

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-008215**Date Inspected:** 27-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. Liu yang**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 070397 perform FCAW welding on, north tower, Lift 4, Weld joint no. NSD1-FESA4-3 F/F-35A. 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-2332-tc-p5-f.

2. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040338 perform FCAW welding on, north tower, Lift 4, Weld joint no. NSD1-FBSA4-1 A/C-53. ZPMC CWI Identified as Mr. Chen ying xin. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2332-tc-p5-f.

3. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 207745 perform SAW welding Strut web plate, Weld joint no. ED1-A 6003-3-3B. 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-4221-B-U3C-s1.

4. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 053869

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perform SMAW welding on, INSIDE North tower Lift 1, Weld joint no.NSD1-A166 E/J-73B. 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-345-2G (2F)-Repair.

5.This QA inspector, Baskar Govindarajan, Prepared Incident report, 04-0120F4_TL015_B204_07-27-09_Excess leg length, for excess welding leg between stiffener and 109 mtr. Diaphragm, which was found to be 45 mm, inside South tower lift 3. The weld joint no. identified as SSTL3 – 1 I/K- 136. Informed the same to Mr. Cannon of ZPMC and Mr. Kim of ABF. The clearance between the adjacent hole and welding found to be 2mm.

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
