

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

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-009652**Date Inspected:** 03-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**CWI Name:** Mr. Liu yang/ Mr. Xu le feng**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 040570 perform SMAW welding on, Strut flange to web, weld joint no. ND1-A 6002-18-7A. 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-3214-TC-U5B-1.

2. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040333 perform FCAW welding on, inside soth tower, Lift 3, BC corner diagonal plate, 89 mtr. Elevation, Weld joint no. SSTL3-1 K/K-6. ZPMC CWI Identified as Mr. Wang chuan qin. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2233-B-U2A-F1.

3. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 053870 perform SMAW welding on, North tower, Skin E plates, Weld joint no. NSD1-FESA4-3 F/F-66A. This welding is being done to rectify the distortion as per Welding repair report no. T-WR-2074. 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-485-SMAW-1G (1F)- Repair. Photograph attached.

---

# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

4. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 068864 perform FCAW welding on, Doublers plates of North tower Lift 4, Weld joint no. NSD1-FASA4-1 B/E-5. ZPMC CWI Identified as Mr. Du zhi qun. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-4332-tc-p4-f.

## 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 D/K- 22, 23

## 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 for this date. The member is identified as West tower, Lift 1 & 2, internal corner splice plate, Bay no. 11. The weld designations reviewed are as follows:

1. WSD1- SA355- 1, 2 B
2. WSD1- SA176- 1,2 A

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



## Summary of Conversations:

---

---

# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

---

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.

---

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

---