

**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-009651**Date Inspected:** 01-Sep-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>	<b>Yes</b>	<b>No</b>	
<b>Inspected CWI report:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Approved WPS:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
		<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<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. 11

1. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 053870 perform SMAW welding (Surface repair) on, Skin C, near weld joint no. ESTL3- 4 B/K-83B on East tower, Lift 3. ZPMC CWI identified as Mr. Guo peng. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-4G(4F)- Repair.

2. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 041271 perform SMAW welding on, Strut plates, Flange to stiffener, Weld joint no. SD1- A6002-9-12B. ZPMC CWI Identified as Mrs. 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.

Bay no. 10

3. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 053870 perform FCAW welding on, Inter connecting splice plate, Weld joint no. SSD1-SPSA3—70-2B. 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-2231-TC-U5-F.

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4. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 053049 perform SMAW welding on, Strut splice plate, Weld joint no. ND1-A 5012-36-1B. ZPMC CWI Identified as Mr. Shi wei song. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3211-tc-u5b-1.

## 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 East tower, Lift 3 BC corner edges. The weld designation reviewed is as follows:

ESTL3-4B/K-84A

## Visual Inspection Testing:

This QA inspector performed Random Visual Inspection (VT) of the area previously tested and accepted by ZPMC Quality Control personnel. The member is identified as south tower, Lift 3, BC Corner triangular plate. The weld designations reviewed are as follows:

SSTL 3- 1 B/K- 18, 20

SSTL 3 – 1 C/K – 20, 21, 100, 101

SSTL 3 – 1 F/K – 16, 18, 93, 94

SSTL 3 – 1 G/K – 22, 23, 111, 112

SSTL 3 – 1 H/K – 16, 17, 92, 93

SSTL 3 – 1 I/K – 20, 21, 111, 112

SSTL 3 – 1 J/K – 16, 17

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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**Inspected By:** Baskar, Govindarajan

Quality Assurance Inspector

**Reviewed By:** Clifford, William

QA Reviewer