

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

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-014392**Date Inspected:** 20-May-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 Qi Guo/ Mr. Xu Le Feng	<b>CWI Present:</b>	<b>Yes</b>	<b>No</b>
<b>Inspected CWI report:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Approved WPS:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
		<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<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 041271, 046709 perform SMAW welding on, Spare strut flange to web and the weld joint is identified as ND1-STSA4-10-119mtr.-2-7B, 35A. 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-3212-TC-U5B-1. (Photo attached)

2. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 046769 perform SMAW welding on, Spare strut flange to web and the weld joint is identified as ED1-STSA4-10-119mtr.-1-35B. 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-3212-TC-U5B-1

3. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040704, 040759 perform FCAW welding on, Type 2 Bearing stiffener of Shear plate WD1-A 25 and the weld joint is identified as WD1-A25 B/E-3, 12. ZPMC CWI Identified as Mr. Xu Le Feng. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2331-TC-P4-F. (Photo attached)

---

---

# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

---

Bay no. 10

4.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 053869, 057258 perform FCAW welding on, Type 2 Bearing stiffener of Shear plate WD1-A 22 and the weld joint is identified as WD1-A22 A/B-23, 17. ZPMC CWI Identified as Mr. Yu QI Guo. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2331-TC-P4-F

Heavy Dock Jetty

5.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040302, 040280 perform FCAW welding on, Façade plate on Skin A of South tower, Lift 1 and the weld joint is identified as SSD1-SA 159- 7, 8. 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-2131.

6.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as O40675 perform SMAW Repair welding on, Skin B of temporary attachment removal area on East shaft, Lift 1. 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-345-SMAW-2G(2F)-Repair.

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.

---

---

# WELDING INSPECTION REPORT

*( Continued Page 3 of 3 )*

---

---

---

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

---