

**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-014241**Date Inspected:** 20-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	Xu Xian Ping	<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>		

**Summary of Items Observed:**

This inspector performed magnetic particle inspection, MT, on tower shear plate A28 bearing plate, in accordance with NWIT 057843. This inspection was after acceptance by ZPMC personnel. This inspector noted and indication measuring approximately 4mm in length at the bearing plate end of weld 31. ZPMC attempted to lightly grind to remove the indication, but was unsuccessful. After this investigation by grinding, ZPMC cancelled the above mentioned NWIT and plans to resubmit after repair.

This inspector noted FCAW welding of WD1-A22 A/B- 16. The welding procedure was identified as WPS-B-T-2331-Tc-P4-F. The ZPMC QC was identified as Yuan Hui Gang. The ZPMC CWI was identified as Li Lin. The welder was identified as 052075.

This inspector noted FCAW welding of SPSA4-22, and SPSA4-18 pursuant to a weld repair report labeled T-WR. The welding procedure was identified as WPS-345-FCAW-3G (3F)-Repair. The ZPMC QC was identified as Yuan Hui Gang. The ZPMC CWI was identified as Li Lin. The welders were identified as 054069, 040533, 053116, and 057180.

This inspector assisted in the performance of an after blast VT in accordance with ZPMC Notification # T-430 for an Internal VT inspection. This inspection included points from 47.6M-38M DD on North Tower Lift #1 inside Blast Shop #1. Various rejectable conditions were noted during this inspection including: areas of insufficient blasting, gouge marks in the steel, and foreign material in cope holes. Areas noted during this inspection were marked directly on the steel for repair and rework by ZPMC personnel.

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Unless otherwise noted, all work observed on this date appeared to be in general compliance with the 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 Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Barrentine, Daniel	Quality Assurance Inspector
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<b>Reviewed By:</b>	Carreon, Albert	QA Reviewer
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