

**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-016502**Date Inspected:** 23-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. Zhao Chen Sun**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, observed, ZPMC qualified welding personnel identified as 050038 perform SMAW Repair welding on; Cross Bracing Gusset and Skin A of South shaft, Lift 3, in 109 mtr. elevation and the weld joint is identified as WD1-GUSA3-3-109 mtr.-S-3B. 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-SMAW-4G (4F)- FCM-Repair.

2. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 052916 perform SMAW welding on; Cross Bracing Gusset and Skin A of East shaft, Lift 3, in 99 mtr. elevation and the weld joint is identified as WD1-GUSA3-3-99 mtr.-E-4A. 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-B-P-2212-TC-U5B-FCM. (Photo attached)

3. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040365 perform SMAW welding on; Cross Bracing Gusset and Skin A of North shaft, Lift 3, in 99 mtr. elevation and the weld joint is identified as WD1-GUSA3-3-99 mtr.-N-3A. 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

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## WELDING INSPECTION REPORT

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WPS-B-P-2212-TC-U5B-FCM.

Bay no.10

4. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 044511 perform SMAW welding on; South shaft, Lift 5, Intersection diaphragm plate to Grillage plate and the weld joint is identified as SSD1-TL5-1B/F-15. ZPMC CWI Identified as Mr. Zhang Huang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3213-TC-U4c.

5. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 052075 perform FCAW welding on; Façade seal angle and the weld joint is identified as ND1-SFSA4-157-7, 8. ZPMC CWI Identified as Mr. Zhang Huang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132. (Photo attached)

Bay no. 11

6. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 202100 perform SMAW welding on; Interior splice plate and the weld joint is identified as ESD1-SPSA5-20-1B. 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.

7. This QA inspector, Baskar Govindarajan, observed ZPMC qualified welding personnel identified as 040736 perform FCAW welding on; Lift 13-OBG Edge plate and the weld joint is identified as EP 3030B-001-055. 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-2231-B-U2-F.

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

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Cross Bracing welding with tower on 99 mtr. elevation -Heavy Dock



Facade seal angle welding at Bay no. 10



## 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.

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**Inspected By:** Baskar, Govindarajan

Quality Assurance Inspector

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**Reviewed By:** Clifford, William

QA Reviewer