

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-014772**Date Inspected:** 15-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/ Mr. Liu Yang	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. 10

1. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 251194 perform SMAW welding on; Pad eye of Skirt plate and the weld joint is identified as ND1-A 713 A/E-74. ZPMC CWI Identified as Mr. Liu Yang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2112-Pad eye. (Photo attached)

2. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 050289 perform SMAW welding on; Lift 4 to 5, interior splice plate and the weld joint is identified as NSD1-SPSA5-19-2B. ZPMC CWI Identified as Mr. Liu Yang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3211-TC-U5B-1.

Bay no. 11

3. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040619 perform SMAW welding on; West Shaft, Lift 5 Grillage plate and the weld joint is identified as WSD1-TL5-4 B/F-34A, 34B. ZPMC CWI Identified as Mr. Xu Le Feng. The welding parameters as measured using QC's

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

calibrated instruments appeared to be in general compliance with WPS-B-T-3213-B-U3B.

4.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040724 perform SMAW welding on; Spare strut Flange to stiffener and the weld joint is identified as SD1-STSA4-5-143 mtr.-1-28, 32. 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-4113-1.

5.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040611 perform SMAW welding on; Lift 4 to 5, interior splice plate and the weld joint is identified as ESD1-SPSA5-20-2B. 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-1.

6.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040723 perform FCAW Repair welding on; Lift 5 Cap plate and the weld joint is identified as GTSA5-B/G-3 A/B. 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-345-FCAW-1G (1F)-Repair. (Photo attached)

Magnetic Particle Testing:

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6028 MT report for this date. The member is identified as BC Corner Diagonal plate welding with Skin B & C of West shaft, Lift 4 at Bay no. 11. The weld designations reviewed are as follows:

WSTL4- 2 I /L – Jt. nos – 14, 84 –BC corner, West, Lift 4
WSTL4- 2 J /L – Jt. nos – 15, 84 –BC corner, West, Lift 4
WSTL4- 2 K /L – Jt. nos – 15, 85 –BC corner, West, Lift 4
WSTL4- 2 G /L – Jt. nos – 14, 15, 86 –BC corner, West, Lift 4

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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



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 Micheal Ng (15921845703), who represents the Office of Structural Materials for your project.

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