

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-014570**Date Inspected:** 31-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**CWI Name:** Mr. An Qing Xiang**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 056364 perform SMAW welding on, Temporary attachment, i.e platform support plate at 111.67 mtr elevation of South tower, Lift 3 and the welding carried out in Skin C. 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-p-2114. (Photo attached)

2. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040619 perform SMAW welding on; Spare strut Flange to web plate and the weld joint is identified as WD1-STSA4-5-139m-1-48B. 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-B-T-3212-TC-U5B-1. (Photo attached)

3. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 044551 perform SMAW welding on; Lift 4 to 5, interior splice plate and the weld joint is identified as ESD1-SPSA5-2-1A. 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-B-T-3211-TC-U5B.

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4.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 044550 perform SAW welding on, Lift 5, Cap plate and the weld joint is identified as GTSA5-B/G-6B. 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-B-T-2221-B-U3C-S-2.

Blasting shop 1

5.This QA inspector, Baskar Govindarajan, performed Pre blast inspection of internal surfaces of East tower, Lift 1, from Base (0 mtr.) to 9 mtr. All the areas marked which requires grinding, weld repair, Grinding & MT wherever applicable in all the Skins which includes Type 1 & 2 bearing stiffeners. This inspection was carried out along with QA Inspector Mr. Sandeep Kumar whose lot no. is B 227. All the marked points shown to ZPMC inspectors. Mr. James Lumley, QA NACE Level III Inspector was present during the inspection process.

6.This QA inspector, Baskar Govindarajan, performed, anchor bolt hole to Type 1 & 2 bearing stiffeners distance measurement of East shaft, Lift 1. This measurement of distance was carried out along with QA Inspector Mr. Sandeep Kumar whose lot no. is B 227. This was carried out in all skins of tower. All the reading taken has handed over to Task Leader.

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.

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