

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-012549**Date Inspected:** 06-Mar-2010**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. Du zhi qun/ Mr. Gong Liang			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 207745 perform SAW welding on, Grillage plate of North tower, and weld joint identified as NSD1-TL5-3B-F-6B. ZPMC CWI Identified as Mr. Du Zhi Qun. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3221-B-U3C-S-1. (Photo attached)

2. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 052493 perform SMAW Repair welding on, BC Corner of North tower, Lift 4 and weld joint identified as NSTL4-3B/L-4A. ZPMC CWI Identified as Mr. Gong liang zhu. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW- 2G (2F)-Repair. (Photo attached)

3. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 052493 perform SMAW Repair welding on, CD Corner of inside North tower, Lift 4 and weld joint identified as NSTL4-3B/L-5B. ZPMC CWI Identified as Mr. Gong liang zhu. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW- 2G (2F)-Repair.

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Bay no. 11

4.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 047304 perform SAW welding on, Strut Flange plate and weld joint identified as SD1-STSA4-5-135mtr.-1-3A. ZPMC CWI Identified as Mr. Yu Dong Ping. 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.

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 Outside AB Corner of North tower, Lift 4, at Bay no. 10. The weld designations reviewed are as follows:

NSTL4- 3L/L, Jt. no. – 4A

NSTL4- 3B/L, Jt. no. – 4A –Except Ring areas

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 Skyler Guest - 15000422360, 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