

**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-014151**Date Inspected:** 14-May-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>	Mr. An Qing Xiang/Gao Shi Shun	<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				

**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 Tower Skirt Plate. The weld designations reviewed are as follows:-

ED1-A146-2A/B, 3

**IN PROCESS INSPECTION:-**

BAY #11:-

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: ED1-STSA4-10-119M-1-36B located on Strut Plate. Welder is identified as 046769. ZPMC QC is identified as Mr. Mao Bin Bin. The welding variables recorded by QC appeared to comply with the WPS-B-T-3212-TC-U5b-1.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: ND1-STSA4-10-119M-1-8A located on Strut Plate. Welder is identified as

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041271.ZPMC QC is identified as Mr.Mao Bin Bin. The welding variables recorded by QC appeared to comply with the WPS-B-T-3212-TC-U5b-1.

This QA inspector observed the following work in progress:

FCAW welding of weld joint no: WD1-A21A/B-42 located on Bearing stiffener Plate. Welder is identified as 053316.ZPMC QC is identified as Mr.Xu Jie. The welding variables recorded by QC appeared to comply with the WPS-B-T-2331-TC-P4-F.

This QA inspector observed the following work in progress:

FCAW welding of weld joint no: WD1-A21A/B-30 located on Bearing stiffener Plate. Welder is identified as 040723.ZPMC QC is identified as Mr. Xu Jie. The welding variables recorded by QC appeared to comply with the WPS-B-T-2331-TC-P4-F.

This QA inspector observed the following work in progress:

SMAW Welding of weld joint no: ND1-STSA4-6-131M-2-5B located on Strut Plate. Welder is identified as 040655. ZPMC QC is identified as Mr.Liu Dao Feng. Welding was been performed against Temporary Welding Repair Report and UT report number- T787-UT-3490.The welding variables recorded by QC appeared to comply with the WPS-485-SMAW-2G(2F)-Repair.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: WD1-STSA4-5-131M-1-7B located on Strut Plate. Welder is identified as 040611.ZPMC CWI is identified as Mrs.Yu dong Ping. The welding variables recorded by QC appeared to comply with the WPS-B-T-2212-TC-U5b.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: SD1-STSA4-5-143M-1-48B located on Strut Plate. Welder is identified as 046704.ZPMC CWI is identified as Mrs.Yu dong Ping. The welding variables recorded by QC appeared to comply with the WPS-B-T-3212-TC-U5b-1.

During a random Quality Assurance (QA) in process verification at Bay #11, this QA Inspector observed that ZPMC was performing thermal cutting on Base Shear Plate Face A1 Assembly. The Shear Plate Stiffener weld Joint numbers SD1-A20B/B-9, 10, 11, 12, 25,26, 27 and 28 were removed by ZPMC without the Engineer's approval. These Shear Plates have been VT, MT tested and Green Tag number 5907 was issued prior to cutting apart these welds.Incident report for the same has been raised.For further information, please see the attached pictures.

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

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## Summary of Conversations:

The incident report is issued for the above mentioned discrepancy observed in Bay#11 Shear Plate Stiffener removal and prior to issue it was informed to ZPMC QC and ABF QA.

## 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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<b>Inspected By:</b>	Pillai,Pandaram	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

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