

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-010676**Date Inspected:** 04-Dec-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.

Heavy dock –Jetty

1. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040724 perform SMAW repair welding on, inside Base plate to Skin E, in west tower, lift 1, weld joint identified as WSD1-A 423 B/H-122. ZPMC CWI Identified as Mr. Guo peng. 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, ZPMC qualified welding personnel identified as 062126 perform SMAW repair welding on, inside Base plate to Skin A, in west tower, lift 1, weld joint identified as WSD1-A 423 B/H-127. ZPMC CWI Identified as Mr. Guo peng. 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, ZPMC qualified welding personnel identified as 047701 perform FCAW repair welding on, inside Base plate to Skin B stiffener, in west tower, lift 1, weld joint identified as WSD1-A 423 B/H-96. ZPMC CWI Identified as Mr. Guo peng. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-FCAW-2G (2F)-repair

Bay no. 11

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

4. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040759 perform FCAW welding on, inter connecting splice plate, weld joint identified as ESD1-SPSA4-30-1A. ZPMC CWI Identified as Mr. An qing xiang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-B-U5-F.

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 Interior splice plates plates. The weld designation reviewed is as follows:

ESD1- SPSA4-24 – Jt. nos – 1, 2, 3, 4 A/B – Skin A- East tower

WSD1-SPSA4-4- Jt. nos – 1, 2 A/B – Skin E – west tower

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
