

**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-014134**Date Inspected:** 17-May-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. 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 041271 perform SMAW welding on, Spare strut flange to web and the weld joint is identified as ND1-STSA4-10-119mtr.-2-7A, 9A. 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-3212-TC-U5B-1. (Photo attached)

2. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 046709 perform SMAW welding on, Spare strut flange to web and the weld joint is identified as ND1-STSA4-10-119mtr.-2-35B. 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-3212-TC-U5B-1.

3. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040724, 202100 perform SMAW welding on, Spare strut Stiffener to web and the weld joint is identified as ND1-STSA4-6-123mtr.-1-95, 90. 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-2113.

4. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 049220,

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040609 perform FCAW welding on, Type 2 Bearing stiffener Of Shear plate SD1-A 23 and the weld joint is identified as SD1-A23 A/B- 32, 33. ZPMC CWI Identified as Mr. Xu Le Feng. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2331-TC-P4-F. (Photo attached)

Bay no. 10

5.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040367, 053870 perform FCAW welding on, Type 2 Bearing stiffener Of Shear plate ED1-A 27 and the weld joint is identified as ED1-A27 B/B- 24, 26. ZPMC CWI Identified as Mr. Yu qi guo. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2331-TC-P4-F.

Blasting shop 1

6.This QA inspector, Baskar Govindarajan, performed marking of weld spatters, Arc strikes, grinding points of bearing stiffeners and 0 to 18 mtr. Elevation of inside shaft during the pre blasting inspection of North shaft, Lift 1. This inspection was carried out along with QA Inspectors Mr. Sandeep whose lot no. is B 227. Witnessed the MT carried out by ZPMC ON 18 mtr. elevation. It was observed that no rejectable indication found by ZPMC.

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.

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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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