

**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-014934**Date Inspected:** 10-Jun-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. An Qing Xing/Gua zhi sun	<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

Visual &amp; Magnetic Particle Testing:-

Trail Assembly Area:-

As per the NWIT # 005942 (OS2303) VT&MT performed Tower trail assembly area West Shaft Lift 1 (repair after painting) and discovered the following issues:

1. 47.6M elevation bottom diaphragm skin A item No:1 splice plate was installed.
2. 33M elevation item No:4 was not found.
3. 28M elevation bottom diaphragm skin B item No;1 was already caulked.
4. 23M elevation top diaphragm skin E item No; 8 was already caulked and Skin D item No:7 was already caulked.
5. 23M elevation bottom diaphragm skin D item No;4 was already caulked.

All other locations VT, MT 15% performed and found acceptable. It was informed to the lead Inspector for further action. For further information, please see the attached pictures.

IN PROCESS INSPECTION:-

Bay#11:-

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: ESD1-SPSA5-7-2B located on Lift 5 Interior Splice Plate. Welder is identified

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as 046709.ZPMC QC is identified as Mr. Xu Jie. 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: WSD1-TL5-4B/F-34A located on Lift 5 Grillage Plate. Welder is identified as 040619.ZPMC QC is identified as Mr. Mao Mao Zhao. The welding variables recorded by QC appeared to comply with the WPS-B-T-3213-B-U3b.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: ND1-STSA4-6-143M-1-23 located on Strut Plate. Welder is identified as 040611.ZPMC QC is identified as Mr. Liu Dao Feng. 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-2-75 located on Strut Plate. Welder is identified as 040656.ZPMC QC is identified as Mr. Liu Dao Feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2112.

This QA inspector observed the following work in progress:

ZPMC performed Buttering on Lift 5 East transverse plate. The Buttering area is 8mm thick and 300mm length. The material is A 709M Grade 485 Non-SPCM. Welder is identified as 040655.ZPMC QC is identified as Mr. Mao Mao Zhao. SMAW welding was been performed against Weld repair report T-WR3343. The welding variables recorded by QC appeared to comply with the WPS-485-SMAW-2G(2F)-Repair-1.

This QA inspector observed the following work in progress:

SMAW Welding of weld joint no: SD1-STSA4-5-119M-1-5A located on Strut Plate. Welder is identified as 040610. ZPMC CWI is identified as Mrs. Yu dong ping. Welding was been performed against temporary weld repair report. The welding variables recorded by QC appeared to comply with the WPS-485-SMAW-2G(2F)-FCM-Repair-1.

Bay#10:-

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: SSD1-SPSA5-16-1A located on Lift 5 Interior Splice Plate. Welder is identified as 050289.ZPMC QC is identified as Mr. Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS-B-T-3211-TC-U5b-1.

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

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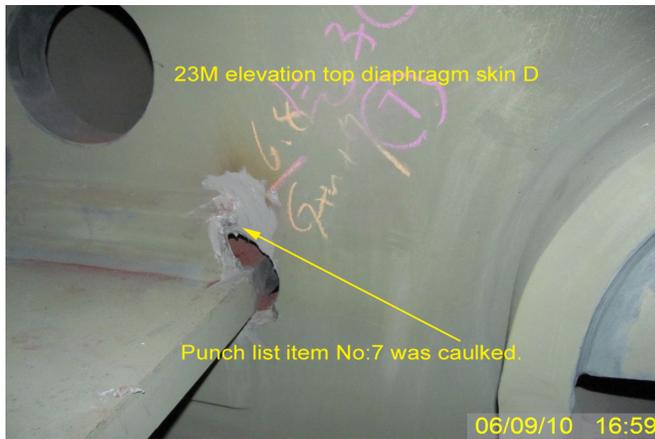
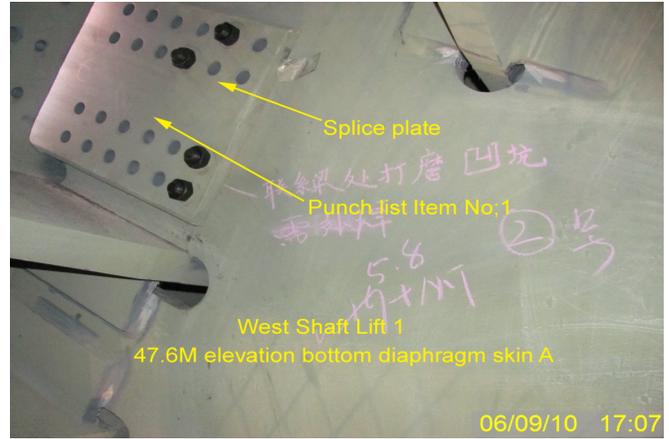
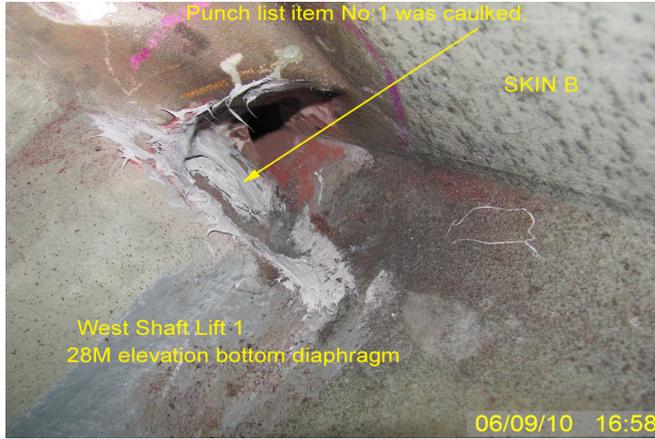
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## Summary of Conversations:

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 Mr.Micheal Ng- 159-2184-5703 , 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