

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-015328**Date Inspected:** 04-Jul-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/ Mr. Qiu Wen	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.

Tower Jetty

1. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 056364 perform SMAW Repair welding on; Cross bracing Gusset plate, Doubler plate to Back fill plate in South shaft, Lift 2, 53 mtr. elevation at Tower trial assembly area and the weld joint is identified as SSD1-SA 164 B/F-9. ZPMC CWI Identified as Mr. Qiu Wen. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-485-SMAW-2G (2F)-Repair-1. Photograph showing the preheating of this joint is attached.

2. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040610 perform SMAW Repair welding on; Cross bracing Gusset plate to Back fill plate in east shaft, Lift 2 at Tower trial assembly area in 77 mtr. elevation and the weld joint is identified as ESD1-SA 300 C/F-12. ZPMC CWI Identified as Mr. Qiu Wen. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-485-SMAW-2G (2F)-Repair-1. Photograph showing the Welding of this joint is attached.

Bay no. 10

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

3.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 050289 perform SMAW welding on; Lift 4 to 5, interior splice plate and the weld joint is identified as NSD1-SPSA5-13-2B. ZPMC CWI Identified as Mr. Gao Zhi chun. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3211-TC-U5B-1.

Bay no. 11

4.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 044551 perform SMAW welding on; Spare strut Flange to stiffener and the weld joint is identified as WD1-STSA4-5-131mtr.-1-25,26. 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-2112.

5.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040655 perform SMAW welding on; Spare strut Flange to stiffener and the weld joint is identified as SD1-STSA4-5-139mtr.-1-41,42. 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-2112.

6.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040704 perform SMAW welding on; Lift 4 to 5, interior splice plate and the weld joint is identified as WSD1-SPSA5-12-2A. 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-3211-TC-U5B-1

Ultrasonic Testing:

This QA inspector, Baskar Govindarajan, performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted at Tower components by ZPMC Quality Control personnel. This QA Inspector generated a TL-6027 UT report for this date. The member is identified as Tower Doubler plate to Back fill plate and Cross bracing gusset plate at 65 mtr. elevation. (Notification no. 006124) . The weld designation reviewed is as follows:

ESD1-SA 300C/F – Jt. nos – 15,16,17,18,19 – East shaft, Lift 2- 65 mtr. elevation

WSD1- SA 340 C/F- Jt. nos – 11,12,13,14,19 - West shaft, Lift 2- 65 mtr. elevation

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



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 Micheal Ng (15921845703), who represents the Office of Structural Materials for your project.

Inspected By: Baskar, Govindarajan

Quality Assurance Inspector

Reviewed By: Clifford, William

QA Reviewer