

**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-010270**Date Inspected:** 01-Nov-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. You qi guo**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 (Heavy dock jetty)

1. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 066283 perform SMAW repair welding on, base plate to Skin C stiffener, inside south tower, lift 1. The weld joint identified as SSD1- A111 B/H- 92. ZPMC CWI Identified as Mr. You qi guo. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS- 345- SMAW-2G (2F)-Repair.

Machining area

2. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 041271 perform SMAW repair welding on, 111.89 mtr. Top diaphragm, Skin A in west tower, Lift 3. The weld joint identified as WSTL3-4J/K-28. 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-345-SMAW- 3G (3F)-repair.

3. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 052930 perform SMAW repair welding on, 65 mtr. Diaphragm, AE corner in North tower, Lift 3. The weld joint identified as NSTL3-3 D/K-51. ZPMC CWI Identified as Mr. Zhe feng. The welding parameters as measured using QC's

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calibrated instruments appeared to be in general compliance with WPS-345-SMAW- 3G (3F)-repair.

### 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 west tower, Lift 3, 111.89 mtr. Diaphragm fit lugs and diaphragm to Skin A, B, C, D and E and Bay 11-spare strut. The weld designations reviewed are as follows:

WSTL3-4 J/K – Jt. nos. 12,13,27,31,32,66,67,73,74 – Skin A,C,D &E

WSTL3-4 J/K -Jt.nos. 52,53,76 – Skin B

WD1-6001-3 – Spare strut -1 no.

### 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 Tower interconnecting splice plate at Bay no. 10. The weld designation reviewed is as follows:

NSD1-SPSA3-66-- Jt. nos. 1,2,3

NSD1-SPSA3-56-- Jt. nos. 1,2,3,4

NSD1-SPSA3-04-- Jt. nos. 1,2

NSD1-SPSA3-04-- Jt. nos. 1,2

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