

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-009653**Date Inspected:** 04-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 040460 perform SAW welding on, Strut Splice plate, weld joint no. WD1-A 502-35-1A. ZPMC CWI identified as Mr. Ma yun. 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 066401 perform FCAW welding on, Shear plate, Weld joint no. ED1-A 27A/E-87. 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-2331-TC-P4-F.

3. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 068918 perform FCAW welding on, Doublers plates of Skin A, 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.

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4.This QA inspector, Baskar Govindarajan, observed, welding between Strut web plate and stiffener, weld joint no. ED1-A 6003-3-59, carried out on top of Web joint, weld joint no. ED1- A 6003-3-5A/B. The thickness of web joint found to be 60/28. The thickness of Stiffener found to be 28mm. ZPMC CWI identified as Mr. Ma yun. Photograph attached

Bay no. 11

5.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 041271 perform SMAW welding on, Shear link beam, between flange to web, Weld joint no. SD1-A 6002-10-7A. 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.

6.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 048810 perform FCAW Repair welding on, Inter connecting corner splice plate, Weld joint no. WSD1-SPSA3-53-1A. ZPMC CWI Identified as Mr. Li lin. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-FCAW- 2G (2F)- Repair.

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