**DEPARTMENT OF TRANSPORTATION**
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
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-016341
**Date Inspected:** 02-Aug-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:** 700
**OSM Departure Time:** 1900
**Location:** Shanghai, China

**CWI Name:** Zhu Le Feng

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|---|---|---|---|
| **Inspected CWI report:** | ☐ Yes | ☑ No | ☐ N/A |
| **Electrode to specification:** | ☑ Yes | ☐ No | ☐ N/A |
| **Qualified Welders:** | ☑ Yes | ☐ No | ☐ N/A |
| **Approved Drawings:** | ☑ Yes | ☐ No | ☐ N/A |

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|---|---|---|---|
| **CWI Present:** | ☑ Yes | ☐ No | |
| **Rod Oven in Use:** | ☑ Yes | ☐ No | ☐ N/A |
| **Weld Procedures Followed:** | ☑ Yes | ☐ No | ☐ N/A |
| **Verified Joint Fit-up:** | ☑ Yes | ☐ No | ☐ N/A |
| **Approved WPS:** | ☑ Yes | ☐ No | ☐ N/A |
| **Delayed / Cancelled:** | ☐ Yes | ☑ No | ☐ N/A |

**Bridge No:** 34-0006
**Component:** Tower Components

**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

BAY#10

This QA Inspector observed the following work in progress
Shielded Metal Arc Welding (SMAW):
Weld joint # 8A located on North tower Lift-5 Grillage Assembly NSD1 – TL5 – 3E/F. Welder is identified as 067707. ZPMC Quality Control (QC) Inspector is identified as Fu Wei Min. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3213 – TC – U5b.

Weld joint # 14 located on South tower Lift-5 Grillage Assembly SSD1 – TL5 – 1B/F. Welder is identified as 040273. ZPMC Quality Control (QC) Inspector is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3213 – TC – U4c.
(See attached photo)

Weld joint # 06 located on North tower Lift-5 Grillage Assembly NSD1 – TL5 – 3E/F. Welder is identified as 066443. ZPMC Quality Control (QC) Inspector is identified as Fu Wei Min. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3313 – TC – P5.

Weld joint # 5B located on North tower Lift-5 Grillage Assembly NSD1 – TL5 – 3E/F. Welder is identified as 066326. ZPMC Quality Control (QC) Inspector is identified as Fu Wei Min. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3213 – TC – U5b.

BAY#11

This QA Inspector observed the following work in progress
Shielded Metal Arc Welding (SMAW):
Weld joint # 2A located on Lift-5 Splice Plate Stiffener WSD1 – SPSA5 – 17. Welder is identified as 054465. ZPMC Quality Control (QC) Inspector is identified as Shang Hai Long. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3211 – Tc – U5b – 1.

Weld joint # 3B located on Lift-5 Splice Plate Stiffener ESD1 – SPSA5 – 17. Welder is identified as 046704. ZPMC Quality Control (QC) Inspector is identified as Shang Hai Long. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3211 – Tc – U5b – 1.

Weld joint # 1B located on Lift-5 Splice Plate Stiffener WSD1 – SPSA5 – 7. Welder is identified as 040656. ZPMC Quality Control (QC) Inspector is identified as Shang Hai Long. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3211 – Tc – U5b – 1.
(See the attached photo)

Weld joint # 25A located on East tower Lift-5 Grillage Assembly ESD1 – TL5 – 2B/F. Welder is identified as 046769. ZPMC Quality Control (QC) Inspector is identified as Xu Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3213 – TC – U5b.

Weld joint # 12A located on West tower Lift-5 Grillage Assembly WSD1 – TL5 – 4E/F. Welder is identified as 066258. ZPMC Quality Control (QC) Inspector is identified as Xu Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3213 – TC – U5b.

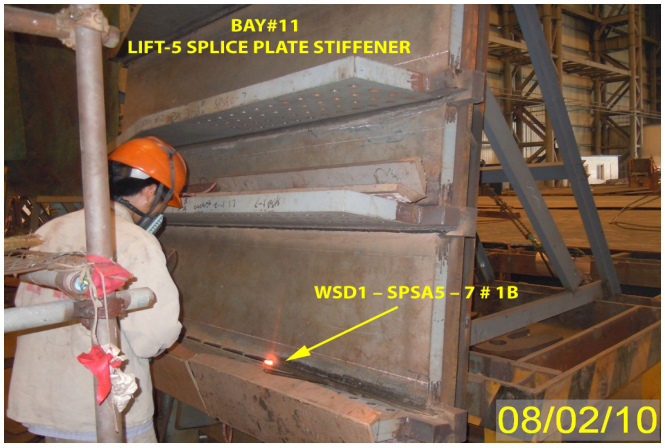
Weld joint # 26A located on East tower Lift-5 Grillage Assembly ESD1 – TL5 – 2B/F. Welder is identified as 044541. ZPMC Quality Control (QC) Inspector is identified as Xu Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3213 – TC – U5b.

Weld joint # 5B located on West tower Lift-5 Grillage Assembly WSD1 – TL5 – 4E/F. Welder is identified as 067993. ZPMC Quality Control (QC) Inspector is identified as Xu Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3213 – TC – U5b.

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 Conversations.

**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 Michael Ng - 15921845703, who represents the Office of Structural Materials for your project.

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| **Inspected By:** | Kumar,Sandeep | Quality Assurance Inspector |
| **Reviewed By:** | Clifford,William | QA Reviewer |