

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-010288**Date Inspected:** 09-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. Lin zhong an**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 037932 perform SMAW repair welding on, inside North tower, Lift 3. The weld joint identified as NSTL3-3 B/K-84A. 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.

2. This QA inspector, Baskar Govindarajan, observed, Transverse indication of approximately 6 mm when performing 10% MT at West tower, lift 3, 89 mtr. Diaphragm, Skin B fit lug, weld joint no. WSTL3-4 C/K-69. Incident report raised.

Trial assembly (Heavy dock jetty)

3. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 062126 perform SMAW welding on, Temporary support plate, for west tower, Lift 1. ZPMC CWI Identified as Mr. Yu qi guo. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132.

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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 North tower, Lift 3, AE corner and step plates and West shaft, lift 3-89 mtr. Elevation to Skin A,B,C,D, E and fit lugs. The weld designations reviewed are as follows:

NSTL3- 3 B / K – Jt. no. 84 – 15% of 32 mtr. length AE corner
NSD1-FASA3-1 C/E – Jt. nos – 5,6,7,18,19,20 – Manhole and step plate
WSTL3- 4 C/K- Jt. nos- 51,57,68,53,76,81,82,9,10,11,18,19,26 – 89 mtr.
WSTL3-4 C/K- Jt. nos- 39,29 – AE corner back fill plate
WSTL3- 4 D/K- Jt. nos – 38,29 – DE corner back fill plate

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 AE and AB corner of North tower, Lift 3 and back fill and bracing plates of west tower, lift 3 at outside yard. The weld designation reviewed is as follows:

NSTL3- 3 B/K - Jt. nos – 83B, 84B – 10 % of 32 mtr. Length AE and AB corner
WSTL3 -4 C/K- Jt. nos – 40, 28 – AE corner back fill plate
WSTL3 – 4 D/K – Jt. nos – 39, 29 – DE corner back fill plate
WSTL3 -4 C/K –Jt. nos – 95, 96 –Bracing plates

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
