

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-008212**Date Inspected:** 23-Jul-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. Wang chuan qing**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 & Tower assembly area

1. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040333 perform SMAW welding on, Strut Splice plate, Weld joint no. ED1-A 5001-16-1A. ZPMC CWI Identified as Mr. Wang chuan qing. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3211-TC-U3B-1.

2. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 207745 perform SAW welding on, Strut web plate, Weld joint no. ND1-A 6002-18-3B. ZPMC CWI Identified as Mr. Wang chuan qing. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-4221-B-U3C-S-1.

3. This QA inspector, Baskar Govindarajan, observed, at East tower Assembly area, Jetty that in Lift 1 tower, 47.6 mtr. Elevation, in complete fusion in fit lug welding, weld joint no. ESD1-A 165 H/J-134 have been attended and MT carried out as per notification no. 03759. This has been done to close NCR no. ZPMC- 0242. Please refer photo. 04-0120f4_07-23-09-Fit lug repair_B204.

4. This QA inspector, Baskar Govindarajan, observed, at East tower Assembly area, Jetty that in Lift 1 tower, 47.6

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mtr. Elevation, Tack welding has been removed in weld joint no. ESD1-SA 165 H/J-214. This has been attended and MT carried out as per notification no. 03759. This has been done to close NCR no. ZPMC- 0242. Please refer photo. 04-0120f4_07-23-09-Tack weld removal_B204.

5. This QA inspector, Baskar Govindarajan, observed, at East tower Assembly area, Jetty that in Lift 1 tower, 38 mtr. Elevation, Tack welding has been removed in weld joint no. ESD1-A 165 F/J-97. This has been attended and UT, MT carried out as per notification no. 03759. This has been done to close NCR no. NCR-ZPMC- 0247. Please refer photo. 04-0120f4_07-23-09-Tack weld removal1_B204.

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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