

**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-014160**Date Inspected:** 13-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. An Qing Xiang**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, has taken measurements of distances between Anchor bolt hole and Type 1, 2 and main stiffener of Skin C of North Shaft, Lift 1. These readings have been taken along with QA Inspector Mr. Sandeep whose lot no. is B 227.

2. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040724 perform SMAW Repair welding on, Doublers plate to Cross bracing support plate on Skin A of West Shaft, Lift 1 and Weld joint identified as P 475-W-2. ZPMC CWI Identified as Mr. Zhao Chen Sun. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345+485-SMAW-3G(3F)-Repair. (Photo of Gouging the weld is attached)

**Bay no. 11**

3. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040725/049541 perform FCAW welding on, Bearing stiffener of Shear plate no. ED1-A 29 and the weld joint is identified as ED1-A29-33, 30 A/B. 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-2331-TC-P4-F.

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# WELDING INSPECTION REPORT

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(Photo attached)

4.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040723 perform FCAW welding on, Bearing stiffener of Shear plate no. WD1-A 25 and the weld joint is identified as WD1-A25 B/E-10. 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-2331-TC-P4-F.

5.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040724 perform SMAW welding on, Spare strut flange to web and the weld joint is identified as ND1-STSA4-6-143mtr. -2-74A. 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.

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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**Inspected By:** Baskar, Govindarajan

Quality Assurance Inspector

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**Reviewed By:** Clifford, William

QA Reviewer