

**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-012550**Date Inspected:** 07-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

<b>CWI Name:</b>	Mr. An Qing Xiang/ Mr. Tu Jun	<b>CWI Present:</b>	Yes	No	
<b>Inspected CWI report:</b>	Yes No N/A	<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes No N/A	<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes No N/A	<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes No N/A	<b>Approved WPS:</b>	Yes	No	N/A
		<b>Delayed / Cancelled:</b>	Yes	No	N/A
<b>Bridge No:</b>	34-0006	<b>Component:</b>	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 040414 perform SAW welding on, Grillage plate of South tower, and weld joint identified as SSD1-TL5-1B-F-21B. ZPMC CWI Identified as Mr. Tu Jun. 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 056364 perform SMAW welding on, Tower Skirt plate and weld joint identified as SSD1-SA447-3-5, 9, 10. ZPMC CWI Identified as Mr. Zhu Zhong Jie. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2112.

Bay no. 11

3. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 049099, 046704 perform SMAW welding on, AB Corner of inside West tower, Lift 5 and weld joint identified as WSD1-TL5-4B/F-20B, 32B. ZPMC CWI Identified as Mr. An qing xiang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3211-TC-U4B-1.

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## Heavy Dock Jetty

4. This QA inspector, Baskar Govindarajan performed dimension measurements of Gap and misalignment of Interior splice plates between South tower Lift 1 and Lift 2 from inside. The same was measured from Top and bottom side of interior splice plates over the stiffeners of all the skins, i.e. Skin A to E. These measurements have been carried out along with QA Inspector Mr. Shailesh Gaikwad whose lot no. is B295. Thickness of all stiffeners found to be 70 mm and the maximum Gap between stiffener to Interior splice plate on both top and bottom found to be 9mm and the minimum found to be 0mm. The maximum misalignment between stiffener to Interior splice plate on both top and bottom found to be 5.5 mm on weld toe side and 10mm on stiffener end side respectively and the minimum found to be 0 mm on both weld toe and stiffener end. (Photo attached)

## 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 AB and AE Corner of East tower, Lift 5, at Bay no. 11. The weld designations reviewed are as follows:

ESD1-TL5-2B/F, Jt. nos. – 3A/B, 36A/B – AE Corner

ESD1-TL5-2B/F, Jt. nos. – 37B, 9B – AB Corner

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



## Summary of Conversations:

No relevant conversations.

## Comments

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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.

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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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