

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-011924**Date Inspected:** 12-Feb-2010**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. Li lin/ Mr. Du zhi qun**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.

Bay no. 10

1. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 066733 perform FCAW repair welding on, CD corner of North tower, Lift 4, and weld joint identified as NSTL4-3 B/L-1B.

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-345-FCAW-1G (1F)-Repair.

2. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 066236 perform FCAW welding on, inside South tower, Lift 4, Skin E fit lugs on 143 mtr. Elevation and weld joint identified as SSTL4-1 K/L-29, 94. ZPMC CWI Identified as Mr. Gong liang zhu. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2333-T-C-P4-F. (Photo attached)

3. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 057258 perform SMAW welding on, Spare strut plate, weld joint identified as ND1-STSA3-1-89mtr.-1-26A. ZPMC CWI Identified as Mr. Du zhu qin. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-485-SMAW-2G (2F)-FCM-Repair.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Bay no. 11

4. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 041716 perform SAW welding on, Spare strut splice plate, and weld joint identified as ED1-SA4-68-131mtr.-5, 6, 7-1B. 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-B-T-4221-TC-U5-S-1. (Photo attached). During this welding it was observed that, ZPMC using the WPS which have expired on Jan. 2010. (Photo attached). The was informed to Mr. Ken of ZPMC QA, Mr. Li lin of ZPMC QC and Mr. Li Shi you of ABF. ZPMC QA Said, they have forwarded letter to ABF for renewal.

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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

remedial efforts please contact Skyler Guest - 15000422360, who represents the Office of Structural Materials for your project.

Inspected By:	Baskar, Govindarajan	Quality Assurance Inspector
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Reviewed By:	Clifford, William	QA Reviewer
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