

**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-012898**Date Inspected:** 21-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

<b>CWI Name:</b>	Mr. Yu Dong Ping/ Mr. Tu Jun	<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes No N/A	<b>Rod Oven in Use:</b>	Yes	No N/A
<b>Electrode to specification:</b>	Yes No N/A	<b>Weld Procedures Followed:</b>	Yes	No N/A
<b>Qualified Welders:</b>	Yes No N/A	<b>Verified Joint Fit-up:</b>	Yes	No N/A
<b>Approved Drawings:</b>	Yes No N/A	<b>Approved WPS:</b>	Yes	No N/A
		<b>Delayed / Cancelled:</b>	Yes	No N/A
<b>Bridge No:</b>	34-0006	<b>Component:</b>	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. 11

1. 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- 1B. 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)

Bay no. 10

2. This QA inspector, Baskar Govindarajan, has taken exterior alignment reading between South tower lift 3 and Lift 4 at Bay no. 10 on all skins. i.e. Skin A, B, C, D and E. The reading was taken along with Caltrans Inspector Mr. Pillai, B 286, and the reading found to be within 4 mm. This was reported to SMR. This reading was taken before heat straightening. The maximum misalignment, i.e. 4mm observed in Skin E.

3. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 052493 perform SMAW Repair welding on, AE Corner of south tower, Lift 5, and weld joint identified as SSD1-TL5-1B-F-36A. 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-485-SMAW-4G (4F)-Repair. (Photo

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attached)

## Heavy Dock Jetty

4.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 068924 perform FCAW welding on, Exterior Bearing stiffener of inside South tower, Lift 1, Skin C, and weld joint identified as SSD1-SA17 F/G-42. 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.

5.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 C, and weld joint identified as ESD1-SA294 F/G-49. 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.

## 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 East tower, Lift 4, BC Corner Diagonal plate Butt joints at Bay no. 11. The weld designation reviewed is as follows:

ESTL4-2 D/L – Jt. nos. 55,26,56,27,28,58,29– BC corner

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.

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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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