

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-013040**Date Inspected:** 12-Apr-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. Gong Liang Zhu**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, performed Anchor bolt distance between two bearing stiffeners at Tower truss assembly area. These measurements were carried out in inside North tower Lift 1 Base. All the measurements were carried out in Skin A, B, C, D and E. All the reading taken was handed over to Task leader.

2. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 205649 perform FCAW welding on, Internal, exterior bearing stiffener on West tower, Skin B and Weld joint identified as WSD1-SA279-13. ZPMC CWI Identified as Mr. Gong Linag Zhu. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2333-TC-P4-F. (Photo attached)

3. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040489 perform FCAW welding on, Shear plate to Base plate between North and West tower, and weld joint identified as ND1-A26 A/B-44. ZPMC CWI Identified as Mr. Zhao chen Sun. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2332-TC-P5-F.

4. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040280 perform SMAW repair welding on, Shear plate support plate of North tower, BC corner and weld joint identified

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as NSD1-A112 A/H-1. 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-345-SMAW-3G (3F)-Repair.

5. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040675 perform SMAW surface repair welding on, West tower Skin D Bearing stiffener and weld joint identified as WSD1-SA 294 F/G-70. 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-345-SMAW-3G (3F)-Repair. (Photo attached)

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.

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