

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-009915**Date Inspected:** 17-Oct-2009**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**CWI Name:** Mr. Zou liu hai**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.

Trial assembly area

1. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 062782 perform FCAW welding on, South tower, Lift 1-Skin A to Base plate. The weld joint identified as SSD1- A 111 B/H-5. ZPMC CWI Identified as Mr. Zou liu hai . The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2332-TC-P5-F. Photo attached.

2. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 216687 perform SMAW tack welding on, Platform Bracket to 53mtr. Bottom double diaphragm, South tower, lift 2 without preheating. ZPMC CWI Identified as Mr Zou liu hai. This QA inspector, Baskar Govindarajan raised incident report for the same.

Machining area

3. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 067571 perform SMAW welding on, stiffener plate, inside south tower, lift 3 on 89 mtr. Elevation diaphragm. The weld joint no. identified as SSD1-FBSA3-1 B/C-9. ZPMC CWI Identified as Mr. Zhu feng. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2113-B-U2A.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Unless otherwise noted, all work observed on this date appeared to generally comply with 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
Reviewed By:	Clifford, William	QA Reviewer
