

**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-012901**Date Inspected:** 25-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.

Bay no. 11

1. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040733, 049099 perform SMAW Buttering welding on, Skirt plate, and Skirt plate identified as WSD1-A 804. ZPMC CWI Identified as Mr. An Qing Xiang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-2G (2F)-Repair. (Photo attached)

2. 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 ND1-STSA4-6 B/M-1-4A. 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-S-1. (Photo attached)

**Visual Inspection Testing:**

This QA inspector performed Visual Inspection (VT) of 100% of the area previously tested and accepted by ZPMC Quality Control personnel. The member is identified as Grating support brackets, West tower, Lift 1, 43 mtr. And 47.6 mtr. elevation. The weld designations reviewed are as follows:

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GGSA- 23PLAN-W43M- Jt. nos – 1to 6- 8 nos of Brackets  
GGSA-25PLAN-W43M- Jt. nos – 1to 6- 8 nos of brackets  
GGSA- 27PLAN-W47.6M- Jt. nos – 1to 6- 9 nos of Brackets  
GGSA- 29PLAN-W47.6M- Jt. nos – 1to 6- 9 nos of Brackets

## 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 South tower, Lift 5, BC & DE Corner at Bay no. 10 AND Strut angle plates. The weld designation reviewed is as follows:

SSD1-TL5-1 B/FL – Jt. nos. 11, 38 A/B - BC corner  
SSD1-TL5-1 B/FL – Jt. nos. 24, 52 A/B - DE corner  
ND1-SA4-68-139mtr.-7 – Jt. no. 1 A/B – Strut angle  
ED1-SA4-68-143mtr.-4 – Jt. no. 1 A/B – Strut angle  
ED1-SA4-68-139mtr.-4 – Jt. no. 1 A/B – Strut angle  
ED1-SA4-68-139mtr.-7 – Jt. no. 1 A/B – Strut angle  
ND1-SA4-68-127mtr.-1 – Jt. no. 1 A/B – Strut angle  
ND1-SA4-68-127mtr.-4 – Jt. no. 1 A/B – Strut angle  
ED1-SA4-68-131mtr.-2 – Jt. no. 1 A/B – Strut angle  
ND1-SA4-68-127mtr.-7 – Jt. no. 1 A/B – Strut angle

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



## Summary of Conversations:

No relevant conversations.

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## 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
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<b>Reviewed By:</b>	Clifford, William	QA Reviewer
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