

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-009666**Date Inspected:** 12-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. Qie wen**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.

Machining area

1. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 067904 perform SMAW surface repair welding on, Fit lug of 85.25 mtr. Elevation, East tower, lift 3. The weld joint identified as ESTL3-4 B/K-40. ZPMC CWI Identified as Mr. Liu xiao zhong . The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-3G (3F) - repair.

2. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040723 perform SMAW surface repair welding on, 99 mtr. diaphragm, inside south tower, lift 3. ZPMC CWI Identified as Mr. Liu zhong an . The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-2G (2F) - repair.

3. This QA inspector, Baskar Govindarajan, observed ABF personals doing grinding of Fit lug weld joints and Skin C to diaphragm in 47.6 mtr. Elevation of North tower, Lift 1. Photograph attached.

Trial assembly area

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4.This QA inspector, Baskar Govindarajan, witnessed, ABF personnel's performing Magnetic particle examination in 53 mtr. Elevation of south tower, Lift 2. All indications marked by ABF personnel's have been noted down in respective weld maps for record.

5.This QA inspector, Baskar Govindarajan, observed ZPMC qualified welding personnel identified as 068764 perform FCAW welding on; Skin A stiffener to tempravory reinforcement plate, bottom of south tower, lift 1. 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. Photograph attached.

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