

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-012897**Date Inspected:** 20-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 059525, 040713 perform FCAW welding on, Exterior Bearing stiffener of inside East tower, Lift 1, Skin C, and weld joint identified as ESD1-SA294 F/G-69, 54. 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 066482 perform FCAW welding on, exterior Bearing stiffener of inside East tower, Lift 1, Skin D, and weld joint identified as ESD1-SA296 B/E-6. 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 040614 perform SMAW welding on, Strut splice plate, and weld joint identified as SD1-SA4-56-143mtr.-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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4.This QA inspector, Baskar Govindarajan, has taken exterior alignment reading between East tower lift 3 and Lift 4 at Bay no. 11 on all skins. i.e. Skin A, B, C, D and E. The reading was taken along with Caltrans Inspector Mr. Sandeep Kumar, B 227, and the reading found to be within + or -2 mm.The maximum misalignment have observed on Skin B. This was reported to SMR. (Photo of Lift 3 and 4 attached)

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 Grillage plate at Bay no. 10 and Tower Façade plates at Outside yard.. The weld designations reviewed are as follows:

ED1- A227-7, Jt. nos. – 14, 15 –Façade plate
ED1- A244-1, Jt. nos. – 5, 6 –Façade plate
ED1- A222-13, Jt. nos. – 1, 19, 20 –Façade plate
ED1- A224-7, Jt. nos. – 10, 15, 21 –Façade plate
WD1- A145-7, Jt. nos. – 3, 4 –Façade plate
ED1- A244-2, Jt. nos. – 2, 41, 42 –Façade plate
ED1- A222-14, Jt. nos. – 16, 17 –Façade plate
ED1- A206-7, Jt. nos. – 3, 5 –Façade plate
NSD1-TL5-3 B/F , Jt. no. -19 A/B –Grillage plate
NSD1-TL5-3 B/F , Jt. no. -6 A/B –Grillage plate

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

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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.

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