

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-015536**Date Inspected:** 06-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.

Bay no. 10

1. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 053870 perform FCAW welding on; Façade manhole cover plate and the weld joint is identified as WD1-SA4-66-33-11/12. 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-2132 (Photo attached)

2. 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-SPSA5-13-4B. 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.

3. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 052493 perform SMAW welding on; Lift 4 to 5, interior splice plate and the weld joint is identified as SSD1-SPSA5-13-1B. 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.

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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-STSA4-5-123mtr.-1-23, 24. 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.

Tower Jetty

5.This QA inspector, Baskar Govindarajan, observed during random 10% verification of Ultrasonic Testing (UT) of Doubler Plate to Backfill Plate, One Class "B" non conforming longitudinal indication measuring approximately 60 mm in length found in 77 mtr. elevation of South shaft, Lift2. Depth of the discontinuity from face A is approximately 37 mm, and Y location found to be 15 mm from Strut side. Reported the same to Task leader, and Incident report written. (Photo attached)

Ultrasonic Testing:

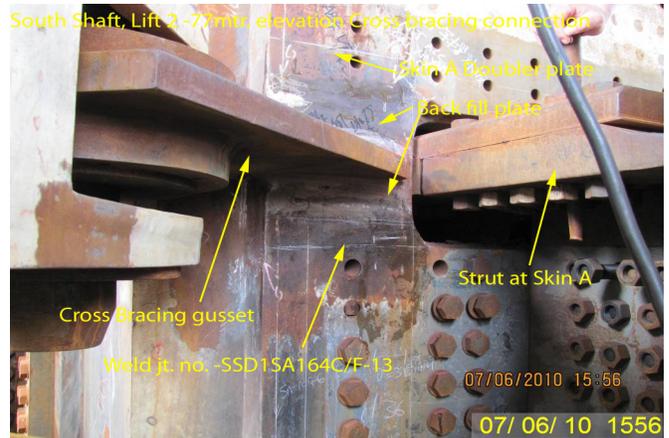
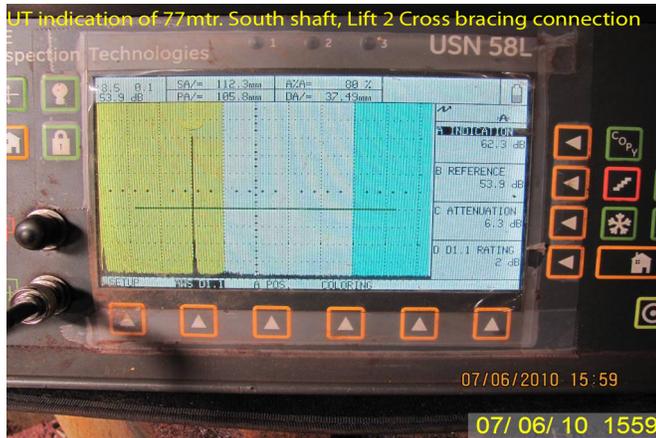
This QA inspector, Baskar Govindarajan, performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted at Tower components by ZPMC Quality Control personnel. This QA Inspector generated a TL-6027 UT report for this date. The member is identified as Tower Doubler plate to Cross bracing gusset plate at 53 mtr . & 77 elevation. (Notification no. 006134) . The weld designation reviewed is as follows:

ESD1-SA 300 B/F – Jt. nos – 21,22,24,25,26 – South shaft, Lift 2- 53 mtr. elevation
WSD1-SA 340 B/F – Jt. nos – 11,12,13,14,15 – South shaft, Lift 2- 53 mtr. elevation
ESD1-SA 300 C/F – Jt. nos – 11,12,13,14,21 – South shaft, Lift 2- 77 mtr. elevation
WSD1-SA 340 B/F – Jt. nos – 15,16,17,18,21 – South shaft, Lift 2- 77 mtr. elevation
SSD1-SA 164 C/F – Jt. nos – 13,14,15,16,19 – South shaft, Lift 2- 77 mtr. elevation
NSD1-SA 166 C/F – Jt. nos – 15,16,17,18,22 – South shaft, Lift 2- 77 mtr. elevation

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

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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