JV
**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

**OSM Arrival Time:** 700
**OSM Departure Time:** 1900
**Location:** Shanghai,China

**CWI Name:** Mr.You Qi Guo

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| **Inspected CWI report:** | ☐ Yes | ☑ No | ☐ N/A | **CWI Present:** | ☑ Yes | ☐ No | |
| **Electrode to specification:** | ☑ Yes | ☐ No | ☐ N/A | **Rod Oven in Use:** | ☑ Yes | ☐ No | ☐ N/A |
| **Qualified Welders:** | ☑ Yes | ☐ No | ☐ N/A | **Weld Procedures Followed:** | ☑ Yes | ☐ No | ☐ N/A |
| **Approved Drawings:** | ☑ Yes | ☐ No | ☐ N/A | **Verified Joint Fit-up:** | ☑ 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 date Caltrans OSM Quality Assurance (QA) Inspector, Nagalingam Pandaram Pillai was present during the times noted above for observations relative to the work being performed.

Magnetic Particle Testing:-
BAY #11:-
This QA inspector performed Magnetic Particle Testing (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 West Tower Lift 5 Skin Plate and “AB” Corner Seam. The weld designations reviewed are as follows:-

WSD1-TL5-4D/F-34,35A/B
WSD1-TL5-4C/F-7,9A/B
WSD1-TL5-4B/F-20A/B, 32AB

IN PROCESS INSPECTION:-
TOWER TRAIL ASSEMBLY AREA:-

EAST SHAFT LIFT 1:-
This QA inspector observed the following work in progress:
FCAW welding of weld joint no: ESD1-SA227F/H-34 located on Skin E Bearing Stiffener. Welder is identified as 049220.ZPMC QC is identified as Mr. Fu wei min. The welding variables recorded by QC appeared to comply

with the WPS-B-T-2333-TC-P4-F.

This QA inspector observed the following work in progress:
FCAW welding of weld joint no: ESD1-SA227F/H-43 located on Skin E Bearing Stiffener. Welder is identified as 040723.ZPMC QC is identified as Mr. Fu wei min. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

This QA inspector observed the following work in progress:
FCAW welding of weld joint no: ESD1-SA227F/H-46 located on Skin E Bearing Stiffener. Welder is identified as 205649.ZPMC QC is identified as Mr. Fu wei min. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

SOUTH SHAFT LIFT 1:-

This QA inspector observed the following work in progress:
FCAW welding of weld joint no: SSD1-SA16F/G-35 located on Skin E Bearing Stiffener. Welder is identified as 053869.ZPMC CWI is identified as Mr. You Qi Guo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

This QA inspector observed the following work in progress:
FCAW welding of weld joint no: SSD1-SA16F/G-55 located on Skin E Bearing Stiffener. Welder is identified as 054069.ZPMC CWI is identified as Mr. You Qi Guo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

This QA inspector observed the following work in progress:
ZPMC performed Buttering on North Shaft Skin “D” Bearing Stiffener (NSD1-SA22B/E-23,20).The Buttering area is 10mm thick. The material is A 709M Grade 345 Non-SPCM. Welder is identified a 040581.ZPMC CWI is identified as Mr. Zhao Chen Shun. SMAW welding was been performed against Weld repair report T-WR3200. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F)-Repair.

This QA inspector observed the following work in progress:
SMAW Welding of weld joint no: SSD1-A111A/H-3A/B  located on Shear Plate. Welder is identified as 040690. ZPMC CWI is identified as Mr.Qiu Wen. Welding was been performed against Weld Repair Report T-WR3202 and UT report number: T787-UT-2764-R1.The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G(3F)-Repair.

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

# WELDING INSPECTION REPORT

*( Continued Page 3 of 3 )*

**Summary of Conversations:**

No Relevant Conversation.

**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:** | Pillai,Pandaram | Quality Assurance Inspector |
| **Reviewed By:** | Clifford,William | QA Reviewer |