

**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-009650**Date Inspected:** 31-Aug-2009**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

<b>CWI Name:</b>	Mr. Liu yang/ Mr. Xu le feng	<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes No N/A	<b>Rod Oven in Use:</b>	Yes No N/A	
<b>Electrode to specification:</b>	Yes No N/A	<b>Weld Procedures Followed:</b>	Yes No N/A	
<b>Qualified Welders:</b>	Yes No N/A	<b>Verified Joint Fit-up:</b>	Yes No N/A	
<b>Approved Drawings:</b>	Yes No N/A	<b>Approved WPS:</b>	Yes No N/A	
		<b>Delayed / Cancelled:</b>	Yes No N/A	
<b>Bridge No:</b>	34-0006	<b>Component:</b>	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 052917 perform SAW welding on, Spare strut splice plate, Weld joint no. ND1-A 5002-21-1A. ZPMC CWI Identified as Mrs. Liu yang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3221-TC-U5-S1.

2. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 044500 perform SMAW welding on, Strut plates, Flange to stiffener, Weld joint no. ED1- A6003-2-16. 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-3212-TC-U5B-1.

3. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040345 perform FCAW welding on, Inter connecting corner splice plate, Weld joint no. SSD1-SPSA3-54-1B. ZPMC CWI Identified as Mr. Du Zhi qin. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-B-U5-F.

Bay no. 11

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## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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4. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 069043 perform FCAW welding on, Doubler plates of Skin A, West tower, Weld joint no. WSD1-FASA4-2 A/E-34. ZPMC CWI Identified as Mr. Li hong fei. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2332-TC-P4-F.

### Magnetic Particle Testing:

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6028 MT report for this date. The member is identified as Triangular plates to diagonal stiffener of CD corner, North tower, lift 3. The weld designations reviewed are as follows:

NSTL3 -3B/K-3  
NSTL3 -3C/K-3, 94  
NSTL3 -3D/K-3  
NSTL3 -3F/K-3, 79  
NSTL3 -3G/K-3  
NSTL3 -3H/K-3, 78  
NSTL3 -3I/K-3, 93  
NSTL3 -3J/K-3  
NSTL3 -3G/K-94

Unless otherwise noted, all work observed on this date appeared to generally comply with 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
<b>Reviewed By:</b>	Clifford, William	QA Reviewer

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