

**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-014399**Date Inspected:** 21-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. Zhao Chen Sun/An Qing Xian			<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:-

TOWER TRAIL ASSEMBLY:-

EAST SHAFT LIFT 1:-

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 East Shaft Lift 1 Ladder Connection Plate and Doubler Strut Plate. The weld designations reviewed are as follows:-

ESD1-A167A/H-9,10,11,12

ESD1-A167G/H-136,137,138,139

ESD1-A167G/H-166,167,160,276

P475-E-1,2,3,4,5,6

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 A29 Shear Plate to Base Plate and Shear Plate Bearing Stiffeners. The weld designations reviewed are as follows:-

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ED1-A29A/B-76,55,64,68,71.

IN PROCESS INSPECTION:-  
TOWER TRAIL ASSEMBLY:-

This QA inspector observed the following work in progress:

FCAW welding of weld joint no: SSD1-SA173-5 located on South Shaft Lift 1 Facade Plate at 33M Elevation.

Welder is identified as 040302.ZPMC QC is identified as Mr.Wang Chaung Xin. The welding variables recorded by QC appeared to comply with the WPS-B-T-2131.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: SSD1-SA173-6 located on South Shaft Lift 1 Facade Plate at 23M Elevation.

Welder is identified as 053049.ZPMC QC is identified as Mr.Wang Chaung Xin. The welding variables recorded by QC appeared to comply with the WPS-B-T-2114.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: SSD1-SA173-13 located on South Shaft Lift 1 Facade Plate at 38M Elevation.

Welder is identified as 040302.ZPMC QC is identified as Mr.Wang Chaung Xin. The welding variables recorded by QC appeared to comply with the WPS-B-T-2114.

This QA inspector observed the following work in progress:

ZPMC performed weld repair on Temporary attachment removal area of South Shaft Lift 1 located on Skin B (47.6M Elevation). The base metal repair areas were approximately 3mm depth and 100mm, 85mm length at 2 random locations. The material is A 709M Grade 345 Non-SPCM. Welder is identified as 500363.ZPMC QC is identified as Mr.Zhu Feng. SMAW welding was been performed against Temporary weld repair report. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G(3F)-Repair.Please see the attached picture.

This QA inspector observed the following work in progress:

ZPMC performed repair on Temporary attachment removal area. SMAW welding of weld joint no:

SSD1-A11B/H-126A/B located on South Shaft Lift 1 CD Corner Seam. Welder is identified as 040582. ZPMC

CWI is identified as Mr.Qiu wen. SMAW welding was been performed against Temporary weld Repair Report .

The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G(4F)-Repair.Please see the attached picture.

BAY#11:-

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: ND1-STSA4-10-119M-1-7B located on Strut Plate. Welder is identified as

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.

SMAW welding of weld joint no: ND1-STSA4-6-123M-1-97 located on Strut Plate. Welder is identified as

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040655.ZPMC QC is identified as Mr.Mao Bin Bin. The welding variables recorded by QC appeared to comply with the WPS-B-T-2112.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: ED1-STSA4-6-143M-1-73A located on Strut Plate. Welder is identified as 044551.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.

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



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

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