

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-015719**Date Inspected:** 09-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/ Mr. Xu Le			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; Skin A Doubler plate to Back fill plate in South shaft, Lift 2, 77 mtr. elevation at Tower trial assembly area and the weld joint is identified as SSD1-SA 164 C/F-13. 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. The CWR Report found to be T-CWR-670.

2. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 044551 perform SMAW Repair welding on; Cross bracing gusset to Back fill plate in West shaft, Lift 2, 53 mtr. elevation at Tower trial assembly area and the weld joint is identified as WSD1-SA 340 B/F-16. 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. The CWR found to be T-CWR-669.

3. This QA inspector, Baskar Govindarajan performed Dimensional verification of Gap, Misalignment of Interior splice stiffeners on top and bottom side of East 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 5 mm in in Skin A, B,C, and D stiffeners. Also, a gap between

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Interior upper splice and Lift 3 tower, Skin A, found to be 10.8 mm which is shown in photographs. All the readings taken were handed over to Task Leader. (Photograph showing the 10.8 mm Gap is attached with this Report)

Bay no. 11

4.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-SPSA5-7-3A. 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.

5.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040614 perform SMAW welding on; Lift 4 to 5, interior splice plate and the weld joint is identified as ESD1-SPSA5-12-3A. 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 046704 perform SMAW welding on; Lift 4 to 5, interior splice plate and the weld joint is identified as WSD1-SPSA5-12-3A. 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 049220/040723 perform FCAW welding on; OBG side plate components and the weld joint is identified as SP 3106-001-032, 033. 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-2312.

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