

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-011117**Date Inspected:** 19-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. Du zhi qun/ Mrs. Yu dong ping			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.

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1. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 053049 perform SMAW welding on, Lift 5, Transverse diaphragm beam flange to web, weld joint identified as ND1-BPSA5-2-1-6. ZPMC CWI Identified as Mr. Du zhi qun. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3312-TC-p5.

2. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040269 perform SMAW welding on, Lift 5, Transverse diaphragm beam flange to web, weld joint identified as ND1-BPSA5-3-2. ZPMC CWI Identified as Mr. Du zhi qun. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3312-TC-p5.

3. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 050295, 207745 perform SAW welding on, CD corner of North tower, Lift 4, weld joint identified as NSTL4-3B/L-1A. ZPMC CWI Identified as Mr. Tu jun. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-TC-U2B-S.

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4.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040690 perform SMAW repair welding on,East tower, Lift 4, AB corner, weld joint identified as ESTL4-2B/L-59A. ZPMC CWI Identified as Mr. Li lin. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-2G (2F)-repair.

5.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 500342 perform SMAW welding on, Spare strut, web to stiffener, weld joint identified as SD1-STSA3-89mtr.-1-46. 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-B-T-2113.

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
