

**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-014576**Date Inspected:** 27-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. Qiu wen/An qing Xiang	<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 West Tower Lift 4 Fit Lug of Skin A, B, C, D, E and back fill Plates at 131M elevation. The weld designations reviewed are as follows:-

WSTL4-H/L-7,8,17,20,27,28,31,33,47,49,53,59,60,67,78,80,81,88,90,92,94,100,101,103,116,117,120,121,125,126,130.

**IN PROCESS INSPECTION:-**

Trail Assembly Area:-

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: WD1- GUSA3-3-53M-E-4B located on Cross Bracing Gusset Plate with Skin A. Welder is identified as 040655. ZPMC CWI is identified as Mr. Qiu Wen. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-TC-U5b-FCM.

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## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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This QA inspector observed the following work in progress:

SMAW welding of weld joint no: WD1- GUSA3-3-53M-W-4B located on Cross Bracing Gusset Plate with Skin A. Welder is identified as 202323.ZPMC CWI is identified as Mr.Qiu Wen. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-TC-U5b-FCM.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: WD1- GUSA3-3-53M-N-4B located on Cross Bracing Gusset Plate with Skin A. Welder is identified as 056200.ZPMC CWI is identified as Mr.Qiu Wen. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-TC-U5b-FCM.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: WD1- GUSA3-3-53M-S-3B located on Cross Bracing Gusset Plate with Skin E. Welder is identified as 044511.ZPMC CWI is identified as Mr.Qiu Wen. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-TC-U5b-FCM.

Bay#11

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: ED1-STSA4-6-143M-1-30 located on Strut Plate. Welder is identified as 040724.ZPMC QC is identified as Mr. Mao Bin Bin. The welding variables recorded by QC appeared to comply with the WPS-B-T-2113.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: ED1- STSA4-6-135M-2-84 located on Strut Plate. Welder is identified as 040656.ZPMC QC is identified as Mr. Mao Bin Bin. The welding variables recorded by QC appeared to comply with the WPS-B-T-4113-1.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: ED1- STSA4-6-135M-1-87 located on Strut Plate. Welder is identified as 202100.ZPMC QC is identified as Mr. Liu dao feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2112.

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

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# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

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## 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

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**Reviewed By:** Clifford,William

QA Reviewer