**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 #: 04-0120F4
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-014580
**Date Inspected:** 31-May-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:** 900
**OSM Departure Time:** 1900
**Location:** Shanghai,China

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| **CWI Name:** | Mr.An Qing Xiang/Qiu wen | **CWI Present:** | ☑ Yes ☐ No |
| **Inspected CWI report:** | ☐ Yes ☑ No ☐ N/A | **Rod Oven in Use:** | ☑ Yes ☐ No ☐ N/A |
| **Electrode to specification:** | ☑ Yes ☐ No ☐ N/A | **Weld Procedures Followed:** | ☑ Yes ☐ No ☐ N/A |
| **Qualified Welders:** | ☑ Yes ☐ No ☐ N/A | **Verified Joint Fit-up:** | ☑ Yes ☐ No ☐ N/A |
| **Approved Drawings:** | ☑ 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:-
Trail Assembly Area:-
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 Tower Lift 2 Cable Tray Support. The weld designations reviewed are as follows:-

B22-2-EL54.773M-1-1-E
B22-2-EL54.773M-1-2-E
B22-2-EL54.773M-2-1-E
B22-2-EL54.773M-2-2-E
B22-2-EL55.822M-1-1-E
B22-2-EL55.822M-1-2-E
B22-2-EL55.822M-2-1-E
B22-2-EL55.822M-2-2-E
B22-2-EL56.222M-1-1-E
B22-2-EL56.222M-1-2-E
B22-2-EL56.222M-2-1-E
B22-2-EL56.222M-2-2-E

IN PROCESS INSPECTION:-
Bay#10:-
This QA inspector observed the following work in progress:
FCAW welding of weld joint no: ED1-A27B/E-83 located on Shear Plate Bearing Stiffeners. Welder is identified as 057258.ZPMC CWI is identified as Mr. You Qi Guo. 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: ED1-A27B/E-82 located on Shear Plate Bearing Stiffeners. Welder is identified as 057280.ZPMC CWI is identified as Mr. You Qi Guo. 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: SSD1-SPSA5-16-2A located on Lift 5 Interior Splice Plate. Welder is identified as 050289.ZPMC CWI is identified as Mr. Tu Jun. The welding variables recorded by QC appeared to comply with the WPS-B-T-3211-TC-U5b-1.

This QA inspector observed the following work in progress:
SMAW welding of weld joint no: SSD1-SPSA5-19-1B located on Lift 5 Interior Splice Plate. Welder is identified as 052930.ZPMC CWI is identified as Mr. Tu Jun. The welding variables recorded by QC appeared to comply with the WPS-B-T-3211-TC-U5b-1.

Bay#11:-

This QA inspector observed the following work in progress:
SMAW welding of weld joint no: ED1-STSA4-6-139M-1-6A/B located on Strut Plate. Welder is identified as 044541. ZPMC QC is identified as Mr.Mao Bin Bin. Welding was been performed against Weld Repair Report T-WR3258 and UT report number- T787-UT-2887.The welding variables recorded by QC appeared to comply with the WPS-485-SMAW-2G(2F)-FCM-Repair-1.

This QA inspector observed the following work in progress:
SMAW welding of weld joint no: WD1-STSA4-5-139M-1-48B located on Strut Plate. Welder is identified as 040619.ZPMC QC is identified as Mr. Liu Dao Feng. 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-1-20 located on Strut Plate. Welder is identified as 040614.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:
FCAW welding of weld joint no: WD1-A25B/E-87 located on Shear Plate Bearing Stiffeners. Welder is identified as 049220.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.

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