

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-016355**Date Inspected:** 09-Aug-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. 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. 11

1. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 053316 perform FCAW welding on; Lift 13 Component, Bike path and the weld joint is identified as BK 004A6 -019-069. 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-2131.

2. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 205649 perform FCAW welding on; Lift 13 Component, Bike path and the weld joint is identified as BK 004A7 -019-04. 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-2131.

3. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040610/041271 perform SMAW welding on; East shaft, Lift 5, intersection diaphragm plate to Skin E and the weld joint is identified as ESD1-TL5-2 BF-22/23. 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-B-T-3213-TC-U4C.

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4.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 046709 perform SMAW welding on; East shaft, Lift 5, intersection diaphragm plate to Skin A and the weld joint is identified as ESD1-TL5-2 BF-7B. 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-B-T-3213-TC-U5B.

Bay no.10

5.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 066443 perform SMAW welding on; North shaft, Lift 5, intersection diaphragm plate to inside Skin E and the weld joint is identified as NSD1-TL5-3 B/F-28B. 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-B-T-3213-TC-U5B.

6.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 066361 perform SMAW welding on; North shaft, Lift 5, intersection diaphragm plate to inside Skin E and the weld joint is identified as NSD1-TL5-3 B/F-11. 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-B-T-3213-TC-U4C.

7. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 052075 perform FCAW welding on; Façade plate Base plate and the Façade plate is identified as SFSA4-337. 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-345-FCAW-1G (1F)-Repair.

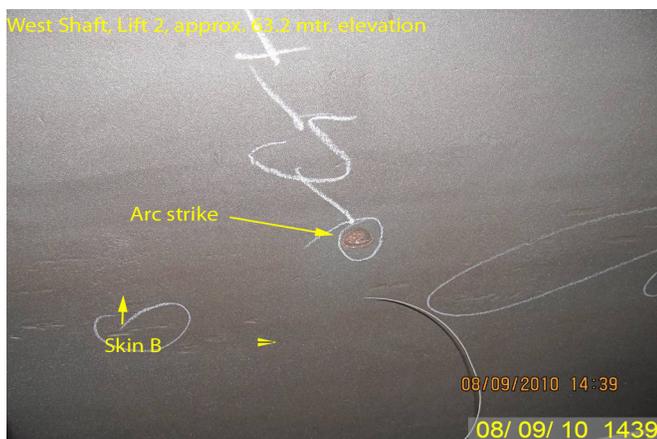
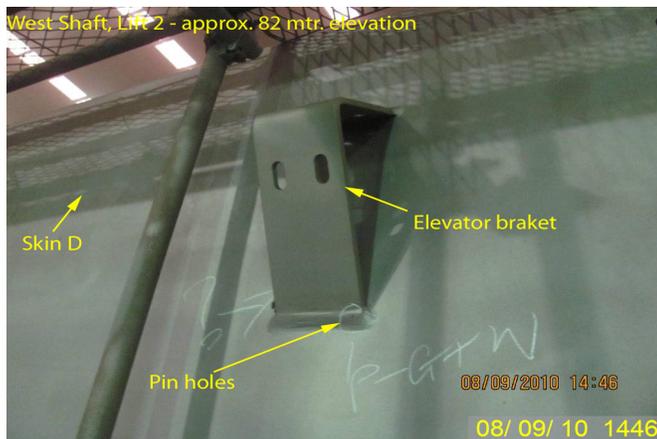
Blast shop 1

8. This QA inspector, Baskar Govindarajan, performed Pre blast inspection of external surfaces of West tower, Lift 2. All the areas marked which requires grinding, weld repair, Grinding & MT wherever applicable in all the Skins of Tower from 50.3 to 83 mtr. Elevation. This inspection was carried out along with QA Inspector Mr. Robin Sharma (B309), Mr. Reddy (B 308) and Mr. Gade (B 307). All the marked points shown to ZPMC inspectors. Mr. James Lumley, QA NACE Level III Inspector was present during the inspection process. Incident report rose for the same. (Photo attached)

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:

This QA Inspector, asked Mr. Steve Hall for the wrapping off welding in diaphragm plates inbetween stiffeners of OBG Lift 13, Side panel plate no. SP3070-001, which was wrapped off. As per Mr. Steve hall, this is an outstanding issue and need solution from Mr. Eric Sang. Since Mr. Eric sang not available today, this will be sorted out tomorrow.

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