

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-009654**Date Inspected:** 05-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. 11

1. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040775 perform FCAW Repair welding on, Inter connecting corner splice plate, Weld joint no. WSD1-SPSA3-55-2B. 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-345-FCAW- 2G (2F)- Repair. The welding repair report (WRR) found to be T-WR-2070.

2. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 044550 perform SAW welding on, Spare strut flange plate, Weld joint no. WD1-A 6003-7-3A. 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-4221-B-U3C-S1.

3. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 046704 perform SMAW Repair welding on, Strut Splice plate, weld joint no. WD1-A 5007-10-1A. 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-485-SMAW-1G (1F)-repair. The welding repair report (WRR) found to be T-WR-UT-2183.

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4.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel doing SMAW welding in overhead position on East tower, Lift 3, CD Corner, weld joint no. ESTL3- 4 B/K- 83B, which was already tested and accepted by UT from ZPMC and CT. Length of welding in this CD corner tested is 6mtr.. Refer notification no. 004126. Photograph attached.

Bay no. 10

5.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-SPSA3-70-4B. 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-2231-TC-U5-F1.

Bay no. 12

6.This QA inspector, Baskar Govindarajan, raised Incident report no. 04-0120F4_TL015_B204_09-05-09_Cold bending -for cold bending of distorted Web plate, Strut no. ND1- A 6002-8, which is fracture critical steel. The thickness of web plate found to be 60/28.

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 & CD corner, . The weld designations reviewed are as follows:

ESTL3- 4 D/K-65, 66 – BC Corner

ESTL3-4J/K-1, 2 – CD corner

ESTL3-4I/K-92, 93, 85, 87 – CD corner

ESTL3-4H/K-148, 149, 72, 73 – CD corner

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

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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