

**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-011103**Date Inspected:** 15-Dec-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. Li lin**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.

**Heavy dock –Jetty**

1. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040704 perform FCAW welding on, inside bearing plate stiffener in Skin B, of East tower, lift 1, weld joint identified as ESD1-SA 233-14. ZPMC CWI Identified as Mr. Li lin. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2333-TC-P4-F.

2. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 042218 perform FCAW welding on, inside bearing plate stiffener in Skin A, of East tower, lift 1, weld joint identified as ESD1-SA 233-D/F- 2, 4. ZPMC CWI Identified as Mr. Li lin. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2333-TC-P4-F.

3. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 049541 perform FCAW welding on, inside bearing plate stiffener in Skin E, of East tower, lift 1, weld joint identified as ESD1-SA 233-F/H-4, 6. ZPMC CWI Identified as Mr. Li lin. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2333-TC-P4-F.

4. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040338

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# WELDING INSPECTION REPORT

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perform FCAW welding on, inside bearing plate stiffener in Skin C, of south tower, lift 1, weld joint identified as ESD1-SA 17-F/G-30. ZPMC CWI Identified as Mr.Li lin. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2333-TC-P4-F.

### Magnetic Particle Testing:

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 for this date. The member is identified as North shaft, Lift 3, 85.25 mtr. And 89 mtr. Diaphragm to Skin C & D and fit lugs at Bay no. 11. The weld designations reviewed are as follows:

- NSTL3- 3 B/K- Jt. nos – 8,9,13,70,71,72 – 85.25 mtr. Fit lugs
- NSTL3- 3 B/K- Jt. nos – 10, 56 – 85.25 mtr. Diaphragm to skin
- NSTL3- 3 C/K- Jt. nos – 10,11,16,79,80,81,86 – 89 mtr. Fit lugs
- NSTL3- 3 D/K- Jt. nos – 8,9,69,70,64,65 – 89 mtr. Fit lugs
- NSTL3- 3 C/K- Jt. nos – 12,13,88 – 89 mtr. Diaphragm to skin
- NSTL3- 3 D/K- Jt. nos – 13,18,66 – 89 mtr. Diaphragm to skin

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.

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<b>Inspected By:</b>	Baskar, Govindarajan	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford, William	QA Reviewer

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