

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-008207**Date Inspected:** 17-Jul-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. Chen ying xin**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 052493 perform SMAW welding on, Strut Splice plate, Weld joint no. ND1-A 5002-10-1B. ZPMC CWI Identified as Mr. Zhou yu. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3211-TC-U5B-1.

2. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040252 perform SAW welding on Strut web plate, Weld joint no. ED1-A 6001-7-1B. ZPMC CWI Identified as Mr. Liu yang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3221-B-U3C-S-1.

3. During In process inspection at Bay no. 10, Waviness up to 6mm observed in stiffener plates of south tower Lift 4, Skin E, near Weld joint no. SSD1-FESA4-1 F/F-47A, ZPMC CWI identified as Mr. Chen ying xin. The same have been informed to Mr. Canon of ZPMC QA, and as per him, the waviness will be rectified by heat straightening process. Photograph attached.

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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. 11

Sl.no.	Inspection part	Section
1.	WSD1-FDSA4-4D/D-51A, 9A, 7A, 49A, 4A, 46A, 8A, 36A, 50A, 23B, 37B, 21B, 35B, 18B, 32B, 22B	West tower, Lift 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.

Inspected By: Baskar, Govindarajan

Quality Assurance Inspector

Reviewed By: Clifford, William

QA Reviewer