

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-015718**Date Inspected:** 08-Jul-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. Zhao Chen Sun**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 044511 perform SMAW Repair welding on; Cross bracing gusset to Back fill plate in South shaft, Lift 2, 65 mtr. elevation at Tower trial assembly area and the weld joint is identified as SSD1-SA 164 C/F-10. 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-485-SMAW-2G (2F)-FCM-Repair-1. (Photo attached).

2. This QA inspector, Baskar Govindarajan performed Dimensional verification of Gap, Misalignment of Interior splice stiffeners on top and bottom side of South Shaft Lift 2 & 3 Connections. This Readings were taken along with QA Inspector Mr. Sandeep Kumar (B 227) and these dimensions measured in Skin A, B, C, D and E. During this, QA Inspector observed offset of approximately 11 mm in lower splices between Lift 2 and interior splice, Skin C stiffener. All the readings taken were handed over to Task Leader. (Photograph showing the Offset is attached with this Report)

Magnetic Particle Testing:

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

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 South and North shaft of façade connection plates in 53 mtr., 65 mtr. and 77 mtr. Elevations. The weld designations reviewed are as follows:

SSD1-SA 164 D/F- Jt. nos -34, 35 –South, Lift 2 Façade connection plate

SSD1-SA 61 D/G- Jt. nos -1, 2 –South, Lift 2 Façade connection plate

NSD1-SA 164 D/F- Jt. nos -37, 38 –North, Lift 2 Façade connection plate

NSD1- SA 61 D/G – Jt. nos – 7, 8 - North, Lift 2 Façade connection plate

SSD1-TL5 F/L –Jt. nos – 160, 161 –Rail post pipe sleeve -65 mtr.

ESD1-TL7 H/L –Jt. nos – 211, 212 –Rail post pipe sleeve -77 mtr.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

No relevant conversations.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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
---------------------	-------------------	-------------