

**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-015782**Date Inspected:** 26-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**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 037996 perform SMAW welding on; West shaft, Lift 5, Grillage plates and the weld joint is identified as WSD1-TL5-4 E/F-28B. 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-3213-TC-U5B. (Photo attached)

2. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 202100 perform SMAW welding on; East shaft, Lift 5, Grillage plates and the weld joint is identified as ESD1-TL5-2 F/F-4. 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-3313-TC-P5.

3. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040656 perform SMAW welding on; Interior splice plate between Lift 4 & 5 and the weld joint is identified as WSD1-SPSA5-7-2A. 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.

Bay no.10

---

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

---

4.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 050289 perform SMAW welding on; South shaft, Lift 5, Grillage plates and the weld joint is identified as SSD1-TL5-1 F/F-11B. 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-3213-TC-U5B.

5.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040414 perform SAW welding on; Bike path, Floor beam plates of Lift 13 and the weld joint is identified as BK 004A1-031-009. 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-2221-B-L2C-S-2.(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 Lift 2, Manhole cover part weld at Heavy Dock Jetty (Notification no. 06284) and Lift 4 Strut angle splice plate at Bay no. 11(Notification no. 06288). The weld designations reviewed are as follows:

P -362 -S- Jt. nos -1,2,3,4 – Lift 2,Manhole cover plate  
P -362 -N- Jt. nos -1,4 – Lift 2,Manhole cover plate  
WD1-SA4-56-143 mtr.- Jt. no -3 –Lift 4, strut angle splice plate  
WD1-SA4-56-135 mtr.- Jt. no -3 –Lift 4, strut angle splice plate  
WD1-SA4-56-123 mtr.- Jt. no -1 –Lift 4, strut angle splice plate  
SD1-SA4-56-131 mtr.- Jt. no -3 –Lift 4, strut angle splice plate  
SD1-SA4-56-119 mtr.- Jt. no -1 –Lift 4, strut angle splice plate  
ED1-SA4-56-119 mtr.- Jt. no -4 –Lift 4, strut angle splice plate

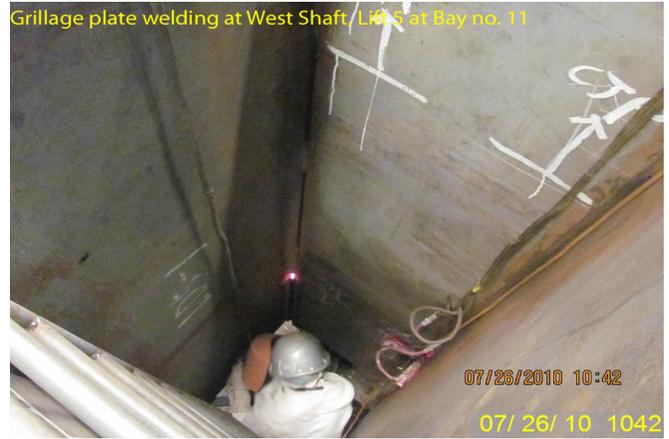
Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

---

# 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