

**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-012895**Date Inspected:** 18-Mar-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. 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.

**Heavy Dock Jetty**

1. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040713 perform FCAW welding on, Exterior Bearing stiffener of inside East tower, Lift 1, Skin D, and weld joint identified as ESD1-SA296 B/E-9. ZPMC CWI Identified as Mr. Ye yong Jun. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2333-TC-P4-F.

2. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 059525, 040723 perform FCAW welding on, exterior Bearing stiffener of inside East tower, Lift 1, Skin E, and weld joint identified as ESD1-SA227 B/H- 3, 11. ZPMC CWI Identified as Mr. Ye yong Jun. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2333-TC-P4-F.

Bay no. 11

3. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040667, 040614 perform SMAW welding on, Strut splice plate, and weld joint identified as SD1-SA4-56-131mtr.-1,2,3,4-1A. ZPMC CWI Identified as Mr. Yu Dong Ping. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3221-TC-U5B-1. (Photo attached)

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# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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4.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 044550 perform SAW welding on, Strut Flange plate, and weld joint identified as NSD1-STSA4-6-131mtr.-1-2B. ZPMC CWI Identified as Mr. Yu Dong Ping. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-4221-B-U3C-S1. (Photo attached)

5.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 050289 perform SMAW repair welding on, Strut splice plate, and Strut splice identified as WD1-SA3-18-89mtr.- 4. ZPMC CWI Identified as Mr. Yu Dong Ping. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-2G (2F)-Repair.

## 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 Nort tower, Lift 4, CD Corner seam at Bay no. 10. The weld designation reviewed is as follows:

NSTL4-3B/L – Jt. no. 1A – CD corner

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

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# WELDING INSPECTION REPORT

*( Continued Page 3 of 3 )*

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<b>Inspected By:</b>	Baskar, Govindarajan	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford, William	QA Reviewer

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