

**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-006940**Date Inspected:** 05-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Wen Zhong Wan**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 Mr. Zhen yi (067949) perform FCAW welding on inside south tower Lift 2, diagonal plate components, Weld joint no. SSD1-TL 5J/L-56. ZPMC CWI Identified as Mr. Wang chuan qing. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2332-tc-p4.

2. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as Mr. Zhang wei (066399) perform FCAW welding on inside south tower Lift 2, diagonal plate components, Weld joint no. SSD1-TL 5J/L-57. ZPMC CWI Identified as Mr. Wang chuan qing. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2332-tc-p4.

3. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as Mr. Zhang we bao (052023) perform FCAW welding on inside North tower Lift 2, skin plate components, Weld joint no. NSD1-TL 8E/L-46. ZPMC CWI Identified as Mr. Wen zhong wan. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2113.

4. This QA inspector, Baskar Govindarajan, observed, Parent metal damage up to 4mm in Stiffener plates of South

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tower skin C, Lift 3(Bay no. 10)- where lifting hook have been removed by Arc Gouging. Photograph attached.  
(File name-04-0120f4\_05-05-09-PM Damage3\_B204)

## 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 on this date. The member and the weld designations are as follows:

## Bay no. 10

1. Lift 3-Skin D to stiffner,                   SSD1-FDSA3-1B/C, 51A/B,41A/B  
53A/B,48A/B,55A/B,34A/B,49A/B,  
27A/B
2. Tower strut                                   WD1- A 467-28M-3
3. Tower strut                                   WD1- A 467-43M-4

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



## 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 Serge sinevod - 134-8257-0045, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Baskar, Govindarajan	Quality Assurance Inspector
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<b>Reviewed By:</b>	Clifford, William	QA Reviewer
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