

**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-014926**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**CWI Name:** Zhou zhong hai**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:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

BAY#14

SMAW welding of weld joint 4F-190 located on PCMK SEG3004C of Segment 12AW welder is identified as 067829. ZPMC QC is identified as Mr. Zhong yong gang. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2114-FCM-1.

SMAW welding of weld joint 4F-111 located on PCMK SEG3001E of Segment 12Aw welder is identified as 047864. ZPMC QC is identified as Mr. Zhong yong gang . The welding variables recorded by QC appeared to Comply with the WPS-B-P-2114-FCM-1.

FCAW welding of weld joint 2F-009 located on PCMK SEG300C of Segment 12AW welder is identified as 062438. ZPMC QC is identified as Mr. Tao wei . The welding variables recorded by QC appeared to Comply with the WPS-B-T-2132.

FCAW welding of weld joint 2F-008 located on PCMK SEG3004G of Segment 12AW welder is identified as 020473. ZPMC QC is identified as Mr. Tao wei . The welding variables recorded by QC appeared to Comply with the WPS-B-T-2132.

FCAW welding of weld joint 2F-005 located on PCMK SEG3004L of Segment 12AW welder is identified as

---

---

# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

---

202122. ZPMC QC is identified as Mr. Tao wei . The welding variables recorded by QC appeared to Comply with the WPS-B-T-2132.

FCAW welding of weld joint 3G-002 located on PCMK SEG3006N of Segment 12CW welder is identified as 201215. ZPMC QC is identified as Mr. Tao wei . The welding variables recorded by QC appeared to Comply with the WPS-B-T-2233-B-U2-F.

## TRAIL ASSEMBLY YARD

VT inspection of Corner assembly cope holes dimension measured with ZPMC QC Mr. Zhang qiang in lift 7AW is recorded by QC appeared to comply with as per drawing.

## BLAST SHOP # 1

Caltrans Quality Assurance (QA) Inspectors performed random visual inspection of Lift 1, North tower internal surfaces from 38m Top diaphragm to 50.3m tail end of the shaft surface after grit blasting. Several weld repair points for porosity, dent have been marked by ABF Inspectors and CT Inspector Mr. Chandra (B 247). This has to be marked for Magnetic particle testing (MT) after welding. One photo which shows the weld repair for a dent of approximately 5 mm deep in Skin D, near 38m and approximately 3mm deep weld metal gouged for 100mm in length. In Skin E, near 38m. Elevation is attached with this report. It was observed that, a Bolt was entrapped in between fit lug in Skin A (AE Corner) near 38m Bottom diaphragm. Photo of the same is attached with this report. This Visual Inspection carried out along with ABF QA inspectors Mr. Don Walton, Mr. Sun and Mr. Shi stone.

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



---

# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---



## 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 Eric Tsang-15--0042-2372, who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Kumar,Chadra	Quality Assurance Inspector
----------------------	--------------	-----------------------------

---

<b>Reviewed By:</b>	McClendon,Timothy	QA Reviewer
---------------------	-------------------	-------------