

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-008421**Date Inspected:** 13-Aug-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. Liu yang/ Mr. Xu le feng	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. 11

1. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 046704 perform SMAW welding on, Strut splice plate, Weld joint no. SD1-A 5002-31-1B. ZPMC CWI Identified as Mrs. Yu dong ping. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3211-TC-U5B-1.

2. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 041716 perform SAW welding on, Strut splice plate, Weld joint no. WD1-A 5007-25-1A. ZPMC CWI Identified as Mrs. Yu dong ping. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3221-TC-U5-S1.

Ultrasonic Testing:

This QA inspector, Baskar Govindarajan, performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted at Tower components by ZPMC Quality Control personnel. This QA Inspector generated a TL-6027 UT report on this date. The member and the weld designations are as follows:

WELDING INSPECTION REPORT

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Bay no. 10 & 11

Sl.no.	Inspection part	Section
1.	NSD1-A 166 C/J- 78, 203	North Tower- Lift 1
2.	NSD1-A 166 G/J-188	North Tower- Lift 1
3.	ED1-A6003-7- 5,6 A	Strut web plate
4.	ED1-A6003-8- 5,6 A	Strut web plate
5.	ED1-A6001-4- 5,6 A	Strut web plate
6.	ED1-A6001-5- 5,6 A	Strut web plate
7.	ED1-A6001-6- 5,6 A	Strut web plate

Magnetic Particle Testing:
For Green Tag

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 #	Inspection part #	Section#
1.	ESD1-FESA4-2 B/F- Jt. 9, 10, 11, 22, 23, 24	East tower, Lift 4
2.	ESD1-FESA4-2 C/F- Jt. 7, 8, 9, 14, 15, 20	East tower, Lift 4
3.	ESD1- FESA4-2 D/F- Jt. 18, 19, 20, 7, 8, 9	East tower, Lift 4
4.	ESD1-FESA4-2 E/F- Jt. 7, 8, 9	East tower, Lift 4

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.

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