

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-009657**Date Inspected:** 03-Oct-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. Qiu wen/ Mr. Chen ying xin			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.

Trial assembly area

1. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 056200 perform SMAW welding on, south tower, Lift 1, Strut doublers plate to interconnecting box supporting plate, weld joint no. SSD1-SA159 C/J-6. ZPMC CWI Identified as Mr. Wang xiao bing. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-4114.

2. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 070397 perform FCAW welding on, south tower, Lift 1, Skin E to interconnecting box supporting plate, Weld joint no. SSD1-SA173 J/K-11. ZPMC CWI Identified as Mr. Qiu wen. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132.

Bay no. 10

3. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 052930 perform SMAW welding on, Spare strut flange to web plate, Weld joint no. ED1-A 6003-5-11A. ZPMC CWI Identified as Mr. Chen ying xin. The welding parameters as measured using QC's calibrated instruments appeared

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to be in general compliance with WPS-B-T-2212-TC-U5B.

4.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040460 perform SAW welding on, spare strut web plate, Weld joint no. ED1-STSA3-2-89M-1-4B. 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-4221-B-U3C-S-1.

Machining area

5.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 066881 perform FCAW build up welding on; Skin B & C of North tower lift 1 bottom up to 25 mm. ZPMC CWI Identified as Mr. Zhu feng. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-FCAW-3G (3F)-Repair. The CWR no. for the repair welding found to be CWR-T-CWR-55.

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.

Inspected By:	Baskar, Govindarajan	Quality Assurance Inspector
Reviewed By:	Clifford, William	QA Reviewer
