

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-006987**Date Inspected:** 12-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Wen wan Zhong**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, Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Bay no. 10

1. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as Mr. Wen chao (069866) perform FCAW welding on Inside North Tower skin plates to diaphragm, Lift 2, Weld joint no. NSD1-TL 8 E/L-72. ZPMC CWI Identified as Mr. Wen Wan zhong. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-4333-tc-p5-f.

2. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as Mr. Chen qiqiong (056364) perform SMAW welding on Tower strut plates, Weld joint no. ND1-A46.8-23-48. ZPMC CWI Identified as Mr. Ye yong jun. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-4113-1.

3. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as Mr. Guo liang (040453) perform SMAW Tack welding on south Tower Lift 3-BC Corner. ZPMC CWI Identified as Mr. Chen yin yin. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2214-B-U2.

4. This QA inspector, Baskar Govindarajan, observed, in Bay no. 10, North tower lift 1, between Skin A&E,

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temporary Supporting beam like structure welded with Skin A. Skin A& E found not welded. Photograph attached.
File name. 04-0120f4_05-13-09-beam_B-204

Magnetic Particle Testing:

For Green Tag

1.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 a TL-6028 MT report on this date. The member and the weld designations are as follows:

Sl.no.	Inspection part	Section
Bay no. 11		
1.	East tower fit lug Lift 2	All fit lug on skin A
2.	East tower lift 2 diaphragms	All diaphragm to Skin A welds
3.	East tower lift 2 welds	Double diaphragm web plate to Skin A&E

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



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 Serge sinevod - 134-8257-0045, who represents the Office of Structural Materials for your project.

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Inspected By:	Baskar, Govindarajan	Quality Assurance Inspector
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Reviewed By:	Clifford, William	QA Reviewer
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