

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-014940**Date Inspected:** 17-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.

Tower Jetty

1. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040582 perform SMAW welding on; Cross Bracing plate with Doublers plate in Lift 2 of south tower on 77 mtr. elevation and the weld joint is identified as SST1- SA164 C/F-16. ZPMC CWI Identified as Mr. Qiu Wen. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-4212-PC-U4C. (Photo attached)

Bay no. 10

2. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 044511 perform SMAW welding on; Lift 4 to 5, interior splice plate and the weld joint is identified as NSD1-SPSA5-6-3B. 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.

3. 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-SPSA5-19-2A. ZPMC CWI Identified as Mr. Liu Yang. The welding parameters as measured using QC's

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calibrated instruments appeared to be in general compliance with WPS-B-T-3211-TC-U5B-1.

4.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 052930/052493 perform SMAW welding on; North Shaft, Lift 5 Grillage plate on Skin A and the weld joint is identified as ND1-TL5-3 B/F-24A, 41B. 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-3213-B-U3B. (Photo attached)

Bay no. 11

5.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040704/040619 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 calibrated instruments appeared to be in general compliance with WPS-B-T-3213-B-U3B.

6.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 046709 perform SMAW welding on; Lift 4 to 5, interior splice plate and the weld joint is identified as ESD1-SPSA5-7-3B. 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.

7.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.

Ultrasonic Testing:

This QA inspector, Baskar Govindarajan, performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted at Tower components by ZPMC Quality Control personnel. This QA Inspector generated a TL-6027 UT report for this date. The member is identified as Cross bracing support plate with skin of East and west tower of 77 mtr. elevation at Tower Jetty area.(Notification no. 006001) The weld designation reviewed is as follows:

- 1.WD1-GUSA3-3-77 mtr.-E – Jt. no – 3A/B (Cross bracing plate at 77 mtr. –East shaft)
- 2.WD1-GUSA3-3-77 mtr.-W – Jt. no – 3A/B (Cross bracing plate at 77 mtr. –West shaft)

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

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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