

**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-014572**Date Inspected:** 01-Jun-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. Xu Le Feng**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.

## Painting shop 1

1. This QA inspector, Baskar Govindarajan, performed, anchor bolt hole to Type 1 & 2 bearing stiffeners distance measurement of North 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 external side of all skins of tower. All the reading taken has handed over to Task Leader.

## Bay no. 13

2. This QA inspector, Baskar Govindarajan, performed, anchor bolt hole to Type 1 & 2 bearing stiffeners distance measurement of Shear plate no. WD1- A 28 and SD1-A 20. 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 Internal & external side of shear plate. Also, Distance between stiffener to stiffener measured at Top and Bottom. All the reading taken has handed over to Task Leader.

## Bay no. 11

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## WELDING INSPECTION REPORT

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3.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 202100 perform SMAW welding on; Spare strut web to stiffener and the weld joint is identified as ND1-STSA4-10-119mtr.-2-55. 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-2212.

4.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-SPSA5-2-1B. 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-3211-TC-U5B.

5.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040619 perform FCAW welding on; Lift 5, Skin E extension plate in AE Corner of West tower, and the weld joint is identified as WSD1-TL5-4 B/K-34B. 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-3213-F-U3B. (Photo attached)

6.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 041271 perform SMAW Repair welding on; Spare strut angle plate and the weld joint is identified as ED1-SA4-69-119mtr.-7-1A. 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-485-SMAW-1G (1F)-FCM- 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.

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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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