

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-015999**Date Inspected:** 27-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.

Bay no.10

1.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 050289 perform SMAW welding on; South shaft, Lift 5, Grillage plates and the weld joint is identified as SSD1-TL5-1 F/F-5B. 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, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040581 perform SMAW welding on; North shaft, Lift 5, Grillage plates and the weld joint is identified as NSD1-TL5-3 B/F-11. 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-U4C.

3.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040365 perform SMAW Repair welding on; Lift 5, Interior splice plate and the weld joint is identified as NSD1-SPSA5-13-1A. 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-485-SMAW-2G (2F)-Repair.

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Bay no. 11

4.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 066258 perform SMAW welding on; West shaft, Lift 5, Grillage plates and the weld joint is identified as WSD1-TL5-4 E/F-25B. 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. (Photo attached)

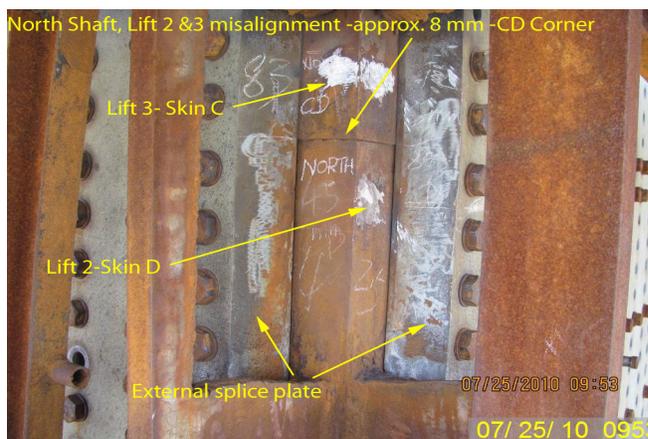
5.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040611 perform SMAW welding on; East shaft, Lift 5, Grillage plates and the weld joint is identified as ESD1-TL5-2 F/F-15B. ZPMC CWI Identified as Mr. Xu Le Feng. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3313-TC-P5.

6.This QA inspector, Baskar Govindarajan, performed, Dimension measurements of 10 nos of Spare struts after machining, which includes Overall length and Drilled holes to edge of strut at Both end of struts on Top and Bottom side. These measurements has been taken in the following struts, ED1-STSA4-6-139mtr.- 2, ED1-STSA4-6-131mtr.-2, ED1-STSA4-6-123mtr.- 2, ND1-STSA4-6-131mtr.- 2, ND1-STSA4-6-135mtr.- 2, ED1-STSA4-6-127mtr.- 2, ND1-STSA4-6-131mtr.- 1, ED1-STSA4-6-127mtr.- 1, ND1-STSA4-6-135mtr.- 1 and ED1-STSA4-6-139mtr.- 1. All the measurements taken were handed over to Task leader.

Heavy Dock Jetty

7.This QA inspector, Baskar Govindarajan, wrote an Incident report for the offset of approx. 8 mm observed in North tower, Lift 2 & 3, Skin C, CD corner in 83 mtr. elevation. (Photo attached with this report)

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



WELDING INSPECTION REPORT

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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.

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