

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-010291**Date Inspected:** 10-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. 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.

Machining area

1. This QA inspector, Baskar Govindarajan, observed, Transverse indication of approximately 7 mm when performing 10% MT at West tower, lift 3, CD corner diagonal plate, Bottom side capping plate, weld joint no. WSTL3-4 K/K-51. Incident report submitted.

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2. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 052917 perform SAW welding on, Spare strut splice plate, weld joint identified as ED1-SA3-18-109 mtr.-5-1B . ZPMC CWI Identified as Mr. Gong gang zhu. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3221-TC-U5-S1.

3. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040333 perform SMAW welding on, Spare strut web to flange joint, weld joint identified as ND1-A6002-16-27 . 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-4113-1.

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4.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 056364 perform FCAW welding on, interconnecting splice plate, weld joint identified as SSD1-SPSA4-24-2B . 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-B-T-2231-TC-U5-F1.

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5.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 058009 perform SMAW welding on, Spare strut plate, weld joint identified as WD1-STSA3-2-89 mtr.-1-64A . ZPMC CWI Identified as Mr. Xu le feng. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3212-TC-U5b-1.

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

WSTL3- 4 B / K – Jt. nos. 77, 78- diagonal plate to skin
WSTL3- 4 B / K – Jt. nos. 4, 5- diagonal plate to diaphragm
WSTL3- 4 F / K – Jt. nos. 75, 76- diagonal plate to diaphragm
WSTL3- 4 G / K – Jt. nos. 92, 93, 97, 98- diagonal plate to diaphragm
WSTL3- 4 I / K – Jt. nos. 88, 89, 95, 96 - diagonal plate to diaphragm
WSTL3- 4 K / K – Jt. no. 44- Top side capping plate
WSTL3- 4 K / K – Jt. no. 51- Bottom side capping plate

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
