

**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-015781**Date Inspected:** 25-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. 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.

**Heavy Dock Jetty**

This QA inspector, Baskar Govindarajan, Performed, Lift 2 & 3, External alignment measurements which includes, Top, Bottom and side Gap between Splice and Tower Skins, Horizontal and Vertical Flatness near Splice plates, Distance between Splice plate and Tower Skin Edges of all corners, Lift 2 & 3 misalignment in all corners. These measurements carried out along with QA Inspector Mr. Ragavendra Reddy (B 308) in South and North tower on Skin A, B, C, D and E. All the reading has been handed over to Task Leader. (Photo of misalignment of approx. 8mm observed in North shaft between Lift 2 & 3 in Skin C, CD Corner is attached)

**Bay no. 11**

1. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040611, 041271 perform SMAW welding on; East shaft, Lift 5, Grillage plates and the weld joint is identified as ESD1-TL5-2 F/F-2A, 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-3213-TC-U5B.

2. This QA inspector performed Tower strut dimension measurements of strut no. ND1-STSA4-6-139 mtr.-1, which includes Flange to flange distance at Both ends, Stiffener to stiffener distance on both sides, 1:1 fillet

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termination and 10 mm minimum clearance from fillet to CJP. All the measurements taken, were handed over to Task leader.

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.

## 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.

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**Inspected By:** Baskar, Govindarajan

Quality Assurance Inspector

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**Reviewed By:** Clifford, William

QA Reviewer